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Issue 9

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Linatex Limited  
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Email: [kirsten.corney@linatex.com](mailto:kirsten.corney@linatex.com) [www.linatex.com](http://www.linatex.com)



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**Europe's sustainability event**

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## Enjoying a second life

As we enter a new era of austerity every one of us is economising, looking at ways of driving down our own personal costs, looking for smarter ways to use and buy the things we need to live our everyday lives.

This credo extends to what we already have by making sure we don't waste anything that can be used or reused, whether it's recycling rubbish, making today's dinner from yesterday's leftovers, mending old clothes or fixing products that have broken down to extend their life. This culture has entered the national psyche and has even brought out the entrepreneur in the public masses who have become in increasing numbers second hand dealers, whether it's traditional boot sales or becoming 'traders in used stock' in the more sophisticated trading zone of the online auction web sites, such as eBay. Indeed some are even finding they are making a decent return, indeed just recently the UK found its first 'eBay millionaire'.

What this all boils down to is rather than stop using something or throwing it away, why not give it a second life?

Using the theory that change is best achieved from the ground up the culture that now pervades the country will hopefully lead to a better attitude towards using recycled products in industry too. Recycled aggregates have many uses today yet, as highlighted in this issue, there remains an 'attitude' that exists towards their use even when they meet all the necessary requirements. It is pleasing to see how even contaminated soil can be given a second life - as good an example of change from the ground up as one can get.

Recycling soil and aggregates is not the only issue in this credit crunch-beating edition of HUB; recycling equipment also is on the agenda. Whether it is extending the life of existing plant through rebuilds and the use of spare parts or acquiring quality used equipment, which can play a valuable role in many applications, there are a great many ways to drive down costs. Again cultural attitudes may have some part to play here as the allure of the new is not as powerful as it once was and just as more people are prepared to look at the economic benefits of buying used cars, so specifiers are increasingly realising the economic benefits offered by used plant.

The automotive industry has worked hard to create an 'approved environment' which gives the buyer confidence that their used vehicle is not going to be a risk. Dealers of the type of equipment that operates in quarries and waste transfer stations are developing similar standards of after sales care for their used equipment that will only help add to the plant buyer's willingness to consider investing in pre-owned machinery. As a result, pre-owned kit certainly looks set to play a greater role in today's financially prudent recycling and quarrying industries.

**Ross Matthews** - Editor

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HUB DIGITAL MEDIA LIMITED  
27 OLD GLOUCESTER STREET, LONDON WC1N 3AX

## Spring 2009

**Ross Matthews** - Editor

07711 347701 Email: ross.matthews@hub-4.com

**Daren Thomas** - Sales Manager

0845 680 0024 Email: daren.thomas@hub-4.com

**Linda Rainbow** - Sales & Marketing Administrator

0845 680 0024 Email: linda.rainbow@hub-4.com



**For material processing & recycling...**



**MOGENSEN**

Harlaxton Road, Grantham, Lincolnshire NG31 7SF, England  
Tel: +44 (0)1476 566301 Fax: +44 (0)1476 590145  
E-mail: sales@mogensen.co.uk  
Web: www.mogensen.co.uk





# Innovation from Linatex

**Internationally recognised for rubber, over the years Linatex has grown to encompass a complimentary range of products and services for minerals processing, sand plants and mining.**

Today Linatex has developed technology that can offer the lowest cost of ownership in sand processing, whether it is in straight forward sand washing, simple classification of multiple sands, recipe sand classification to provide blends for specific applications, or contaminant removal from brown field sites.

This technology can be utilised in sand and gravel, recycling applications and sand bed recovery of water treatment plants.

Designed to be versatile in meeting their customer needs, Linatex has in the past few years introduced some major product innovations, adding considerable benefits to the plants they have recently designed and commissioned.

**Design and technology – low level and compact plants. No compromise on performance in small packages, compact designed for feed rates up to 200tph.**

With the development of low level platform design Linatex has been a major innovator within this field. Recent high profile projects in the UK have introduced major benefits to the industry through the development of this design. Environmentally friendly in terms of reduced height, this design typically uses less energy because of reduced pumping requirements. Plant maintenance also benefits as it is easily and safely performed with improved access.

With the introduction of Linatex small footprint, low-level compact plants, rapid deployment of portable, single grade sand washing, dewatering & twin grade classification systems is now available.

Designed for minimum installation time, the Linatex range of compact washing and dewatering plants are designed for feed rates of up to 150tph of -6mm as “raised material” and to produce a single grade washed product, dewatered and

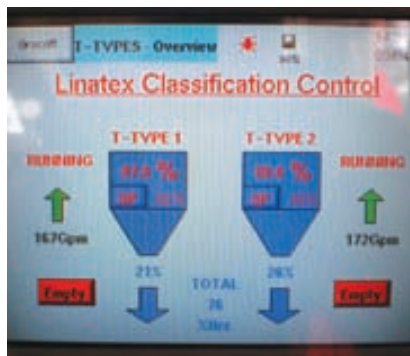
suitable for direct stockpiling.

The standard Linatex Compact Dewatering Screen is configured to perform simple washing ie: the reduction of -63 micron material. Typical applications would be the processing of primary products such as construction sands for concrete, building, mortars, asphalt etc, industrial sands & leisure sand dressings.

The screen can be configured for fines recovery with a maximum recovery down to 50 micron to effect the capture of useful material from effluent streams, or de-gritting of effluent to reduce loading on effluent treatment plant such as thickeners.

A third configuration offers fine classification below for example 125 micron. Typical applications would be for the correction of fines content in sand in order to meet a specific grading requirement.

**Design and technology – Computerised in-line blending.**



In the early 1980's Linatex introduced their 'sand on recipe' concept, whereby raw sand would be separated into distinct fractions and stored in silos. Subsequent mixing of these fractions in the correct proportions could then be carried out to produce any required particle size distribution in the final product.

Since then further improvements in computer control have led to the development of the Linatex in-line blending system, which allows two or three separated fractions to be accurately rebled by computer in one continuous process, with the computer storing the settings for any final desired product. A recent installation in the UK is capable of handling up to 600,000 t/annum (327tph) of -5mm feed material to produce two main specification controlled products: a close

specification concrete sand and a dry silo mortar sand for use by an on-site DSM plant.

**Product innovation - Linatex G4 Hydrocyclones.**



Linatex has used Computational Fluid Dynamics (CFD) modeling and specialist design principles to develop their new range of Linatex G4 Hydrocyclones. Incorporating a number of new features, the Linatex G4 Hydrocyclone offers improved classification efficiency and product recovery.

An interchangeable inlet wedge is a unique feature of the Linatex G4 Hydrocyclone which allows operators the opportunity to quickly change the size of the inlet and fine-tune the cyclone's performance without physically removing it from the process line. Feed slurry is introduced into the cyclone in a tall narrow ribbon via a scrolled, swept inlet entry. This maximises separation forces, reduces turbulence and improves classification efficiency.

Offered in a broad range of sizes Linatex G4 Hydrocyclones are fitted with moulded replaceable liners, 20mm - 30mm thick, to maximise wear life and minimise operating costs.

**Green power provides improved ladder safety**

Many UK quarry installations have already benefitted from the installation of the new Linatex self contained radio controlled swivel chute drive.

# in sand processing



Designed to provide a safe working environment by eliminating the need for plant operatives to access and reposition stock piling chutes. The system also derives its total energy requirement from the wind.

Retrofit is intended to be a straight forward process - all the system components bar the radio control handset being installed at chute level within the tower - and there is no requirement for an external power supply or hard wiring to the ground. Once installed and powered up, the unit will await instruction from the remote control handset, drawing minimal power from the battery which is itself continuously topped up by the wind turbine charger.

Beyond monitoring battery condition and occasionally greasing the chute's bearings the unit is considered essentially maintenance free.

## Product innovation – State-of-the-art screening technology.



Linatex designs, manufactures and supplies an extensive range of state-of-the-art screening equipment. The Linatex screen range includes horizontal linear motion vibrating screens, rotary screens, banana screens and high frequency vibrating screens. Applications extend from dewatering and fine sizing to heavy-duty materials sizing.

Since the introduction of Linatex Finite Element Analysis (FEA), in-house FEA capabilities have optimised the mass and strength of the Linatex screen range, providing their customers with lower capital and operating cost solutions.

Designs have evolved and improved over time, with developments arising from many years of operational experience. Linatex screen technology ensures the delivery of drier sand from the screen; this reduces environmental impact whilst providing cost benefits by reducing the drying investment and energy required by downstream producers.

## Where it all began.

A constant issue within the material handling industries, wear has been at the top of the agenda with Linatex since the development of their world famous range of natural and synthetic rubber some 80 years ago.

What makes Linatex Rubber unique is that they manufacture, supply & install their own range, and as a manufacturer and applicator, Linatex employs highly skilled and trained rubber lining experts who take full responsibility for selection, preparation and installation. The focus is, and always has been on ensuring the best fit of product for the environment that delivers the best possible results and the lowest possible cost of ownership, with the ultimate aim of delivering higher yield to customers.

Linatex wear protection can be applied to many surfaces to fully protect the base structure from wear; including chutes, pipe linings, flexible bends, anti build-up linings and vessel linings.

Recently Linatex successfully introduced impact panels to the market. Developed for high performance in areas of exceptionally high wear, impact and abrasion, the panels will absorb noise and vibration. Quick and easy to install, with a unique interlocking design, Linatex Impact Panels provide a quick and cost effective solution in high wear environments.

# Linatex

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## Care for your plant.

Processing plant optimisation brings immediate benefits. Linatex offer an individual plant audits. This comprehensive review of the plant performance often results in not only a higher throughput been achieved but a greater recovery of sands overall. A further obvious benefit being the reduction of plant downtime.

Linatex currently offer several levels of planned service and maintenance which can include the replacement of Linatex slurry pumps including parts, and also, repair or cost effective replacement of competitor slurry pumps. Sand plant service includes sand plant optimisation and upgrades, on originally supplied equipment, and any competitor's plant where improvements can be shown to be viable.

Linatex rubber lining services can also be included along with the support of Linatex technical engineers for any process issues. All service and maintenance contracts include agreed schedules for response times and pricing and include regular performance reviews. With all Linatex personnel carrying their EPIC safety passport, Linatex are fully committed to all client in-house and HSE health and safety guidelines.



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## Pathway To Zero Waste

A new initiative to help construction companies in the South East substantially reduce costs and lessen their environmental impact was launched on 3 March 2009 that, according to the Rt Hon Hilary Benn, Secretary of State for Environment, Food and Rural Affairs, will be "a bold step towards the sustainable, low-carbon, zero waste economy that we all want to achieve".

Pathway To Zero Waste (PTZW) aims to create a culture of resource efficiency that will see business waste volumes - which currently account for 80% of all waste in the South East - greatly reduced, with far more material reused, recycled, or converted to energy instead of being sent to landfill.

"The economic benefits we will unlock are considerable - an estimated £370m reduction in operating costs by 2011 alone," said Dr Chindarat Taylor, director, PTZW.

"The comprehensive network of recovery and recycling infrastructure needed to support smarter resource use - which PTZW will help establish - will create thousands of new jobs, providing further economic benefits and helping to deliver long-term sustainable prosperity."

Founded by SEEDA (the South East England Development Agency), the Environment Agency and WRAP (Waste & Resources Action Programme), PTZW focuses their activities in the South East, combining their skills, resources and expertise to be a powerful force for change.

Environment Secretary Hilary Benn, welcomed PTZW's launch, saying: "This is a bold step towards the sustainable, low-carbon, zero waste economy that we all want to achieve. We need to stop asking how we will dispose of the waste we create and ask why we are getting rid of it at all. Because in many cases, we shouldn't. In difficult economic times, reducing waste and unnecessary costs makes sense. We must recognise that there are opportunities here, particularly in the South East. But we need to think of waste as a resource, and Pathway To Zero waste is a big step towards doing just that."

With landfill space in the South East set to run out within in five years, PTZW is focusing initially on construction and demolition (C&D) waste, the biggest source of waste sent to landfill in the region. Food and wood waste will follow.

PTZW's targets for C&D waste are:

- by 2011, a 50% reduction in C&D waste sent to landfill against 2008 levels - one year ahead of national and industry targets
- by 2020, a 90% reduction in C&D waste sent to landfill against 2008 levels, paving the way for a zero waste region.

"Businesses in the South East waste millions of tonnes of usable material every year by sending it to landfill," continued Dr Taylor.

"Most don't realise that once the value of wasted materials and labour is included, the true cost can be up to ten times more than the disposal cost. PTZW will act as a catalyst of change, bringing private and public sector organisations together and focussing on what needs to be done to deliver rapid, significant and lasting improvements to the way we view and manage waste. The result will be lower costs, new jobs and a better environment. It's a win, win, win situation for the South East."

## Aggregates, quarry products, cement and concrete combine to form the Mineral Products Association



Lynda Chase -  
Gardener chairman of MPA



The Mineral Products Association (MPA) has been formed through the merger of the British Cement Association (BCA), the Quarry Products Association (QPA) with its membership covering land based, marine, recycled and secondary aggregates, asphalt, ready-mixed concrete, agricultural lime, industrial lime, mortar, silica sand and The Concrete Centre. It represents 222 members across the UK. The MPA is the representative body for the aggregates, asphalt, cement, concrete, lime, mortar and silica sand industries and its members supply around £5bn of essential materials to the UK economy; by far the largest single supplier of materials to the construction sector.

### The organisation

The MPA says it will build on and enhance the strong reputation established by its constituent parts for supporting their members to operate in a manner that is economically viable and socially and environmentally responsible. It will represent and promote the mineral products industry in order to:

- Secure and maintain the licence to operate for the sustainable supply of essential mineral products; Continue to innovate and deliver sustainable solutions;
- Maintain existing and develop new markets.

The newly merged organisation has Lynda Chase-Gardener as its chairman. Nigel Jackson has been asked to take on the role of acting chief executive, supported by an executive team of Simon van der Byl, Pal Chana and Andrew Minson.

Lynda Chase-Gardener said: "In these particularly difficult economic conditions, there is a real opportunity for the new organisation to add value to the work of its member companies and to provide a more effective voice for the industry."

Before its merger to become the MPA, the QPA published its latest survey in February which indicates an unprecedented decline in sales volumes in the final quarter of 2008, and very significant reductions in aggregates and ready mixed concrete volumes for the year.

In the final quarter, sales volumes of crushed rock and sand and gravel aggregates fell by 29% and 28% respectively compared with the same period of the previous year. Looking at the major value added products, ready mixed concrete sales fell by 26% and asphalt by 15% in the final quarter.

For the year as a whole, sales volumes of crushed rock sales fell by 12%, sand and gravel by 15%, ready mixed concrete by 14% and asphalt by 3%.

The aggregates and concrete markets turned down very significantly in 2008 and this trend accelerated in the fourth quarter as the slowdown in construction activity spread well beyond the well documented housing collapse. The asphalt market started the year positively, but again declined rapidly towards the year end.

QPA director general Simon van der Byl commented: "We thought 2008 would be difficult but the reduction in markets in recent months has been very rapid and very substantial. The outlook for 2009 is grim as there is no prospect of recovery in construction activity until well into 2010, with plenty of downside risk to potentially extend the construction recession.

It is absolutely vital that government takes action to ensure a significant improvement in the functioning of credit markets and implements a far more substantial initiative of construction investment and maintenance, if the worst case projections for the economy and the construction industry are to be avoided. Government announced a programme of accelerated construction work in the November Pre Budget Report, but market conditions are now significantly worse and this work will have little impact on construction activity over the next 18 months. Unless further action is taken there is a great risk that the construction sector will be forced to reduce its capacity and skills base to such an extent that it will be difficult to respond effectively when the economy recovers."



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## Finlay Plant Secures KKB3R Order

**Finlay Plant South East - part of the Finlay Group of companies - has supplied four new screeners to Kent-based plant contractor KKB3R.**

The Terex Finlay 883 screeners have joined the range of machinery in the KKB3R fleet, which reflects the company's growing and diverse operations in its eleventh year of trading.

KKB3R was formed in 1998 by Colin Basi, with one excavator and one Trommel screener. It now has a turnover of £10 million and specialises in remediation, contract recycling and specialist material processing.

The new screeners take the number of machines supplied to KKB3R, by Finlay Plant South East, to a total of 20.

Colin Basi, managing director of KKB3R, said: "It is important for us to have a supplier with same day service and spares back-up, so that is why we keep with Finlay Plant."

"The Terex Finlay 883 is proving a valuable asset. We needed it to expand our operations in general remediation work across the south of England."

*Left to right; Leon Sheehy of Finlay Plant South East, with Colin Basi of KKB3R.*



The Finlay 883 works as an aggregate screener after a primary crusher, or on its own as a frontline screening machine.

Applications include quarry waste, construction and demolition debris, topsoil and aggregates. Processing at a rate of up to 500 tonnes per hour, the key to the 883 is its adaptability, whatever the application or industry.

Leon Sheehy, managing director of Finlay Plant South East, said: "As a business, we have focused on delivering best-fit processing solutions for screening, washing, silt recovery, crushing, waste processing and recycling, all coupled with excellent service."

"We are delighted that KKB3R have built up their fleet through our company and that they enjoy the reassurance of our comprehensive service and spares offering, to keep their entire fleet running effectively, with just one point of contact for all their machinery."

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## Tarmac maintains its number one position in UK aggregates

**Tarmac remains the largest aggregates company in Great Britain with an estimated share of over 23%, according to the annual report published by BDS Marketing Research that estimates the outputs and shares of all sand and gravel pits, crushed rock quarries and marine wharves in Great Britain, by location and company. Tarmac's share has increased over the past year as a result of its purchase of the outstanding 50% in United Marine Aggregates that it did not already own. The company is the largest producer in the midlands, Yorkshire, northern England and Wales.**

Aggregate Industries continues as the second largest company, followed by Hanson. Cemex and Lafarge. These companies together now represent an estimated 73% of total UK aggregates production.

The report identifies nearly 50 pits and quarries that have recently closed or are planned to do so shortly. Whilst some of these have run out of reserves, the current recession is forcing some companies to mothball uneconomic operations.

The consultancy is expecting a further decline in industry sales during 2009. It is forecasting a fall of 6% in primary aggregates markets during the current year. Strong growth is expected during 2010. This is seen as a partial recovery from the current low levels of demand, rather than a full recovery to pre 2007 levels. BDS still expects the market to be around 7% down in 2010, compared with volumes of just two years ago.

The report lists all known sand and gravel pits, crushed rock quarries and marine wharves, by individual location and company. The estimated output of each site is included, with company market shares shown by county, region and nationally, by each type of aggregate.

Further details of the report entitled: 'Estimated outputs of pits, quarries and marine wharves in Great Britain' are available by contacting Julian Clapp at BDS on (01761) 433035 or email [julian.clapp@bdsmarketing.co.uk](mailto:julian.clapp@bdsmarketing.co.uk) or [www.bdsmarketing.co.uk](http://www.bdsmarketing.co.uk)



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## Terex creates centres crushing & screening of excellence

**Terex Materials Processing is proposing to revise its global operational footprint, creating dedicated "centres of excellence."**

Under immediate consideration is the consolidation of manufacturing and assembly facilities to concentrate production, skills and expertise in identified "centres," for the Terex Finlay, Terex Pegson and Powerscreen brands as follows:

- Centre of Excellence: Screening equipment for both Terex Finlay and Powerscreen would be produced in Dungannon, Northern Ireland (currently produced in both Dungannon and at Omagh, Northern Ireland).
- Centre of Excellence: Crushing equipment for both Terex Finlay and Terex Pegson would be produced in Omagh, Northern Ireland (currently produced in both Omagh and Coalville, England).
- Coalville will continue to house the Terex Global Chamber Design Centre - the centre of excellence in bringing Terex crushing technology to the forefront of the industry.

Each of the Coalville, Dungannon and Omagh locations would continue to provide aftermarket support, applications and sales services for their respective products through their customary points of contact. The current ranges of crushers, screens and wash plants would continue to be available.

It is proposed that the new centres would be established in stages throughout 2009 and into 2010.

Kieran Hegarty, vice president of Terex Material Processing commented: "By focusing on similar products at one location, we would be able to provide our customers with the best possible value offerings; therefore, we firmly believe," Hegarty added, "that the proposed changes would allow us to retain and grow our strong global presence in the crushing and screening market."



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# Green economic revolution debated at Futuresource 2009

The Futuresource 2009 conference and exhibition, hosted by CIWM (Chartered Institution of Wastes Management) and ESA (Environmental Services Association) at London ExCeL in June, is bringing together politicians and business leaders to discuss waste, recycling and resource management strategies that can deliver against these three key objectives.

"Futuresource 2009 is centred on green growth," says CIWM chief executive, Steve Lee. "Brown, Obama and the European Parliament have all acknowledged that industries like ours and the services we develop in coming years will be critical to sustainable economic growth and reducing the impact of climate change. Over three days, we will be showcasing ideas and technology that will shape the future and create new jobs in the waste, recycling and resource management sector. Thanks to the interactive conference programme and extensive networking opportunities, professionals from both the public and the private sector will also be sharing their knowledge and experience with policymakers to help set the resource efficiency agenda for years to come."



**The Rt Hon Hilary Benn MP, Secretary of State for Environment food and Rural Affairs**



**WRAP chief executive Liz Goodwin**

The format of the new Futuresource conference is designed to allow the issues facing the industry to be roundly debated. Senior government ministers,

including Hilary Benn MP, Secretary of State for Environment food and Rural Affairs, and Shadow Secretary of State for Environment, Food & Rural Affairs, Nick Herbert MP, will outline the policies and priorities shaping the national and international landscape.

The real implications of delivering these will then be debated in a series of lively head to head sessions. Paul Bettison, chairman of the Local Government Association's environment board and Mark Wallace, director of the Taxpayers Alliance, will debate whether local waste services are really being delivered in the public interest, and Michael Warhurst of Friends of the Earth

and Hakan Rylander of Swedish waste disposal firm SYSAV will be discussing what role energy from waste should play in the future. On day two, the very real challenge of funding waste services and infrastructure in the current economic climate and the pros and cons of co-mingled recycling collections are the two head-to-head topics, with speakers including Malcolm Ward, ESA Chairman and CEO, Cory Environmental, Richard Skehens, managing director of Grundon Waste Management, and David Workman, Director General of the British Glass Manufacturers' Confederation.

In other sessions, representatives from the Scottish Government and Welsh Assembly Government will be joined by UK and continental waste management experts in a review of the UK's progress in terms of the European league table, and speakers including Lord Smith of the Environment Agency, SITA UK chief executive David Palmer-Jones, and Julie Hill of the Green Alliance, will be among the speakers asking what we are trying to achieve and whether we have got our priorities right.

Key stakeholders are the focus of the afternoon sessions on day two. Leading industry spokespeople from household names such as Ford and Sainsbury's join Shanks Group CEO Tom Drury to discuss what services UK business want from the sector, and the challenge of communicating with the public and other stakeholders to change behaviour will be explored by speakers including WRAP chief executive Liz Goodwin and Jim Meredith, WRG's Group Chief Executive.

The final day of Futuresource 2009 involves a programme of 12 presentations and discussion sessions grouped thematically into energy from waste, municipal waste collection and management, commercial and industrial waste management, and local authority performance and service efficiency.

Commenting on Futuresource 2009, Dirk Hazell, chief executive of ESA, said: "We are offering a packed conference programme with some of the UK's and Europe's leading thinkers on waste management and resource efficiency, backed by a comprehensive trade exhibition with over 300 exhibitors representing the sector and its major client base. Every aspect of the green revolution will be under one roof for three days and the scale of our new event reflects the central role our industry has to play in the sustainable development of UK plc and the global environment. It will be the start of something big."



## CEMEX UK awards enhanced service contract to Linatex

Building materials provider CEMEX UK has awarded a new national maintenance service contract to Linatex for a period of 12 months. The agreement entails the supply of labour and parts for planned maintenance services. Originally encompassing 19 sites this new agreement has now been amended to cover all CEMEX sites in the UK.

The contract includes all planned service and replacement for Linatex slurry pumps including parts, and also, repair or cost effective replacement of competitor slurry pumps. Sand plant service includes sand plant optimisation and upgrades, on originally supplied equipment, and any competitor's plant where improvements can be shown to be viable. Linatex rubber lining services are also included along with the support of Linatex technical engineers for any process issues. An agreed schedule for response times and pricing alongside a commitment to working under the current CEMEX UK Health and Safety Policy with all Linatex personnel carrying their EPIC safety passport has also been agreed. A minimum quarterly review has been included within the agreement, which will provide both companies with key performance indicators.



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## Blackpool hosts materials handling industry's leading seminar

Bulk09 takes place on 23-24 April 2009 at the Hilton Blackpool Hotel. The Materials Handling Engineers Association (MHEA) annual Technical Awareness Seminar continues to be a popular event in the industry's calendar and this year the event has received a major sponsorship from Rema Tip Top Industry UK.

The event provides the materials handling industry with an opportunity for networking and discussing the developments, future trends and application opportunities relating to solids handling and processing equipment.

Simon Phillips, construction liaison manager of Cross London Rail Links, will open the event by bringing attendees up to-date with the opportunities outlined in 2008.

The event also features sessions covering innovation in belt conveying, pneumatic conveying, environmental issues, project opportunities, the handling of secondary fuels and screening, feeding and weighing together with a plenary lecture, which will outline Possibilities and Capabilities of Pneumatic Conveying Systems. To complement the sessions there will be the ever-popular gala dinner on 23 April.

In a further announcement from the MHEA, HUB 4 has been made an approved MHEA Media Partner



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# Introducing the MHEA

**The Materials Handling Engineers Association MHEA is active in many areas of interest to HUB 4 readers so Hub 4 invited the associations' secretary Peter Webster to introduce the association and it's BULK09 event.**

**Since its inception in October 1938, the Materials Handling Engineers' Association (MHEA) has sought to support the technical and commercial interests of UK and overseas companies supplying and using powder & bulk & handling equipment. Currently this involves industries such as Animal Food, Cement, Chemicals, Ferrous & Non Ferrous Metal Production, Food and Drinks including Confectionery, Grain & Derivatives, Minerals and Coal, Offshore Oil & Gas Industry, Pharmaceuticals, Plastics & Rubbers, Quarrying, Solid Bio fuels, Water & Waste Treatment.**

Among its duties the organisation considers all matters of general interest to both the suppliers and users of materials handling equipment and to develop, promote and extend its use both in the UK and abroad. Co-operation and collaboration is encouraged amongst members aimed at improving efficiency of the manufacturing, distribution and storage industries by the application of appropriate materials handling techniques. The MHEA represents the industry in discussions with Government Departments, major Industries and other users, and research and academic institutions. It encourages co-operation among members on all technical, commercial and legislative matters and take part in the appropriate international institutions. Training and education of personnel, both in industry and the educational establishment, are also encouraged. The organisation provides a means of consultation with other bodies on technical investigation, standardisation and Health & Safety matters. Furthermore it provides an information service on technical and commercial matters and trading opportunities

Ross Matthews puts a series of questions to Peter Webster, secretary of the MHEA to find out more about the organisation and its forthcoming BULK09 conference.

**HUB: What can the MHEA offer the industry in terms of help and information?**

PW: I see MHEA as a cost-effective means of tapping into a unique technical marketing knowledge base. Our membership is wide spread covering all aspects of the Material Handling Industry in a one-stop shop. We offer industry access to latest developments in materials handling and superior technical knowledge through our design seminars and technical publications.

**HUB: What other activities is the MHEA involved in?**

PW: We hold regular meetings usually incorporating a site visit for corporate member companies and over the past 3 years we have received invitations and visited Aggregate Industries in Carnforth; ATH Resources, Glenmuckloch Open Cast Coal Site in Ayrshire; Corus in Scunthorpe; Drax Power Station; Greater Manchester Waste in Sharston; Irish Cement in Drogheda; Lafarge at Mountsorrel; RWE npower at Tilbury power station; Sonea Tafibra in Merseyside; ThyssenKrupp in Germany and UTE Tuneladora Metro in Barcelona. Our last visit was to the Orchid Recycling Plant at Mersey Side Waste Disposal where 24 members attended an extremely interesting and informative visit. This was only available to MHEA members

The MHEA's annual Technical Awareness Seminar continues to be a popular event in the industry's calendar. Since 2002 these events have attracted an average of 85 delegates and Bulk07 & Bulk08 at the Blackpool Hilton averaged 100. We are currently holding a complete review of MHEA; it's our intention to offer more services to our members in specific areas, such as training.

**HUB: Who should join the MHEA and what benefit would they gain?**

PW: As our name suggests, any company involved in the Materials Handling Industry and Associated Industries will benefit from highly regarded networking opportunities and future 'user' group discussion forums; participation in the MHEA UK/Europe Site Visits to appropriate industry facilities; access – via the secretary – to expert information such as the new

British Standards - (i) Troughed Belt Conveyors - Specification BS 8438: 2004, (ii) Continuous Handling Equipment and Systems - Guide to Properties of Powders and Bulk Materials BS 8439: 2004 and (iii) BS EN 617:2000 Continuous handling equipment and systems - Safety and EMC requirements for the equipment for the storage of bulk materials in silos, bunkers, bins and hoppers.; a 10% reduction in attendance fees for the UK's only annual Bulk Technical Awareness Seminar; involvement in ISHAB Solids Handling Sector opportunities through UKTI support and finally, employees of MHEA Corporate Member companies can now qualify for Designatory awards such as MMHEA which can be used in CVs and on business cards

**HUB: What does MHEA identify as being the critical issues in the sector today?**

The critical issue for many companies today is survival in the present economic downturn. The recession has hit particularly hard in some areas, however MHEA members have access to industrial sectors, which are performing well through contacts in the association helping diversification. Support is available through the membership, help and advice is readily available from one member company to another, a problem shared I think is the proverb

**HUB: As secretary, what are your ambitions for the MHEA and the sector as a whole?**

PW: My ambitions lie firmly in making the MHEA the leading Trade Association in the Bulk materials Handling sector, to be able to increase the membership and offer the services our membership requires.

We are currently reviewing our association and I believe the new mission statements sums up where MHEA needs to be: To promote the performance benefits of Bulk Materials Handling Equipment by:

- Representing Users and Suppliers of members Products and Services.
- Raising Technical Awareness.
- The Education and Promotion of "Best Practice" within the Industry. ►

- Facilitating Business Development and Networking in the Bulk Materials sector.

**HUB: What was the reason behind MHEA starting up the BULK conferences and how well have they developed?**

PW: The Seminars started as a means of keeping our industry up to date with trends and new developments. This was then expanded to include information from Government and updates on legislation relevant to our industry. In more recent years we have built on this foundation and have added the key factor of networking, the addition of the gala dinner with a top line entertainer and has certainly brought delegates closer together, propagating long term business relationships and friendships.

**HUB: How pleased were you with the BULK08 event and what were the interesting points generated by the conference?**

PW: Bulk08 was an outstanding success in both technical content and networking, the venue once again proved to be popular with delegates hence our return for Bulk09. The content of the papers and presentation by the speakers was superb. Topics covered ranged from Construction, Waste through to Coal

**For more information on the MHEA visit [www.mhea.co.uk](http://www.mhea.co.uk).**

 [www.hub-4.com/usefulsites](http://www.hub-4.com/usefulsites)

## Conveying the MHEA Secretary's story

Peter Webster is from the Belt Conveying sector, specialising in steep incline belts. Having originally worked for a subsidiary company Peter went on to form a new company - SBS with a colleague. The beguines grew to become a market leader in this field. From the outset they joined MHEA realising the benefits of membership for a new company in the materials handling industry. "I was involved with MHEA even before then attending my first meetings in the late 1970s," says Peter. "I was lucky enough to be President in 2002 and have always enjoyed not only the technical aspects of membership but also fellowship of others in the same industry."

In October 2008, Peter formally took over as secretary from Dr Harold Wright, who retired after six years of service to the association. HUB 4 was very sad to hear the news during the production of this issue that Dr Wright passed away. We would like to take this opportunity to send our condolences to his family.

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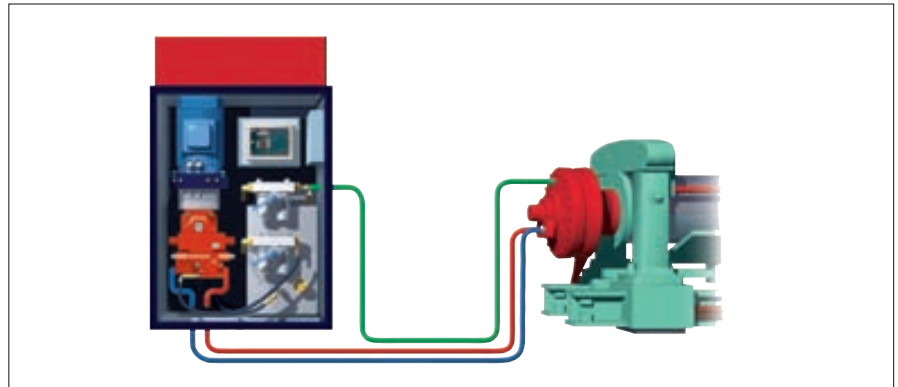


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A typical Hägglunds Drive consists of a drive motor selected from the wide range available to give the torque required. A power unit with a variable displacement pump/motor set and necessary tank, filters and instrumentation. A control and monitoring unit and the inter piping. The arrangement is versatile and flexible which enables customisation to suit the exact requirements of the application and environment.

applications like conveyors, feeders, drums, mills, mixers and heavy mobile plant; featuring versatile mounting, through drives and perfect power sharing for one or more motors acting

together. The power unit can be positioned well away from the drive in a convenient place leaving a compact drive with minimal maintenance to do.



Heavy drums can be driven by one or more drives sharing the load, in this case 4 drives. The pressure in the system inherently balances between the drives and a smooth efficient operation is assured. Hägglunds drives are also used on Digesters, Cement Kilns and Sugar Diffusers and Trommels.



This 8000 tonne/hr belt conveyor at LKAB's Luleå plant in the north of Sweden was supplied by Roxon. They were impressed with the smooth speed control and that the shaft mounted motors require so little space and no foundations. Vibrations and noise levels were also lower than normal and it can run fully loaded at low or high speeds as required.



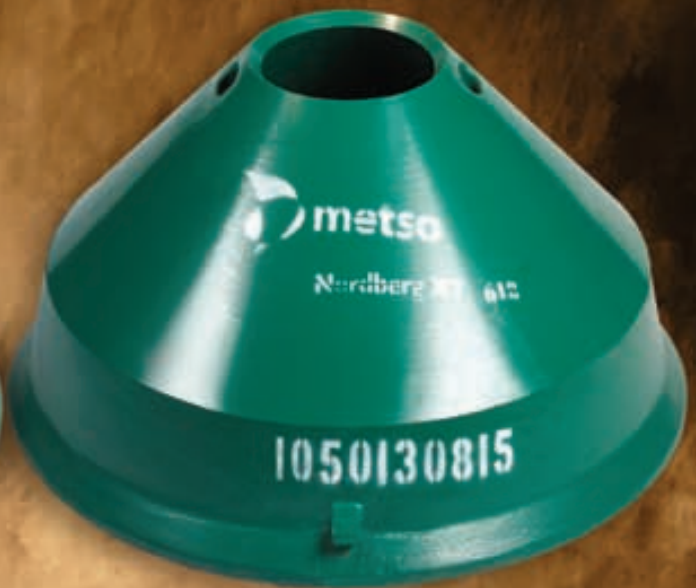
This feeder is driven by a Hägglunds Compact motor type CA100 with variable speed and starting torque of 33kNm, some three times higher than nominal and demonstrates the attractive simple and compact arrangement with the power unit conveniently positioned out of the way. Compact motors are highly efficient and come in over 40 sizes so they can be exactly matched to your needs.

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# Screening out contaminants to give soil a new lease of life

**A suite of screens is helping Arletan keep up with demand for its land remediation processes as Ross Matthews finds out during on a trip to Wales.**

Drive right to the end of the M4 motorway in Wales and there, in Carmarthen's Cwmgwili Valley, you will find a Recycling Village. Arletan's 40 acre landfill and recycling site is the largest privately owned waste recycling facility in Europe, managing waste from demolition, civil construction developments, local authorities and landscape gardeners.

When, in 2006, Eddie Court and his business partner bought an off the shelf company called Arletan and then the Cwmgwili site that was just being used for inert landfill they essentially started from scratch. A lot of hard work and development at the site has seen growth escalate in just two years.

While still taking inert landfill, today the site, christened by Arletan as a 'Recycling Village' has two waste transfer stations, four different licenses for tipping and a fleet of new lorries. Arletan also has sites in Essex, where its head office is now located, and operates out of Manchester and Birmingham.

"If everything comes off as planned this year alone we will have £60 million of business on the books," says Eddie. "It's escalated that quickly."

Starting as a landfill and recycled aggregates business, the company is now using modern plant and machinery to recover, remediate and convert waste to aggregates, subsoils and topsoils for use in a vast range of building, construction and landscaping products.

The original objective for the Recycling Village was to recycle a minimum 85% of the aggregates and soils that pass through Arletan's hands, thereby reducing the need for landfill. Arletan then acquired the rights to land remediation technology from the US called Retekulation and this has been a key component the company's success as this process allows Arletan to recycle 100% of material.

Remediation is just one thing Arletan does. "We have an advantage over most waste firms in that we have so many different avenues because we have the licenses and planning for it," says Eddie. "We can carry out works from land stabilisation to general muck shifting to supplying secondary aggregates as a one stop shop."


The current state of the construction market is keeping the aggregates side of the business quiet. However, for the remediation and treatment packages Arletan gets at least two enquiries every day and is eyeing up some very major accounts.

Playing a vital role in the remediation process and helping keep pace with demand by facilitating the high throughputs required by Arletan's growing business is a set of mobile equipment supplied by Fintec. ►



*The Extec Robotrac being used in remediation process to turn primary 'claggy' filter cake with a high oil and iron content as well as a high moisture content of 68% plus that would normally go to landfill into dry product with a 0.5% oil content that can be used as backfill in furnaces.*





Fintec 640 screening contaminated soils

## Land remediation

Retekulation is used to treat soil from contaminated land either on-site or off-site at Arletan's licensed facilities. "We can treat most contaminants and the system has a 100 percent success rate," says Eddie. The process reduces a customer's need to buy in aggregates in order to replace dig and dump soils by allowing contaminated soil removed from site for treatment to be reinstated for a fraction of the cost of traditional methods. In all cases where this process has been used in the UK, the treated soil has been approved by local Environment Agency teams for re-use on-site, for instance, either as a paving base for roads and car parking or as structural backfill.

extended, making it a lot longer than other Robotracs. This allows the agents to be fed more efficiently. Dust suppression has also been added.

The Retekulation process essentially sees Arletan designing a mix of reagents to treat the contaminated soil. "Each mix is different and is designed to tackle the particular contaminants in the soil being treated," says Eddie. The mix is delivered to a silo, which feeds either the screen or the Robotrac to get the agents into the material. It's computer controlled to ensure the precise percentages required for the mix are delivered. "Our biggest challenge was how do we get these reagents into the material?" says Eddie, "Especially in Wales where

explains.

Material arriving directly from a soil wash can go straight through the Robotrac or the finger screen to get the reagent into it. "We can pick and choose, using whichever machine is more appropriate," says Eddie. "Every site is different; it could be down to available room, if we are working on a customer's site."

Speed is of the essence as well, especially with the equipment. Sometimes we can put through 2000 tonnes of contaminated soil a day - it can vary from a minimum of 75 tph. By the end of the day that soil will be treated. The recycled material is then stored on site or reused on site if carried out onsite.

"When we purchased the site there was an old screen here but it needed upgrading to handle aggregates so we purchased the Fintec 542 screen in June last year. Because of the service we had from Fintec and with the growth of our remediation service we bought another finger screen from them. We also bought the Extex Robotrac from them, and had it painted in Fintec Blue, which we've adopted as the colour of our machines.

Painting wasn't the only thing Fintec did for Arletan. The company was able to modify its machines to meet the precise needs requested by Arletan required for the Retekulation process.

"We've had these machines purposely designed to what we need and the service Fintec has given us is spot on," says Eddie. However, he's keeping these modifications under wraps as they play an important role in Arletan's process.

In addition to Retekulation, Arletan offers other remediation packages and these also involve the Fintec mobile equipment and the company is looking to purchase more machines as new contracts come on stream. "We have learned from using our equipment and have discovered that it would be beneficial to make a few more modifications, just to tweak them further to our needs and get an even better result and push more material through the equipment for a faster turnaround.



Arletan's Fintec 640 has two fingers

The company provides a 'one-stop-shop' where initial site investigation, excavation, haulage to Arletan's site, decontamination and, if necessary, disposal can be taken care of in one place.

The suite of mobile machines Arletan uses for its remediation processes includes a Fintec 542 Tracked Screen, which on the day Hub visited South Wales, was busy at Arletan's Dagenham site treating organic materials from the 2012 London Olympics site, a Fintec 640 finger screen with two sets of fingers and an Extex Robotrac, which has been

you have particular problems with the clays. The most important thing about treating contaminants is that you need to get inside the smallest particle you can. We have found a way of doing that by adapting the mobile equipment."

Material may go through finger screen first, which removes the oversize material, leaving the lower fragments to be treated. "Where you have larger stones in contaminated soils, these stones are not necessarily contaminated, so we can screen them off so that we only need to treat the lower fragments," Eddie





*The recycled material in the foreground comes from the dark material at the rear of the picture.*

Contaminated material hauled from this client's site is put through the Robotrac for treatment. The dark, coloured material going in is primary 'claggy' filter cake with a high oil and iron content as well as a high moisture content of 68% plus. This would normally go to landfill.

"We needed to get the oil content down to 0.5% so the resultant product can be reused as back fill in furnaces and the iron salvaged," says Eddie. Once it has been treated it is dried and shipped back to the client. "We do 500 tonnes a day," Eddie adds. "It takes a second day to cure before ending up with the dry product that can be reused. We've done something that is basically simple yet produced such a good end product," says Eddie.

This one waste stream for this client has led to Arletan signing up to deal with more waste streams and the company is just about to finalise a significant ten year contract.

During a tour round the Cwmgwili site we drive past the piles of treated material for resale. Pointing out one pile as an example, Eddie says: That came in from Ebbw Vale Steelworks as high TPH (Total Petroleum Hydrocarbon) material. We have an order for 10,000 tonnes of that to go out as a fill material to save the customer having to purchase aggregates."

Arletan has taken in Bentonite that will be used in a landfill cell in Swansea as Bentonite liner. "Where spent Bentonite would previously have been rendered useless because it has become wet, we can dry the moisture off and put it back into a form that can be reused to give it a second life," says Eddie.

Among other applications, Arletan treats dredged material and stabilises it for reuse. "We can carry out 300 tph and more if necessary."

The company is even getting enquiries from Kuwait's oil fields to help clean up Saddam Hussein's lingering mess.

Word is getting around very quickly about what these processes can achieve. "When we began I was chasing the markets like mad. Now they are coming to us, says Eddie. "The options are endless. We tend to go for individual client needs."



*Eddie Court demonstrates the dry material that has been recycled from material that would have otherwise gone to landfill.*

"The biggest problem I find, especially with the WAG (Waste Acceptance Guidelines) criteria, is getting local authorities to adapt to using recycled aggregates, which should be their policy. If recycled material meets the required specification then it shouldn't be a problem, but it's just a question of attitude. But it is still a growing market."

Indeed, Arletan is looking forward to a good year and hoping for good summer weather, as last year they were dealt a rough blow with the poor weather. "On average we get 75,000 tonnes in and 75,000 tonnes out every year. I think this year it could be double that," says Eddie.

## Ongoing investment

As part of its ongoing investment Arletan is looking to invest in a soil washer. "This will be a mobile plant and will allow us to carry out contaminant treatment off site as well," says Eddie. The company also wants to put in a trommel and picking station for the C&D waste.

As Arletan signs up new contracts it will also be looking to increase its fleet of Fintec equipment. "We group all our mobile equipment as 'suites of equipment' required to carry out a set amount of work," says Eddie. "A suite would be classed as a Robotrac, excavators, and the finger screen (we don't always use both) and this suite of equipment will carry out a set amount of work. At the moment we run two suites. By the end of the year we will have ten suites." ►

## Happy customers

As mentioned earlier, Arletan has carried out work for the 2012 London Olympics site in East London. In addition to the organic material it is currently processing it has also taken filter cake from soil washers at the site back to Dagenham for treatment, before returning the material back to the Olympics site for reuse.

Eddie comments: "The filter cake came off their soil washers - soils from 90% of the site had to be washed. We treat the fine element where the contaminants are and turn it back into cementitious aggregate, which can go back for reuse on the site as general fill rather than go to landfill."

Eddie adds: "Some thought this couldn't be done but we proved it could and this has subsequently opened up a lot of doors for the company. The process saves customers having to buy aggregates; they can reuse their soils and it diverts waste from landfill by recycling. We offer the whole package from plant hire, through to haulage."

Reusing materials is one of the biggest trends in the industry, according to Eddie. "It stops people importing natural quarry stone and all companies are being forced to go down the environmental route. So I think we have something better to offer in terms of sustainability than a lot of people realise. You only have to look at the landfill costs going up again for oil content material - it's nearly £900 per tonne."

Arletan is carrying out trials for another client that will lead to a significant new contract.





## What is Retekulation?

Redeveloping potentially contaminated brownfield sites is now a standard practice in construction and civil engineering and Retekulation is Arletan's fast deployment mobile service for this process. It can be applied to any project for on-site remediation, providing environmentally and economically sustainable development solutions for the future of construction.

Arletan takes samples of soil to be remediated and compare them with contaminated land data from hundreds of previously treated sites. The company then deploys its mobile equipment and techniques to the site. Treated soil stays on site, which reduces the customer's haulage and landfill costs.

Arletan licenses the Retekulation process developed in the US in mid-1980s. The process essentially mixes chemicals reagents and binding agents to eliminate the hazardous physical and chemical constituent properties to remove any environmental and health risk from the source material, whether its is organic, inorganic, sludge or dredge material – leaving no residual waste, creating a dry and environmentally safe bi-product that can be used as backfill or secondary aggregate safe for onsite or off site reuse. The secondary aggregate can be used on site for example as a paving base for roads or car parks. Since April 2008, site waste management plan regulations have been in force. Arletan can process hundreds of tonnes per hour per mobile unit.

## A suite of mobile equipment to help Arletan keep up with demand

A combination of Fintec and Extec machinery - both companies part of the Sandvik Group - is helping Arletan keep up with demand. The Extec Robotrac track mounted scalping screen, employs a screening process that doubles as a grading screen in many applications. Designed to scalp the heaviest of material, it can also screen finer sizes. The machine's manoeuvrability allows it to be used in a variety of sites and applications. The unit is fitted with Extec's double deck vibrating grid and provides high speed scalping of sticky clay and fines from heavy rock and concrete. The heavy-duty impact feeder absorbs shock loads and maintains smooth flow of material to the stockpiling conveyor.

The Fintec 542 Tracked Screen is designed specifically for the recycling and Contractor market. It has a 3650 mm x 1500 mm two bearing screenbox with increased screening angle built into the bottom deck of the screen. This feature coupled with the larger screening surface area and increased throw on the screenbox enhances screening efficiency and capacity, through the actual screenbox itself.

The belt feeder has an 8 m<sup>3</sup> capacity and is fitted with a radio controlled tipping reject grid as standard. A CAT 3054C water-cooled diesel 74 kW engine with an Engine Shut Down Protection System drives the machine. The main conveyor is fitted with a 1050 mm heavy-duty belt. The tracks are 500 mm wide to cater for various ground conditions and are pendant track controlled.

The Fintec 640 is a heavy duty scalping screen that can work as a stand alone three-way split screener. Constructed for easy mobility and transportation the unit's conveyors are hydraulically foldable and walkways are fixed, for quick transport and set up time on site. The screen can be feed by loading shovel, excavator or crusher The Hardox steel apron feeder provides a solution to aggressive applications and feeds directly on to the variable angle screenbox for maximum screening efficiency.

# Leeman family invest in more machines for expanding metals and waste handling at Benfleet

The Leeman family-owned group of businesses has been a prominent player in the scrap metals trade in southeast Essex for almost 50 years, since it was founded by PW Leeman in 1960. Now the third and fourth generations of the family are continuing the tradition: they have three independent operational centres in Essex, at Benfleet, Grays and Laindon, with a combined total annual throughput of some 180,000 tonnes of scrap metal, mostly ferrous material.

Since its founding, the company has purchased some 40 Terex material handlers for its scrap handling and loading duties. Last year, two new Terex TM350 material handlers were added to the Benfleet operation, where seven Terex units were already in service. More recently, another new TM350 has been installed at Grays, to work alongside an existing Terex TM1804ML.



Anthony Leeman, who runs the Grays operation, explains: "We have recently expanded to practically double the size of the site here at Grays, and our plan is to extend the scope of the facility to take in general waste for sorting and recycling. Although the metals trade is going through a downturn at present, there is an ongoing need for efficient general waste processing and recycling, so we are setting up a new, separate specialist unit to deal with it.

The Leeman family has also had a longstanding working relationship with the EMR group, and most of the metals output from Grays and Benfleet goes to the large EMR shredding and export facilities at East Tilbury and Tilbury Docks.

The 35-tonne Terex TM350 is equipped with a main boom and stick arrangement, which give a maximum outreach of up to 18.2 m, and an orange-peel grab for precise sorting and handling. It also features a hydraulic elevating cab, giving the operator a clear view around the loading area and into trucks and hoppers.



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# Are you prepared?

**Are you prepared for stricter health and safety rules? New legislation recently introduced will significantly increase the penalties for health and safety offences.**

Introduced on the 16th January 2009, the new Health and Safety Offences Act 2008 defines that the maximum fine that can be imposed in the lower courts for breaches of health and safety regulations has been increased from £5,000 to £20,000.

This new legislation will bring into effect heavier penalties for offences. Although the financial penalties in the upper courts remain unlimited the range of offences for which employees, directors, managers and officers can be imprisoned has been broadened, which will become an option in both the lower and higher courts.

Prior to this new legislation, very few health and safety offences could result in imprisonment. With many past offences resulting in a possible prison sentence, in reality custodial sentences could only be imposed in a few, very limited circumstances. However, with the new legislation an urban myth has now turned into reality.

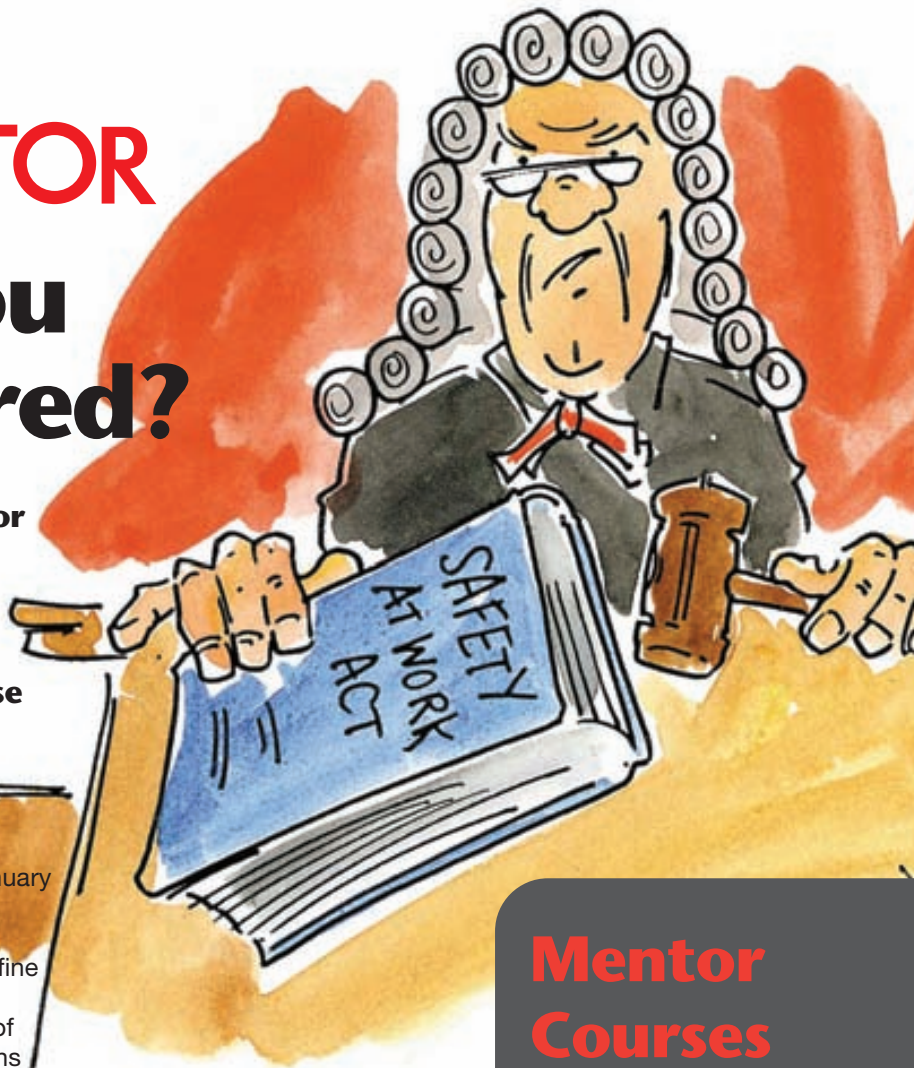
For instance; larking around at work with a forklift truck and accidentally driving over a colleague's leg resulting in a long term disability, would under the old legislation result in a fine – under the new rules a prison sentence is more likely.

Although the recent Corporate Manslaughter legislation received a lot of attention it did not make it any more likely that directors and senior managers would be sent to prison following a workplace death.

In contrast, under the new rules, individuals at any level in a company can be sent to prison if they take short-cuts with health and safety – even if no-one has actually died or been injured.

Now is the time to check your health and safety policies and practices in the light of the new legislation. These should ensure that there are appropriate and robust mechanisms in place to keep your work people healthy and safe at work, and to protect yourselves and your management from both civil and criminal prosecutions arising from health and safety breaches.

Companies should also check that they have adequate insurance cover for any related legal defence costs.



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## New name, same great products

Rammer is recognised by the Quarrying, Demolition and Recycling industry as a leading supplier of quality hydraulic breakers, crusher breaker booms, and demolition equipment with a reputation for productivity and reliability.

Rammer products are now sold under the Sandvik name but the products remain the same, along with all the features and benefits that have made them a worldwide market leader.

In the UK, Sandvik Mining and Construction is the distributor providing a comprehensive sales, service, parts and product support back-up through a highly experienced specialist national dealer network.



## Magnetic sweepers launched



Master Magnets has launched a new range of cost effective magnetic sweepers that can help prevent the costly downtime associated with the repair or replacement of tyres as well as the cost of the tyres themselves, reducing the running cost of vehicles. Called MasterSweep, the range is designed to remove ferrous items such as nails, nuts and bolts and scrap iron etc from large areas, reducing foreign object damage to company vehicles.

The new sweepers include fork-lift mounted magnets, which are simply attached to any forklift for the removal of ferrous objects from spaces such as floors, car-parks and loading bays. The range comprises a variety of sizes to suit the application and does not require a power source.

Adrian Coleman, the company's managing director explains: "Our new MasterSweep range intends to meet current demand for cost effective equipment that still does the job. The sweepers are great for transport companies or manufacturing companies to reduce the cost of flat tyres and damage within their fleets, and will last indefinitely if not abused."



Also included in the range are hand operated broom sweepers used to clear smaller areas of ferrous debris. These sweepers are manufactured from aluminium giving a durable yet lightweight construction, allowing it to be easily lifted over any bin to deposit the ferrous.

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## KCM takes shredder for green waste processing

**Increasing volumes and varieties of recyclable materials coming into KCM Metals & Skip Hire's recycling plant in Rotherham has seen a significant growth in green waste, which has necessitated an addition to the company's range of processing machinery. Turning to Blue Group to provide a solution once again, KCM has purchased a new Doppstadt DW-3060 Shredder from Blue Central specifically to render the green and wood waste for biomass production. KCM's new Doppstadt shredder's advantage is that it can handle tramp material such as metal, which is a significant benefit when processing mixed materials and particularly woodwaste sourced from building and demolition sites.**

Mark and Phil Hickling, owners of KCM Metals and Skip Hire, have built an MRF and Recycling Centre at their Rotherham premises where, in addition to processing and recycling commingled waste, the company is also baling a variety of plastics and cardboard. Loyal customers of Blue Group for some time now (KCM bought a baler last year from Blue to form part of the MRF), their new Doppstadt shredder is already proving a wise investment, with a productive and reliable performance for this growing side of KCM's recycling business.

Commenting on their new acquisition, Mark Hickling says: "We're really impressed with the reliability and throughput of the new Doppstadt. We had a few other shredders demonstrated and the Doppstadt blew them away. It seemed hungry compared with the others", he said, "and its capacity and how easily it dealt with the input waste was impressive". As for Blue, Mr Hickling was glowing in its praise. "We are really pleased with the after sales service, especially from Blue Spares. In our industry we need top-class parts availability and Blue has provided next day if not same day. They really have taken care of us after the initial sale".

The DW-3060 three-axle, 23.50 tonnes operating weight, slow-speed, high torque shredder is one of the larger machines in the Doppstadt "DW" range. Capable of handling larger bulk timber, mixed construction waste and industrial refuse, the DW-3060 has numerous features. These include optimum tooth arrangement on the roller, reversible fan wheel, modified hopper shape for easy loading, electrically controlled roller reversing and a large return conveyor. The 315 kW diesel engine has power to spare for heavy duty applications where pre-shredding is the first step in a materials recycling or waste minimisation operation.

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## Over 180 local authority waste contracts due out to tender shortly

With many waste markets coming under pressure in the short term, waste management companies need to capture local authority contracts to ensure longer term business. The industry marketing consultancy, BDS Marketing Research, has identified over 180 waste collection and waste treatment contracts that will be out to tender over the next three years.

55 local authority waste collection contracts are expected to be let before the end of 2011. Over half of these will be in the south east. Veolia is currently the largest company in this sector. BDS has identified more than 50 contracts held by the company, out of a total of over 400 for the industry.

A separate report published by BDS lists details of local authority waste treatment contracts for the operation of HWRC, composting sites, integrated waste management, recycle and transfer stations. In this sector, SITA, Viridor and WRG are identified as market leaders. BDS estimates that more than a third of the total 360 contracts in the country will be let before the end of 2011.

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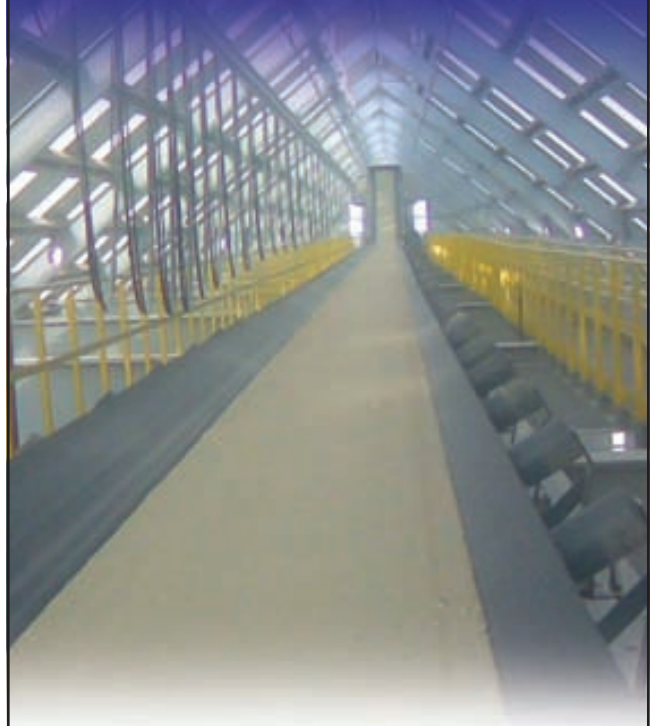


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## Camera chosen for world's first Liebherr R984 high rise ship loader

**The world's first High Rise Liebherr R984 ship loader has recently been supplied to S. Norton & Company, one of the UK's leading metal processing and recycling organisations which handles approximately 1M tonne of scrap per annum.**

Although the new 220 tonne crane arrived at S. Norton's Liverpool base with a pair of cameras linked to a single in-cab monitor covering views to the front and rear of machine, in the interest of maximum visibility and safety the company decided to add a further three cameras and two monitors.

Supplied and fitted by Spillard Safety Systems, two of the new cameras have been strategically located to provide a clear view of both sets of tracks, which are nearly 13 m below the operator's eye level and the third is attached to the dipper arm. This particular camera is vital to the operator when lowering scrap into a ship's hold as the view on one of the monitors enables him to accurately position the grab, despite the fact that the machine's maximum reach to the tip of the dipper is 38.5 m with up to 35 m under the grab.

Commenting on the relationship with Spillard, S. Norton's operations manager Dave Matthews says: "We have worked closely with Spillard Safety Systems on a variety of visibility projects over the years and have always found the company to be very professional and helpful. The new Liebherr machine is a major investment for us and to ensure its safe operation on our busy site it was extremely important that we chose high quality camera equipment."

The three heavy-duty cameras supplied and fitted by Spillard Safety Systems are all protected from accidental damage by specially fabricated boxes and are linked to a pair of the company's Optronics monitors mounted at eye-level in the operator's cab.

## Separation technology supplied to Sackers

**Waste Processing Solutions, the company created by the Finlay Group to cater specifically for the recycling market, has supplied a specialist material recovery facility to Sackers Recycling.**

The Carmac Light Separating Unit (LSU) C1200 is already increasing Sacker's recovery of light material at its Ipswich-based plant by 20%.

With a patent pending, the Carmac LSU C1200 waste classifier is an innovative, high quality lights separating system. Typical applications include the separation of wood and aggregates, as well as paper and plastics.

Easily integrated with existing plant or Carmac's range of units, the system has various output options to a container skip or conveyor system.

Nigel Slinn, commercial director of Sackers, which is based in Gt Blakenham near Ipswich and services the Suffolk area, says: "We are predominantly a scrap metal processor, but five years ago moved into waste recycling and have seen year-on-year growth in the business.

"We currently divert up to 80% of the waste we handle away from landfill. The new recovery facility from WPS is helping us to achieve that figure by increasing our capacity by 20%, so it has been a valuable addition to our operations.



"Before making a choice, we looked at various material recovery facilities. The C1200 appealed because it deals with all waste streams, heavy and light, in one standard operation. The other machinery we looked at was not able to do that. The after sales support from WPS also appealed."

This is the first deal between WPS and Sackers. Last year, WPS – part of the Stafford-based Finlay Group of companies - secured a sole distribution agreement with Carmac Waste Handling Systems spanning England and Wales. WPS cited the fast growing demand for efficient, cost effective waste recycling solutions as the reason it moved into the market.

David Statham, a director of WPS, says: "Carmac equipment is based on experience gained over 10 years in the recycling industry and we are able to provide the time-proven machinery with an extensive after sales service and support package."



## Environmental Marketing Solutions Ltd, one of the most respected manufacturers of bespoke recycling plants and materials handling solutions in the UK and Ireland.

EMS has plants installed and working in some of the most effective materials recovery facilities in the country.

**The company is able to offer solutions to companies handling a broad range of waste streams including:**

- Construction and Demolition (C&D)
- Municipal Solid Waste (MSW)
- Industrial Waste
- Green Waste
- Top Soil, Wood Chip and Compost
- Ferrous and Non Ferrous Metals

EMS has a vast knowledge of waste sector equipment and offer a broad range of new and used products to meet customer needs. All EMS plants are custom designed, manufactured and installed to customer requirements and tailored to suit material, site and budget.

EMS current products include: Trommell Screens, Conveyors, Finger Screens, Vibrating Screens, Picking Stations, Suction Systems, Fan Systems, Shredders, Magnetic Separation, Eddy Current Separation, Bag Openers, Enviro Cabins, Compactors and Balers.



EMS Waste Recycling Systems can reduce waste sent to landfill, improving the quantity and quality of recovered material and will increase throughout the capacity of existing sites or equipment.

EMS are available to help organisations of all sizes from initial concept, through design, manufacture, installation and after sales to help you Reduce, Re-use and Recycle more material to ensure a greener future for all of us.

## Recent EMS Installations include:

### Wheeldon Brothers Waste

A long standing customer of EMS have installed their third plant at a site in Oldham. The plant consists of 2 x 823 trommels, two picking lines and electromagnets. The new plant is positioned against existing premises with the trommels and waste stockpile housed in an existing shed. An 18 metre long x 6 metre wide cabin adjacent to this building having two 1200mm wide picking belts over 7 bays with 2 electromagnets.

The plant is primarily handling MSW; the twin line system allows most efficient use for quick throughput of MSW, and also has the capability to run construction and demolition waste if required.

Jonathan Wheeldon of Wheeldon Brothers Waste is very happy with the system as his site is now capable of handling much more waste; processing it quickly and more efficiently than before. Recovery rates are high and staff at Wheeldon Brothers prefer the new system (which is much safer and comfortable) in contrast to manually sorting waste on the ground in all the elements.



### J Doyle Group-Westhoughton - plant installed and commissioned January 09

An EMS plant was supplied through our long standing dealer CDP plant Chesterfield to J Doyle Group at Westhoughton, Bolton.



The plant comprises of an 823 trommel – 4 bay, overband magnet and an air knife complete with lights suction system and compactor all housed in a custom built enviro – cabin.

The plant is receiving mixed waste including C&D and MSW. Reports from William Nuttal – MD of J Doyle – are positive; recovery rates are high and the recovered material is of good quality. Substantial amounts of waste are being diverted from landfill thanks to the installation of the EMS system which is great in light of the new rate of landfill tax.



# A sleeper crushing solution for Network Rail

As part of its infrastructure investment and commitments for the future to renew, maintain and enhance the rail infrastructure, Network Rail generates approximately 650,000 used concrete railway sleepers per annum.

Network Rail's dedicated recycling team had the enviable task of seeking economical and environmentally friendly disposal methods for all concrete sleepers no longer meeting specifications for reintroduction back into the railway infrastructure.

The company decided to invest in mobile crushing and screening technology from Aggregate Processing and Recycling (APR), which as the UK and Ireland agent for GIPO, supplied a GipoREC R150C (with special modifications) high performance, heavy-duty tracked impact crusher, and a mobile GipoSCREEN S2045DR for the project.

With a current stockpile of 16,000 sleepers at Network Rail's Newport, South Wales site, the two machines were delivered to primarily crush the concrete railway sleepers of F19, F23 and F27 type with an average weight of 275 kg each.

APR worked closely with Network Rail to supply a machine that addressed all the issues that were raised; including effective transportation of the sleepers into the crusher, crushing and separation of pre-tensioned wire, screened material into 1 or 2 grades, closed circuit oversize crushing, and mobility.

Where as the GipoSCREEN supplied is comparatively standard, the GipoREC R150C included several modifications:

To accommodate the length of the sleepers, the angle of the feed channel is raised and incorporates a steeper drop to the rotor 'nip' point.

With a crusher inlet fixed at 1500 mm wide x 1200 mm high the crusher outlet to the discharge channel was also raised an additional 300 mm to allow for better clearance of the crushed concrete and steel.

A short crusher reciprocating discharge conveyor is also incorporated which allows movement of the entire conveyor to give a 1 m clearance to help with potential blockage removal.

To resolve the separation of pre-tensioned wire an extra heavy-duty overband, two pole magnet is positioned to remove the extracted steel wire forwards from the discharge conveyor (as opposed to normal 90° removal of lighter rebar and scrap steel).

To complete the GipoREC R150C machine modifications, the main discharge conveyor is radial through 180 degrees allowing for easier positioning of the GipoSCREEN, or alternatively for radial crushed concrete stockpiles.

In Network Rail's normal operational position, the crushers' main discharge conveyor feeds into the feed boot of the screen.

The GipoSCREEN features radial stockpile conveyors all with remote control hydraulic positioning, with the oversize (from the top deck of the screen) conveyor positioned to feed back into the crusher's feeder.

"We have finally found a solution to the age old problem of disposing of the used concrete sleepers that return from Network Rail's renewals sites, most of which were sent to landfill," says Nigel Bownes, senior recycling & sales specialist

"After various crushing trials over the years we have found that the Gipo allows us to recycle the sleepers into usable products with the clean steel strand being sold and, by using the GipoSCREEN, we can produce a Type 1 stone that can be recycled back into the infrastructure, thus moving the material further up the value chain."



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## Hadley Recycling & Waste Management chooses Precia-Molen.

Precia-Molen has been chosen as the preferred supplier of weighbridges, weighing systems and maintenance support services to Hadley Recycling and Waste Management (HRWM).

Operating seven sites in Berkshire HRWM currently has Precia-Molen weighbridges installed at four sites and two further weighbridges ordered for their Colthrop and Shipton-on-Cherwell operations.

Based in Theale, near Reading HRWM process 400,000 tonnes of waste annually, with a comprehensive business model that includes skip hire, a tipper fleet and a static wash plant located at the Moores Farm operation to process recycled aggregates. With a current recycling rate of 75% HRWM has plans to increase to 90% over the coming year.

Believing in sustainable solutions the company is passionate about conserving the planet's natural resources;



acknowledging the responsibility they have to the environments in which they operate. The company operate an ethos of utilising the latest technology and integrated processes, which coupled with their highly motivated and technically competent employees has enabled them to deliver first class waste management solutions.

Precia-Molen has supplied two 15 metre VS400T weighbridges with 1 300 programmer weighing indicators for the Heron's Nest and Moores Farm operations. A third 9 metre VS400T weighbridge with a 1 300 programmable indicator has been hired to Eversley; and a VS350T weighbridge with 1 200 programmable indicator has also been installed at the Field Farm operation. All have been integrated into Hadley's own business management system.

Martin Elford - General Manager, commented, "We have been very pleased with the professional service we have received over the years from Precia-Molen."

The VS400 series is a truly versatile weighbridge designed by Precia-Molen and offers the user the most flexible weighbridge solution for all industrial weighing applications

Combining strength, durability and flexibility with a modular all-steel, fully welded construction that is entirely suitable for in ground or surface mounted installation.

Standard module sizes are 7.5 and 9 metres in length, which may be combined to provide a weighbridge length of up to 36 metres.

Precia-Molen specialises in industrial weighing, both static and dynamic within the minerals, cement, waste and agricultural industries and has an enviable reputation for innovation and quality at the forefront of weighing technology.



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# New Waste Processing System for Ace Liftaway



**DUO Manufacturing (LJH) has recently completed a project for Ace Liftaway at Romsey, Hampshire.**

**Designed, manufactured and installed by DUO Manufacturing (LJH) the new system is designed to handle two types of material, normal skip waste and light commercial waste.**

Ace Liftaway, a family operated concern was established in 1988 and quickly grew into an extremely successful business. From a small start of one truck and eight mini skips the waste fleet has since increased to 30 waste vehicles ranging from skip loaders of all sizes, hook loaders, tippers and tipper grabs along with two double drive tractor units pulling injector and walking floor trailers.

In 2002 the company moved from its premises at Braishfield, near Romsey to a new site at Yokesfield Hill Industrial Estate at Belbins, Romsey. With the move the company was able to establish a Waste Recycling Centre where 80% of the skip waste stream could be recycled.

In 2007 Ace Liftaway commissioned DUO Manufacturing (LJH) to design and manufacture a new, larger recycling plant which would enable them to produce sustainable, marketable and consistent products of grit, 20mm/40mm/75mm crushed rubble, 6mm/40mm soil, clean wood, dirty wood, cardboard, non-ferrous and ferrous metals and have the facility of segregating plastic. Blower bay material would be destined for waste to energy.

The development of the new facility would ensure that Ace Liftaway remain an industry leader in waste recycling.

Having purchased the original system from LJH the company had no hesitation in going back to them to order a new system due to the durability, strength and build quality of the previous plant.

## The processing system.

The new system is operated on separate shifts where pre-sorting of the waste is carried out to remove large and heavy materials. This includes any materials which could block, or damage the plant, or cause injury to the operating staff.

All incoming skip waste is fed onto the system by means of a vibrating feeder which is complete with a heavy duty hopper fitted with bolted mild steel liner plates. The support structure for this arrangement being encapsulated with removable steel plates to prevent any ingress of spillage.

Any lights material is fed into the system through a hopper which in turn delivers material onto a heavy duty belt feeder fitted with a variable speed drive to regulate the feed of material.

From either of the feed stations material is fed to the trommel screen by a feed conveyor. Fitted with a variable speed drive this conveyor can be programmed to run at differing speeds depending on which type of material is currently being processed. Impact bars are fitted at both feed points onto this conveyor.



*Trommel during installation*

A six bay trommel, 9.4m long x 3000mm diameter then screens out the - 40mm fraction of the material. This screen has been manufactured to the standard LJH heavy duty design, with removable plate decks. Specifically designed for this system it has been increased in diameter to accommodate the lighter type waste.

The + 40 mm material is then conveyed to the picking station by a belt conveyor (C2) which is similar in design to the feed conveyor, except that this unit is fitted with a fixed speed drive and one picking point on the right hand side. This picking point facilitates removal of any extra large pieces to prevent blockages at the transfer of material from (C2 to C3-picking station).

All material from the picking station belt passes over an air knife at the transfer point to (C3). This device removes a high percentage of light waste from the feed onto the picking station. Air flow is easily controlled by an inverter which can be pre-programmed to suit differing types of feed material.

The picking belt then conveys the material through the picking house. This conveyor has a variable speed drive which is adjustable by a rotary potentiometer switch from either side of the belt. System reset and auto start/stop controls are also included in the remote control units.

Any 'non-picked' material then passes under an electro magnet to remove the ferrous material which is then discharged into a stocking bay below. A bi-furcated chute with a manually operated diverter gate then distributes the 'non-picked' waste, either on to a lights waste stockpiling conveyor (when the lights system is operated), or the heavy stone/concrete waste is fed in to a jaw crusher when the heavy skip waste system is operated. An interlock is also fitted to the control on the chute diverter gate mechanism to prevent the light waste system from starting if the gate is open to the crusher feed.

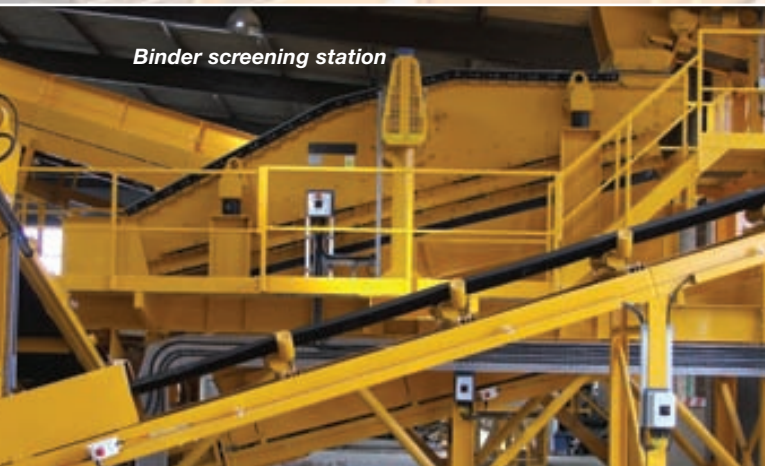


All -40mm material is then collected from under the trommel screen by a steep sided under chute which is fitted with an inspection hatch, suitably sized for entry to carry out routine inspection or maintenance.

A troughed belt conveyor system then feeds the -40 mm material from the trommel to the Binder screening station. This system comprises of a conveyor under the trommel, to a transfer conveyor, which then feeds onto the Bivitec screen feed conveyor.

An overband magnet is fitted over the screen feed conveyor to remove ferrous materials prior to the screen and drop them into a stocking bay.

The Binder Bivitec screen supplied through the DUO-UK dealership is a 4 x 1.6m wide double deck screen which is complete with a 20mm relieving top deck and a 6mm Bivitec type bottom deck to maximise throughput and minimize clogging. Any -6 mm material is then collected from under the Binder screen by a steep sided 6 mm under chute. This chute is again fitted with an inspection hatch suitably sized for entry for routine maintenance.



**Binder screening station**

Material is then fed onto a collection conveyor which is mounted under the screen to feed the - 6mm material onto the stockpiling conveyor.

The - 6mm stockpiling conveyor is fitted with a bi-furcated chute which has an electro-mechanically operated diverter gate, enabling stocking of material into either the -6 mm clean or the -6 mm rubbish bays, depending on the quality of the material. This gate position can be automatically selected as part of the start-up procedure.

Any -40 mm +6mm materials rejected from the Binder screen are conveyed to a further bi-furcated chute which has an electro-mechanically operated diverter gate by means of a troughed belt conveyor. This gate position can also be automatically selected as part of the start up procedure.

The clean - 40 mm +6 mm material is then conveyed to the system for final

screening by a troughed belt conveyor, from the bifurcated chute to the crusher discharge belt. Any contaminated -40mm +6mm material is then conveyed to the rubbish stock bay by a troughed belt conveyor.

The system features a crushing station which comprises of a 900 x 600 mm Parker jaw crusher set to produce a -75 mm product. Any crushed material is conveyed to the primary screening station by a troughed belt conveyor. This conveyor also receives the clean -40 mm +6mm product from the Binder screening station.

To maximize the size of the light waste stocking bay a gantry type structure was manufactured to support this conveyor from the edge of the new building to the primary screen station structure. An overband magnet was also fitted over the screen feed conveyor to remove ferrous materials prior to the screen and drop them into a stocking bay.

The primary screening station comprises of a Parker 'Rapide' 5m x 1.8m wide - double deck screen with a 20mm top relieving deck and a 3m long, -10mm bottom deck. All -10 mm material passes through the screen bottom deck into a stocking bay below, with all +10 mm materials passing over a further air knife, to minimize contamination of the final stone products. Any contaminants removed by the air knife will fall into a lights stocking bay below the screen.

The -75 mm +10 mm material is then conveyed to a final

sizing screen by a troughed belt conveyor system comprising of a short transfer conveyor from under the screen discharge onto the screen feed conveyor.

The final screening station comprises of a Parker 'Rapide' 4m x 1.5m wide - double deck screen with a 40mm top and a 20mm bottom deck. This process provides the final product sizes of -75 mm, +40 mm, -40 mm, +20 mm and -20mm + 10 mm which are transferred by chutes into stocking bays below.

The system has proved a great success for Ace Liftaway, Philip Liddell -MD, commented, "DUO Manufacturing's (LJH) reputation for manufacturing solid build quality and our previous experience of their engineering expertise gave them the edge over their competitors. The new plant has come a long way from our original and the heavy line system works exceptionally well producing continuous and clean recycled aggregate which our customers now trust to be consistent in its quality.

We are recovering vast amounts of ferrous metal which previously would have slipped through and been landfilled; the wood recovery is giving us a consistent quality and clean product for our customers. The Bivitec Screen has proved a major success working in conjunction with the trommel. We are not only producing a quality 6mm soil we are removing fines from the light waste stream. The benefit of the large trommel is that we do not get blockages due to its large diameter.



**Picking station during installation**



**Rubble crushing station**

We are also very pleased with the large Picking Station cabin which not only gives our crew a comfortable and a spacious working environment but enables us to remove a large range of products into the 6 bay facility.

The durability of the Parker components has also been successful in producing clean product.

The entire project has cost in excess of £3 million and created a waste centre which runs like a production facility which has already had a significant impact on reducing our landfill dependency, and in return reduced huge landfill costs."





# Feeder design and selection

Following a recent review in the press of the CEMEX Taff's Well project, reference was made to the Skako Comessa vibratory tray feeders. Bob Hill of Skako further explains the careful design and selection of feeder options to suit the exact plant requirements.

For this project, Skako Comessa liaised in depth with the main contractor Whitwick Engineering (Coalville) to ensure the optimum design for each of the eight vibratory feeder positions. Many of the plant features bore a close resemblance, or identical application to a recent project at CEMEX Halkyn by the same main contractor, which incorporated 12 Skako vibratory feeders, and, on which plant, the feeder design options had been proven.

Of the 20 feeders supplied for both projects, 19 were the Skako fully modular design, whereby the tray section is fully assembled into a modular unit, which incorporates an integral flanged hopper bottom section, with skirt plates, manually adjusted bed depth regulation gate and spring suspension assembly.

However, there were then differing drive types, special design features and both open and totally enclosed dust proof designs to suit the location and specific duty. A number of these design features are highlighted in greater detail.

Feeders operating outside were fully enclosed and dust proof. Under a primary crushed material surge bin are two identical feeders, discharging into a common central discharge chute, over the takeaway conveyor (see photo 1). Each feeder is selected to discharge up to 625 tph of minus 350 mm primary crusher run. In order to accommodate the large feed size, whilst being totally enclosed, the feeder trough has a special increased depth and is of heavy duty design.

Each is driven by twin unbalanced motors (suitable for varying loadings on the feeder) with variable feed rate control between approximately 30-100% provided by a frequency inverter. The required plant capacity could therefore be achieved by either only one of the feeders or both at reduced feed rates. Rod gates were also supplied so either feeder could be isolated for maintenance.

When preceding the impact breakers, the feeders need to carry out a number of functions. To be able to evenly spread the material over the width of the impact rotor, to be totally enclosed to prevent safety issues, and be designed to totally integrate with the impactor feed chute arrangement. For the secondary impactor processing the minus 350 + 75 mm material generally at 450 tph, the feeder is 1800 mm wide, special increased depth and heavy duty design, incorporating a customised support frame to withstand the dynamic loads from the surge bin. A feeder of these dimensions would normally be used to deliver over 1000 tph, however, when the size is determined by the width of the impact rotor and not the capacity, it enables smaller drive motors to be utilised, thereby keeping the power consumption down to a minimum.

The same design criteria also apply to the tertiary impactor, processing minus 75mm at 250tph. The feeder is 1000mm wide to evenly spread the feed, but whereas this sized feeder would often be handling coarser material at up to 500tph, this unit only requires half that capacity, with a small maximum feed size. This feeder can therefore be of a compact 'low height' design, with smaller drive motors and

Two identical totally enclosed 'deep pan' feeders

1 - 2 x 625 TPH totally enclosed 'deep pan feeders'





**2 - 250 tph totally enclosed 'low height' feeder preceding tertiary impactor**



the discharge end designed to feed directly into the impactor feed chute (see photo 2). For both the impact breaker feeders, the variable feed rate control is between approximately 30 – 100% via frequency inverters.

Following the final screening inside the screen building, the coarse screened sizes are all handled on vibratory feeders, where product can be re-circulated to the tertiary impactor; blended with other product sizes, or diverted to load-outs. Inside the building, the feeders under the storage bins can all be open design, therefore reducing costs. Also, the simpler discharge functions mean standard sized feeders can be utilised. To give total flexibility over the feed rate and accuracy of discharge, electro-magnetic driven feeders are utilised, giving infinitely variable feed rate control between 0–100% via thyristor controllers, with instant on/off control. The 1000 mm wide feeders can handle up to 400 tph with the 800mm wide feeders handling up to 250 tph at infinitely variable feed rates (see photo 3).

Plant automation was paramount on these projects, with a central computerised control system. It was necessary to start and stop feeders automatically, for instance from level detectors in bins, and also to be able to select the required discharge rates in the control room. This is not a problem for the Skako feeders, because the thyristor controllers for the electro-magnetic driven units are supplied as standard, with a relay for external on/off control, and also integral terminals and selector switch for automatic regulation from an external isolated reference signal. Additionally, the frequency inverters were selected with the same control facilities for the unbalanced motor driven units.

The above examples give an insight into selecting the best suited designed feeders to suit specific applications.

**3 - 400 tph standard design open feeder with electro-magnetic drive**





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# Mobile secondary crushing unit launched



*Roland Svensson, Global Product Manager - Mobile Crushing and Screening, Andreas Persson, Product Manager of wheel mobile units, and Olov Andersson, Design Manager and Project Manager for development of the Sandvik UH421 in front of the new mobile unit.*

The UH421 mobile secondary crushing unit, launched by Sandvik, has a screen placed alongside the unit and comes with an optimal feed hopper. This means that the material is slowed down and well spread out by the time it reaches the screening media and the screening area in general is optimised.

The efficiency of the Sandvik SS screen was illustrated during tests preceding the launch, when 8-16 material taken directly from the crushing unit contained no fines at all. The result was very positive, as the input material was screened shortly after primary crushing, and was therefore relatively dry.

"A good result depends of course on the conditions at that specific customer, but it still shows the improved screening process," says Andreas Persson, product manager of wheel mobile units, Sandvik Mining and Construction.

The feed station can easily be removed making it is possible to feed the material directly into the crusher. The conveyors are equipped with a robust drive, including external motors and angle gears.

The working conditions around the UH421 are improved thanks to Sandvik's low-noise screening media, leading to high separation efficiency and long service life. In addition, the conveyors are equipped with dust encapsulation and dust filter reducing dust emissions to a minimum.

The crusher in the UH421 is the electrically powered CH440, featuring high capacity, high reduction, low manganese wear and large feed acceptance capacity. Furthermore, the crushing process is continuously and automatically monitored by the intelligent automatic setting regulation system ASRi.

a brand-new and 'user-friendly' control panel provides full control of the process with continuous information on current and historical production, facilitating troubleshooting and minimizing operations disturbances.

The chassis of the crushing unit has been equipped with a third self-steering axle for flexibility during relocation, and it is designed to be registered as a towed vehicle.

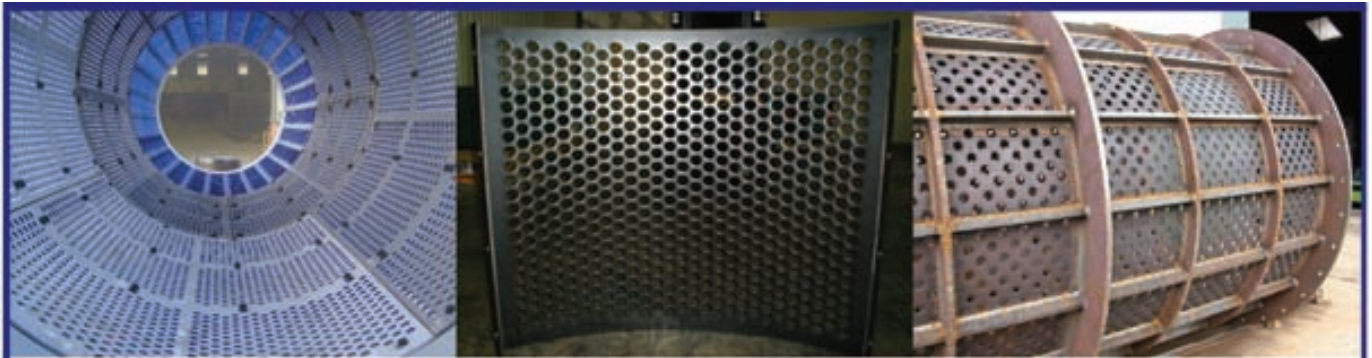
The crushing unit was designed to make registration possible, in line with Sandvik's philosophy aiming at fulfilling inspections requirements. The UH421 has been inspected by the Swedish Road Administration and the Swedish Motor Vehicle Inspection authorities.

"When our customers talk about safety, we can show that we are thinking along the same lines," says Olov Andersson, design manager and project manager for development of the Sandvik UH421.

Although road safety is the biggest reason for registration, it also makes higher speed possible during relocation.

"For some customers, speed is an advantage and translates into cheaper transportation," says Andreas Persson.





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# Mobile communications solution keeps workforce 'In Touch' at Glensanda

The Scottish Western Isles boasts Europe's largest coastal super-quarry. Located on the remote Morvern Peninsula and only accessible by sea, Glensanda brought some major challenges to its operators, Aggregate Industries. A key issue was the lack of mobile communication with key workers due to poor signal strength and outdated equipment. This was a major concern to management, not only from an operational point of view, but it also raised many health and safety issues.

Built into the hillside, Glensanda had various operational areas that all needed to be linked. It has a mile long tunnel within which is a conveyor carrying product from a primary surge pile to secondary and tertiary crushers. Inevitably, the key workers must enter the tunnel on a regular basis. Tunnels are notorious for radio transmission problems and Glensanda was no exception. With communications almost non-existent, management were concerned that the workforce could be at risk, particularly within this unique environment.

As the national preferred supplier to Aggregate Industries, In Touch was commissioned to provide an integrated mobile communications solution for the whole of site. Working closely with 2CL (the company's Motorola Main Dealer), In Touch conducted a thorough site survey and met with local management to identify the key issues.

The existing radio system was rather unusual in the fact that it was operated through a talk through repeater station based on an island in the middle of Loch Linnhe. Initially this worked fine, however as the quarry increased in size communications began to deteriorate, despite the installation of additional equipment in the extraction area. Radio coverage in the tunnel had always been problematic and as such, it was the main driver in implementing the new system to improve health and safety on site.

The challenge given to In Touch was to provide radio communications for the tunnel and throughout the whole of the quarry. Giving utmost priority to communications performance and reliability, In Touch's technicians recommended the installation of two talk-through base stations, using directional aerials and linked together by land line and microwave links with the rest of the site to provide a total communications solution.

The remoteness of the site and importance of communications highlighted the need for a robust and reliable system, which would be resilient to harsh conditions. This was factored in when designing and building the system and battery back up was installed throughout, enabling the system to continue operating for up to 5 hours if a power interruption occurred. As an added safety feature, should part of the system fail, then a fallback mode of stand alone repeaters would become operational.



At the tunnel, the workforce were provided with radios, which scan between the tunnel frequencies and the external frequency, greatly improving site safety and allowing instant and clear communication with management and co-workers.

In Touch was also able to assist in obtaining all the relevant licences from OFCOM, which included both duplex and simplex channels required to support the communications systems on site.

David Lamb, deputy works manager for Yeoman Glensanda comments: "Lack of good radio coverage in some key areas of the quarry had been a safety concern for some time but finding a workable solution has not been an easy path. Once again In Touch and 2CL have proved they have both technical knowledge and creativity to come up with solutions that are practicable and affordable."

John Walden, managing director for In Touch adds: "Site safety has to be of paramount importance in the quarrying industry and we are very proud to have provided a greatly improved communications system for the workforce and management at Glensanda."



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## Secure refuelling, made simple for Mountsorrell Quarry

**Lafarge Aggregates (Mountsorrell Quarry) has used Liquid Management Solutions (LMS) to install future proof radio frequency identification (RFid) fuel management equipment.**

The LMS RF solution was chosen for its existing operational pedigree within some of the world's largest quarries and mines, particularly its design to work on a mobile fuel bowser application. The RF based solution has been specifically designed to provide user simplicity, excellent security and robust reliability suiting this harsh environment.



A fast fill nozzle

Quarry management wanted guidance on ways to introduce fuel management 'best practice' reviewing everything from fuel stock holding, wet stock reconciliation, speed of refuelling and overall security of this 'liquid gold' commodity.

In combination, LMS will also look after the refuelling activities of Lafarge's busy

railhead facilities some 2 miles away from Mountsorrell quarry. Linking high-speed refuelling with RF tags installed on all of the trains and plant will provide an accurate speedy refuelling process.

"Our objective from the outset was to help Lafarge Aggregates accurately account for every drop of fuel being dispensed within the quarry and railhead facilities. The strategy is to manage the complete fuel supply chain from the point of delivery to dispensing activity in 'real-time' says Kevin Taylor, managing director of LMS.

LMS is also providing an outsourced data management service feeding back regular fuel statistics to the Mountsorrell's quarry management.



[www.hub-4.com/directory/7148](http://www.hub-4.com/directory/7148)

## New asphalt screen for Hanson Aggregates in Runcorn

**Hanson Aggregates' operation at Runcorn has recently been upgraded with a new replacement asphalt screen. The new screen, supplied by Finedoor, replaces an old 5 x 1.8 m unit that was located within a Telemat asphalt plant on the site.**

Finedoor supplied a 5 x 1.8 m, four and two half deck screen inclined at 10.5°, which was fitted into an existing structure. The new screen features pumped oil lubrication, which was fitted in a tamper proof box and included an additional back-up pump with rapid change-over fittings.

The screen is constructed of 10 mm thick rigid side plates with heavy-duty bolted-in deck frames and features twin overhead alloy steel shafts with two self-aligning spherical roller bearings per shaft. Designed for end tensioned woven wire screen media, the screen is driven by twin 15 Kw motors complete with vee-belt drives all mounted on a spring loaded motor base.

The pumped oil lubrication system, which is mounted at ground level, incorporates a 200 litre capacity oil tank and twin heater elements. All oil is retained in the tank, which is located adjacent to the main mixing tower from which piping delivers oil and returned oil to and from the tank. Filtered oil is pumped continuously into each bearing, and is continuously drained from the screen centre tube and pumped back to the main storage tank. All the returned oil is filtered prior to entering the storage tank. The oil absorbs heat as it passes through the bearings; this heat is then dissipated in the tank, but will accumulate.



To obtain optimum operating temperature of 60-70°C, an automatic air blast oil cooler circulates oil in the storage tank, again with oil filtration.

The oil used is EP68, much lower viscosity; it can be mineral, not synthetic and requires an annual change.



The use of RAP materials, does not affect the operation of the system, as the oil absorbs heat, and cools the bearings as it passes through, and any excess heat is removed by the air blast cooler. Servicing at Runcorn is carried

out at ground level, and only requires occasional visual inspection of oil pipes and general mechanical items.

Finedoor supplied a unit which has a storage tank, air blast cooler, filters, oil pump, electrical control panel, oil temperature and oil pressure monitoring; all of which can be viewed at ground level, and via multi-core cable, information can be made available to warn operators of either low level oil, low oil pressure, or non flow of oil.

After subsequent site visits the screen was manufactured and with the pumped oil unit was fully tested at the works. It was then installed, tested and commissioned at the Runcorn site by Finedoor engineers within the prescribed time frame.

"After many years of screen problems at Runcorn Asphalt Plant, Finedoor were asked to install a new screen & oil system with the facility of pumped oil lubrication," says site manager, Chris Ashley. "The oil pumped lubrication system is an excellent upgrade to the previous oil tubes, as the oil is always at the correct operating temperature and far easier to check & maintain. Since the screen has been installed there have been no mechanical issues with a good after service care from the Finedoor team."



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Fuelled up equipment at Mountsorrell's quarry face



# New Aggregate Wash Plant for Grundon at Kennethholme Quarry.

DUO (Europe) has recently installed a new aggregate wash plant for Grundon at their Kennethholme Quarry.

The prime objective of the new wash plant is to process 'as-dug' material in a replacement for the existing Grundon operation at the nearby Padworth Quarry where mineral processing will soon cease.

Kennethholme has over 10 years of reserves of a flint based sand and gravel. The new plant site was originally an old paper mill works. Some of the old infrastructure has proved useful for the new plant installation, with the old water treatment system being brought into service for water storage and an old concrete structure utilised as a supporting wall for the hopper feed ramp.

Founded as a minerals company by Steven Grundon in 1929, Grundon is now the largest privately owned waste management group in the UK. As a family owned company, Grundon is well respected nationally for its professionalism and is acknowledged to be in the vanguard of waste management practice and innovation.

## **Production process.**

After site survey and consultations DUO (Europe) supplied a plant capable of processing material at 150 tph, producing the required products of sharp sand, 10mm, 20mm, 40mm and +40mm oversize.

Material is fed via either dumptruck or loading shovel into a 30 ton capacity feed hopper which is fitted with a remote control tipping grid (4" grid spacing) and variable speed drag out belt. All +125mm oversize material is rejected to ground whilst the -125mm material is fed onto a 24 metre long inclined troughed belt feed conveyor.

From here the -125mm material is fed onto a 16 x 5 double deck rinsing screen. Any material greater than 40mm is rejected and sent to stockpile via a conveyor; whilst all -40mm material is fed to a Powerscreen Logwasher. Featuring twin shafts with interchangeable high tensile blades, a built in agitation system excites smaller particles causing them to float and in turn discharge via the water exits. The Powerscrub is fitted with an elevated spray bar which constantly adds water which washes the material and encourages lighter particles to float through the water exit.

Material then passes over an 8 x 4 dewatering screen fitted with polyurethane modules and is then conveyed via a 20 metre transfer conveyor to a 12 x 5 double deck dry screen. This dry screen grades the material into three sizes of 10mm, 20mm, and 40mm which are conveyed and stocked by three further 20 metre long stockpile conveyors.



All waste water from the Powerscrub is then sent over a 6 x 2 dewatering trash screen fitted with polyurethane modules where all foreign materials are removed from the system and fed into a skip, with the water and sand gravity flowing into an adjacent Powerscreen Finesmaster.



The Fines Master 120 compact sand plant incorporates a rubber lined Linatex cyclone with fixed spigot and a rubber lined Linatex centrifugal pump. The system has a self regulating collection sump with built in float system. The underflow from the cyclone is discharged onto a high frequency dewatering screen fitted with polyurethane modules and adjustable vibrating motors. The dewatered sand from the Fines Master is then delivered to stockpile via a radial sand conveyor. The waste water from the sand classification unit is then pumped into a nearby lagoon.



Ken Branigan, Aggregates General Manager commenting on the project said,

“Duo installed the plant in a very efficient and professional manner, paying specific attention to Health and Safety. I would have no problem recommending Duo and their products to anyone”

“At Grundon, we currently operate eight quarries across Southern England - producing a wide range of products for a wide variety of customers. Our core aggregate business is the supply of sands and aggregates to the building, construction, landscaping, decorative, and leisure markets”.

“We offer a unique "open door" policy as we actively encourage the general public, smaller builders, landscapers and DIY enthusiasts to come along and purchase directly from our quarry weighbridge offices – no matter how little product is required”.

“With our huge emphasis on customer care and our commitment to high standards, we are energetically committed to minimising the environmental impact of all our operations and services. Our commitment to quality of service and technological progress is allied to a real and demonstrable concern for the environment”.





# Vehicle theft indifference?

**Markets are 'Institutionally indifferent' to equipment theft, according to a report by TER.**

In its 2008 Equipment Theft Report, The National Plant & Equipment Register (TER) says that all parties involved with construction, demolition, quarrying and agricultural equipment are 'institutionally indifferent' to the theft of equipment, which runs at more than £1 million a week (source: Home Office) in the UK alone.

"It cannot be right that highly valuable machines like excavators and telescopic handlers can be started by a universal key and have no immobiliser, that most places where equipment is used have the security of a wet paper bag, that auctions, dealers and banks don't check to see if they are trading in stolen equipment, and that insurers have no idea what equipment they are insuring," said Tim Purbrick, manager of TER. "At present there is a vicious circle of reasons why this institutional indifference continues and in this year's report we recommend how to turn it from a vicious into a virtuous circle."

Among its findings, the report reveals that:

- Equipment theft in the UK rose by 2% in 2007 to 3,630 higher value equipment thefts
- The value of equipment stolen in 2007 rose by 11% to £36.6M
- The average value of each theft in 2007 was £10,100
- Excavators were the highest theft value category at £12.1M or 33% of all UK equipment theft by value
- Excavator theft rose 20% in 2007 to 740 machines. Thames Valley had the highest level of excavator theft
- Telescopic handlers had the highest annual increase in theft rising 76% to 184 machines or 5% of all UK equipment theft. Thames Valley had the highest level of equipment theft
- The south east of the UK remains the worst area for equipment theft headed by Thames Valley, Kent, Surrey, London and Hampshire
- The highest value theft in 2007 was a £140,000 Extec C10 crusher stolen from Essex on 6th January 2007
- Equipment crime is committed by opportunists, serious organised criminals, some of whom have links to terrorism, and fraudsters
- Equipment criminals use a range of techniques to change the identities of stolen equipment before they sell it on, in the same way that car thieves 'clone' stolen vehicles, in order to dupe purchasers, dealers and auctions
- Used equipment is much in demand globally so in addition to circulating in the UK stolen equipment is also exported to countries such as France, Holland, Poland, Lithuania, Cyprus, Israel and Australia
- Only 5% of stolen equipment is ever recovered. 10% of TER's stolen equipment recoveries in 2007 were made overseas in Cyprus, Lithuania, France and Holland
- More than 600,000 owned items of equipment are registered with TER with a value in excess of £3 billion
- More than 55,000 equipment thefts have been registered with TER with a value in excess of £250 million.

## Op Crassus

Operation Crassus was a national police operation that ran over two weeks during April and May 2008 to identify stolen plant and equipment moving around the national roads network. Over £60,000 worth of stolen plant was recovered by TER as a direct result.

More than 750 roadside spot checks of equipment were made by traffic police and ports authorities using TER's services during the UK-wide

purge. Among 14 items of stolen equipment seized were five excavators, five trailers and two tractors, with one excavator still awaiting formal identification.

The plant was recovered in Staffordshire, South Yorkshire, South Wales, West Midlands, Lothian & Borders, Derbyshire, West Yorkshire and West Mercia on behalf of insurers Norwich Union, Zurich, NFU Mutual and AXA.

We received 445 calls from 37 different police forces during the two-week crack down. Every single police force and port authority in the country was involved in the operation, but the bulk of checks came from Staffordshire, South Yorkshire, West Mercia, Mersyside, West Midlands, West Yorkshire and Humberside, with recoveries resulting for eight forces.

TER provided on-site and over the phone technical assistance to the police 24 hours a day throughout the operation. It also sent out more than 5,000 TER Plant & Equipment Identification guides in the month before the crackdown, adding to the 30,000 already in circulation with the police, as well as providing briefings to roads policing, commercial vehicle crime, ports and other police officers and units.

"It is too long that the criminals have had their own way and Op Crassus was put in place to redress the balance," said PC Paul Ennis of the West Midlands Police Force Traffic Unit who instigated Op Crassus across all UK police forces. "We're very grateful to TER for contribution of their personnel, their data, knowledge and expertise."

## 4 tonnes missing

One September morning last year the Lancashire Police Search Team at Heysham Dock contacted TER requesting assistance with the identification of a 26 tonne JCB excavator, which was destined for Cork in the Republic of Ireland. The driver - from a well known haulage company - had collected the excavator from an industrial park in Buxton in Derbyshire. The Lancashire officers decided to investigate further.

On being informed of the serial number from the plate fixed to the JCB's chassis the TER operator was immediately able to identify that the plate referred to a 22 tonne excavator and not to the 26 tonne excavator at Heysham - 4 tonnes had gone missing somewhere. It subsequently transpired that the plate on the Heysham JCB had been stolen from another JCB excavator, which was still in a dealer's yard in Telford in Shropshire. On directing the officers to other identification data on the excavator an immediate match was made with an excavator, which had been stolen from Sleaford in Lincolnshire on 2nd August shortly before its export to the Netherlands. The theft had been reported to TER but was not logged on the Police National Computer.

The excavator was recovered back to Rocester by JCB itself. Subsequent investigation revealed that the collection address in Buxton was not a bona fide address for the company which had requested the excavator's haulage to Cork, and that they had also provided a false company name. The insurer was Norwich Union. A JCB 802 mini-excavator remains outstanding as stolen from the original theft.

In addition to the recovery of a stolen £75,000 excavator, the police were able to gather some useful intelligence from this recovery.

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Photo © TER

JCB JS260 Excavator, valued at £75,000, stolen in Lincolnshire on its way to the JCB dealer in The Netherlands and recovered by the Lancashire Police using TER's assistance in Heysham Dock en route to Ireland just one month later with a new identity plate stolen from a machine in JCB's dealer in Shropshire. The call for assistance came to TER at 0730. The machine was not listed as stolen on the police national computer but registered with TER by JCB. The insurers were Norwich Union.





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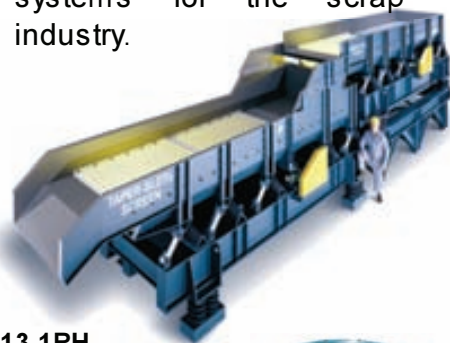
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# Dust in the Workplace – An Explosive Topic

**Graham Doran discusses how companies can reduce the risk of dust explosions occurring in the workplace and the current standards relating to explosion-proof electrical equipment installed in these areas.**



**The risk of a dust explosion occurring in the workplace is not as remote a possibility as people might think. A dust explosion requires only three things: air, combustible dust and a source of ignition such as an electrical spark or hot surface.**

Indeed, many companies are potentially at risk here. Why? Because combustible dusts are present in many process manufacturing environments. Wood shavings, carbon dust, flour, custard powder, sugar, coffee, tea and aluminium dust are just some examples of highly combustible dusts. The problem is when these combustible dusts are left to gather on hot surfaces in a workplace, such as on an overheated electric motor or fan. This can cause smouldering fires to occur, or can cause an explosion when the dust is kicked up, for example, by a person opening a nearby window.

Dust explosions can have catastrophic consequences because the initial shock wave resulting from the explosion kicks up more dust, which triggers a chain reaction through the plant, often resulting in mass destruction of equipment and buildings, as well as causing possible death or injury to employees.

Therefore, as potential sources of ignition, all electrical equipment installed in these areas, including mixers, filling hoppers, conveyor systems, mills, silos, dust extraction plant, kilns and drying systems, need to be adequately protected and designed to operate under these conditions. Directors, company owners, plant managers and maintenance engineers, in fact anyone who is responsible for the health and safety of employees or for sourcing electrical equipment for hazardous areas – needs to be fully aware of the risks of dust explosions, the European Directives and

standards relating to electrical equipment installed in hazardous areas and the measures that can be taken to eliminate the risk of dust explosions occurring.

## New standards

Owners of new equipment are governed by the compulsory European Directive 1999/92/EC, implemented in the UK as the 'Dangerous Substances and Explosive Atmospheres Regulations 2002' (DSEAR). From 2006, this directive also includes 'old' as well as 'new' equipment. In summary, owners are required to identify the risks of explosion; implement explosion protection measures such as avoiding sources of ignition (secondary explosion protection); define zones in areas at risk from dust explosions; create an explosion protection document; use suitable production equipment; and to create a test plan.

For electrical equipment in areas at risk from dust explosions, a new series of standards, EN61241 was introduced. This stricter standard came into effect from the 1 October 2008, which supersedes the existing standard EN 50 281. Within this new series of standards, one of the main protection types for production equipment at risk from dust explosions in accordance with ATEX Directive 94/9/EC, is the protection by enclosures type 'tD'.

This protection type is where the electrical production equipment is equipped with an enclosure to prevent dust penetration and where measures have been taken to limit the surface temperature have been implemented.

The main changes to this standard concern the following areas: impact energy – high demand on impact energy as in Zone 1; electrostatics – electrostatic conductance of the enclosure; and ageing resistance –

high demand on the ageing resistance of the plastic enclosure. Owners need to be aware of these changes when sourcing or upgrading electrical equipment for hazardous dust areas.

Hazardous areas for explosive dust atmospheres are classified into three Zones: 20, 21 and 22.

- Zone 20 is an area in which an explosive atmosphere in the form of a cloud of combustible dust in the air is present continuously, or for long periods or frequently
- Zone 21 is an area in which an explosive atmosphere in the form of a cloud of combustible dust in the air is likely to occur in normal operation occasionally
- Zone 22 is an area in which an explosive atmosphere in the form of a cloud made up of combustible dust in the air is not likely to occur in normal operation but, if it does occur, will persist for a short period only.

In addition, on the 6 April 2008, the Corporate Manslaughter and Corporate Homicide Act 2007 came into force in the UK, which means companies cannot afford to cut corners or delay the implementation of appropriately protected electrical equipment. If they do, these firms could face severe fines or even imprisonment should a dust explosion occur.

## 2000 dust explosions every year

The statistics show that companies need to act now without delay. A staggering 2000 dust explosions occur in Europe every year and all types of companies are affected, including manufacturers of sugar, coal, cocoa, flour-based products, milk powder, tea, grain, fodder and tobacco, as well as wood and metal processing companies.

One recent example of how costly – ►



both in terms of lives lost and damage to plant – dust explosions can be, occurred in February 2008 at the Dixie Crystal Refinery, part of the Imperial Sugar Company and one of the leading sugar manufacturers in the USA. A massive sugar dust explosion killed at least six people and injured more than 60, some seriously, who had to be rushed by helicopter 125 miles away to a special hospital for burns victims. The sugar silos of the filling plant had exploded during the night shift, setting fire to most of the plant. This is just one of many dust explosions that occur around the world. It is estimated that more than 300 dust explosions in grain silos, sugar plants and food companies in the last 30 years in the US alone have cost the lives of more than 120 people.

#### When can dust explode?

A dust explosion requires three ingredients: air, combustible dust and a source of ignition. Combustible dust-air mixtures have different ignition temperatures. The surface temperature of the equipment in areas where there is a risk of dust explosions is allowed to reach two-thirds of the minimum ignition temperature of the surrounding dust-air mixture. With a 5 mm thick layer of dust, this surface temperature must be at least 75°K below the minimum ignition temperature of the dust (glow temperature).

It is therefore the equipment owner's responsibility to ensure that the cleaning and maintenance intervals of installed equipment with a dust explosion risk are scheduled so that no dust layers thicker than 5 mm are allowed to form. At higher dust

deposits, the minimum ignition (glow) temperature of the dust is reduced significantly.

The goal of the current European Directives is to protect operating plants from dust explosions and to prevent damage or personal injury. The explosion protection measures are divided into 'Owner' and 'Manufacturer' Directives. Again, the objective is to implement all necessary measures to ensure that explosion-protected products can only be operated if they do not pose any danger to health and safety and provided that they are correctly assembled, installed, maintained and used for their intended purpose.

#### Footnote:

*Graham Doran is sales & marketing director at Cooper Crouse-Hinds (UK).*

## Down flow and down draft extraction booths order

**Flextraction has recently designed, built and delivered a downdraft extraction booth and a down flow extraction booth to a German manufacturer of wet grinding, mixing and kneading products used in the manufacture of inks, paints, plastics, chemicals, ceramics and minerals.**

The 2 m Downdraft extraction booth is designed to control fumes created during liquid solvents dispensing and the 2 m Downflow extraction booth is designed to control dust during the weighing of glass powders. Both booths are fabricated from 304 stainless steel sheet and meet CoSHH legislation requirements.

The Downflow booth is a one-piece design with the fan enclosure being acoustically lined to reduce noise levels. The air is collected at low level and filtered through 3-stage primary, roughing and secondary bag filters and then finally through HEPA filters providing 99.95% filtration efficiency. The filtered air is discharged above the operator's head with an evenly distributed down flow of 0.5 m/second. This system provides a continuous down flow to suppress dust below the operator's breathing zone into the extraction area.

The extraction performance of the booth is monitored through pressure indicating devices and automatic control of the variable speed fans.

The Downdraft booth provides a laminar airflow with fumes being filtered through a F7 category primary filter and a carbon filter. Extraction is through a rear mounted 7.5 kW centrifugal fan discharging back into the room where this booth is located. The fan starter is located on the booth control panel removing the need for any special on-site wiring.



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## Lightweight Advanced Carrying System (ACSi) for SCBA



Scott Health & Safety has launched the Advanced Carrying System (ACSi), which has been designed specifically as a Class 1, SCBA (Self-Contained Breathing Apparatus) carrying systems combined with the highest standards of performance for use in industrial environments.

Weighing in at only 2.15 kg, the ACSi is significantly lighter than any other carrying system in its class and is the first system in the world to incorporate ThermoFlex technology to create a sculptured soft back plate that aids comfort, ease of movement and contributes to reducing wearer fatigue. The soft back plate is designed and moulded to fit the spine and back muscles and was developed following research with osteopaths, fabric and industrial technologists.

The harness has fully adjustable padded shoulder straps and waistband, which is fitted with a quick release buckle. D Rings allow fast and easy connection of other equipment to the webbing or straps.



# Taking safety to a new dimension

**Global coupler manufacturer Miller and Flannery Plant Hire, one of the largest plant hire suppliers in and around the South East have joined forces in an attempt to improve on-site safety awareness. Ross Matthews attended one of the open days organised by the companies at Flannery's site in Wembley to focus on safety on job sites and to demonstrate the latest in fully automatic quick coupler technology.**

**Some 400 visitors, including representatives of the Health & Safety Executive, attended a joint open day hosted by Miller and Flannery Plant Hire, one of the largest hire suppliers in and around South East. The event held at Flannery's headquarters, located in the shadow of Wembley Stadium, focused on safety and allowed Miller to demonstrate its latest fully automatic quick coupler development - the TwinLock II.**

Flannery lined up a fleet of CAT machines, each with a luminous green Twinlock coupler, which had been developed for the company and is now Miller is making it available for other OEMs.

Flannery first approached Miller last year with the intention to replace its entire fleet with fully automatic quick couplers. Having carried out detailed research into the existing coupler options available to them at that time, Flannery decided that there wasn't a coupler on the market that fully met their specific requirements.

"We spoke to Miller initially as we wanted to fit our fleet with fully automatic hitches that would offer additional protection if the back pin was not correctly engage during attachment," says Martin Flannery.

Miller began to work on a new design to offer the best solution. The fully automatic TwinLock II coupler is based on a proven design, used by many leading OEMs, which has evolved to keep up with the demands of modern working job sites.

Gary Miller, technical director at Miller says: "Our continuous improvement design philosophy allows us to push the boundaries of coupler design technology whilst still retaining functionality and versatility from existing products that we know work well and our customers endorse".

The Twinlock II is fitted with an Automatic Blocking System (ABS), which is designed to automatically capture the front pin in the event that the rear attachment pin is not correctly engaged during the attachment process. It is also designed to only release a bucket or attachment when the operator intends to do so and in a safe and controlled manner. In other words it is designed not to drop a bucket or attachment by accident or through operator misuse.

Part of the overall design process includes significant testing of the coupler in all anticipated accidental and misuse situations before the product is launched into the market place. This includes FMEA and FEA analysis,

destruction testing and field trials, which Flannery has been involved in and provided valuable feedback.

"We have worked very closely with Miller throughout the design process of the TwinLock II and are extremely happy with the end result," says Martin Flannery. "I believe it is a very important advancement in quick-hitch coupler safety and I am very proud to have been involved in the design process".

Flannery continues to invest heavily in new machinery to provide their customers the latest in machine technology from the leading brands, which in turn creates a safer working environment. They are investing a huge sum in changing many of their hitches to the new Miller Twin Lock II coupler system.

## Developing couplers

Steve Ford, business manager – compact division at Miller showed HUB round the display of Miller products at the Open Day to explain the issues surrounding coupler safety. The first coupler Miller offered was a semi-automatic coupler - a hydraulically operated unit connected to pins. Safety pins lock the coupler onto the attachment. "But operators don't always lock the safety pin, so you are just relying on hydraulic pressure to hold the attachment because the safety pin is not installed properly," says Steve. "If anything happens, for example you don't pick up the attachment properly, or something happens on site then the attachment can drop off because you haven't got the mechanical safety device in place. H&S executive & legislation EN474 – the criteria for hydraulic couplers says the coupler must have an independent mechanical safety mechanism that always locks the coupler onto the attachment. A mechanical safety mechanism that holds the coupler in place will remove the risk associated with the hydraulics being released by, for example, a burst hydraulic pipe or an operator inadvertently catching the switch".

The Semi-automatic coupler cannot now be sold in the UK and legislation is also likely to take it out of the European market also. Miller however offers a range of couplers that conforms to current Health & Safety regulations for use in the UK. "It's down to customer choice," says Steve. Pointing out a mechanical coupler with a locking pin that can be used in the UK, he says: "With this operator has to get out of the cab to connect the attachment to the coupler, in which case he can put the safety pin in place and is suitable for smaller machines where you don't want pay for a hydraulic coupler." ►





Inspecting the new coupler

## Fully automatic quick coupling

The Twinlock II is a fully automatic, universal quick coupler, which complies fully with the EN 474 standard. The unit is designed to only release a bucket attachment when the operator intends to do so, in a controlled and safe way. The Automatic Blocking System (ABS) is a mechanical back-up safety system, which has been designed to automatically secure both front and rear attachment pins in the event that engagement forces are lost. In the event of operator error or misuse, and the rear attachment pin is not correctly engaged during the attach process; the ABS automatically secures the front attachment pin. The front edge of the wedge, painted red, lets the operator know of a potentially hazardous situation so that it can be rectified.



The Twinlock II with ABS locks both pins.

Further up the range comes the hydraulic Bug Coupler, which Miller supplies to numerous OEM customers, such as CAT and Komatsu. This coupler allows a machine driver to pick up a range of buckets from different manufacturers without having to leave the cab. It uses a locking pin and locking bar. "When you pick up an attachment this bar will locate into slots to provide a mechanical lock," says Steve, "If for any reason the hydraulic lock fails or the operator plays around with the switch, it is locked in place.

The Twinlock II is a further development of the Bug. Demonstrating the difference to HUB, Steve explains: "This coupler has a blocking bar but in addition it has what we call a 'front latch', and we've called this ABS. As the front latch comes down, you actually have a mechanical lock on both pins, and it also serves as an indicator to the operator who can see (as the latch is painted red) that it is locked."

When the coupler connects on the rear pin and the driver extends the ram to pick up that pin, as soon as the ram is extended, the latch locks the front pin in place and that proves that there is a lock on the front pin as well as the rear pin so it is double safe.

Steve adds that the system is a foolproof method, which is important, as you can't always rely on drivers to operator quick couplers properly. "When they pick up on the front pin sometimes they miss the rear pin and they don't check it," he says. Miller provides an operating guide, which Steve says operators should read. "Once you connect the attachment if you do a small bump test on the ground, if the attachment or bucket is not connected properly it will roll off and you can see it has rolled off before it causes any damage.

"Flannery's wanted us to develop something that satisfied their requirements so we developed this product. It's a very good coupler that can now be used on any equipment," says Steve. At the moment the coupling is available for 13 tonnes upwards but within next 6 months Miller will have a range available from 3.5 tonnes to 85 tonnes and more. Being cast steel as opposed to being fabricate gives it more strength.

The ABS adds a 10-15% price premium over current couplers, but as Garry Miller points out: "What price safety? If this enhancement is going to save lives and make an operation safer and foolproof you can't measure the cost." He adds: "Safety in the industry is top priority as far as we are concerned and we continually strive to make our products safer. It's a very price sensitive world as we know but price is secondary to safety - how much is somebody's life worth? If the going rate is about £1500 but our super safe product is £2100, then it is a 'no brainer'."

Steve adds that Miller can offer a retrofitting opportunity. "We can inspect a customer's old couplers to let them know if it meets legislation. We will inspect it again in 6-12 months time. Secondly, we are also offering a new for old campaign so if the customer has a coupler that is quite old and doesn't meet legislation we will buy that off them and give them a new coupler as part exchange."



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## Mogensen exceeds expectations in Chile

Mogensen supplied a 3 m wide, five-deck Sizer and a matching vibratory spreader feeder to the SCM Carolo-Cerrillos copper mine near Copiapó in Northern Chile in the early autumn of 2008. The aim was to install the Mogensen equipment in close circuit with a Barmac XD120 crusher in the hope of achieving an increased output of feed for supply to a customer's smelter, located some 8 km away, and a reduction in the total power consumption of the plant.

After 260 hours of commissioning and test running it has been established that the Sizer can consistently extract 280 tph of -4mm fines within the required specification from the incoming feed compared with the 200tph quoted initially. The combination of the probability screening principle of the Mogensen Sizer and the rock-on-rock crushing action of the Barmac unit has, as hoped, resulted in significant improvements in plant efficiency.

With the introduction of this equipment the plant is now producing sufficient within-specification material to enable the management to operate the plant with only two of the originally used eight grinding mills, which previously processed the incoming feed without pre-screening. The two remaining mills are achieving a 30% improvement in output with no increase in power consumption, because of the enhanced grading of the feed presented to them. A further benefit is that, with six mills in reserve at any given time, maintenance can be more efficiently planned.

It is reported that the most optimistic hopes of increasing the plant capacity, whilst at the same time reducing total power consumption, have been comfortably exceeded.





# New hot asphalt storage system for Lafarge Ackworth

**A FMA Ullrich Hot Asphalt storage system at the Lafarge Ackworth Depot in West Yorkshire by BG Europa. A four compartment S200/4 II with a total storage capacity of 200 tons split 2 x 47 tonnes and 2 x 53 tonnes has been installed on the Parker Starmix Batch Plant**

The FMA Ullrich type S parallel silo structure comprises four bins arranged in a cluster with all discharging to a single truck loading point. This configuration allows the accurate discharge of all four bins into one truckway, either over a single weighbridge or, as at Ackworth, through the load cell mounted silo structure.

The bottom discharge skip has a capacity of 2000 kg and is lined with stainless steel to promote clean operation. The skip system can operate at 160 tph with a 45 second cycle time to the furthest bin ensuring that maximum production output is maintained.

The FMA Ullrich UCC5 skip controls feature an energy saving mode which matches skip performance to batch plant output. Basically this means that the speed of the skip is automatically controlled to ensure that it returns to the mixer at the time required for batch discharge, thus eliminating excessive power usage by unnecessarily accelerating the skip.

It was imperative that the project was completed during a programmed shutdown period, which immediately preceded a major road project (M180) for the depot. BG Europa ensured full plant operation was achieved on the programmed date to meet production requirements and with minimal disruption to the established Lafarge customer base.

"The installation and commissioning of the hot storage system was delivered within the time frame set." Mick Speed, Cluster production manager of Lafarge "BG Europa's installation crew are to be applauded for their dedicated attitude to "on site" safety. They embraced Lafarge's Safety Culture and completed the task without any incidents.

The range of FMA Ullrich Hot Asphalt stationary hot-mix storage systems allow customers to store asphalt either to expediently fulfil orders, temporarily store material when weather conditions prevent paving or to provide collect trade with rapid turn around.

Automatic skip-systems feature frequency controlled gear motors giving precise control of skip speed and positioning. This total control of the skip allows it to be smoothly accelerated along the track and then slowed as it approaches the required station thus greatly reducing stresses on the winch and rope system.

Skips feature a rounded back and full length sliding bottom gate ensuring clean discharge. Optional stainless steel or Hardox skip liners and an automatic skip spray system can be installed to ensure the system is specified to handle all types of bituminous products.

Load out systems can either feature load cell or weighbridge weighing, giving accurately controlled and rapid vehicle loading. Silos are available in either square or round construction in a range of designs.

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## New lightweight conveyor canopies



**Canning Conveyor has added MWPS (Multi-Wall Polycarbonate Sheets) conveyor canopies to its product portfolio. Used for covering all types of belt conveyors in all industries, including waste and recycling, the canopies are available within a short time frame.**

The units are a lightweight, cost effective alternative to steel and can be supplied in either transparent or a choice of coloured tinted sheeting.

Designed to offer easy access for maintenance they include a 10 year warranty against UV rays and all weather conditions.

The range comprises all belt widths and includes fittings for self installation or they can be installed by Canning engineers at an additional cost.

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# Customisation the Key for Lafarge

Lafarge are enjoying increased efficiencies at their Brooksby quarry following the introduction of a turnkey 180tph sand and gravel washing plant from Northern Ireland company, CDE Ireland.

**The plant has recently completed final commissioning and initial tests on the final products show a considerable improvement in quality when compared to the previous processing system being used at the site.**

Brooksby quarry is located near Melton Mowbray in Leicestershire and is a relatively new addition to the Lafarge portfolio having opened for business in 2007. The company has a licence to extract 300,000 tons of sand and gravel at the site, which at current capacity will allow for fifteen years production. The site will be progressively restored as extraction progresses to become agricultural land and a complex of lakes.

The sustainability agenda is one that Lafarge take very seriously, as can be seen by their membership of seventeen wildlife trusts in the UK alone. While Lafarge are rightly recognised as one of the most prominent names in the global construction materials market, their work in the UK is characterised by a commitment to local community groups and initiatives.

"We rely on the local communities we serve in many ways" explains Andy Morris, National Production Manager in the UK with Lafarge. "Lafarge Aggregates have over 200 sites throughout the UK and the vast majority of these operations are managed on a day to day basis by people from the local area."

In addition to the 200 sites operated by Lafarge Aggregates in the UK, the Lafarge group also operate 30 recycling centres processing a variety of materials including used rail ballast, concrete, asphalt, bricks and other demolition wastes.

## A new solution

Lafarge opened discussions with CDE about a new washing plant at Brooksby in late 2007 as a result of difficulties being experienced in processing the natural sand and gravel at the site. "The presence of clay in the raw feed was proving to be a problem with our previous processing system and this was having a significant impact on the quality and commercial value of our final products" says Andy Morris.

A key factor in the selection of CDE to provide the solution to this problem was the customisation of the plant to the specific characteristics of the feed material. "We had gone down the off the shelf route before and it had not been successful" explains quarry manager at Brooksby, Will Laycock. "We set very high standards in relation to final product quality and these standards dictated that we



sought to address the issues raised by the level of clay in the feed material."

Tackling this issue began with detailed materials testing at CDE's laboratory in Cookstown. A substantial quantity of material was analysed in order to gain a clear picture of the typical grading the plant would be required to process. Once this had been determined CDE's technical design engineers began to build the plant in order to produce the final products required by Lafarge – in this instance three aggregates and two sands (coarse and fine).

Lafarge were able to provide CDE with detailed information on the grading of the final products that were required and from this the constituent parts of the plant were adapted to produce the required results. "Lafarge had a very clear idea of where they wanted to go and this helped enormously when we worked on the plant configuration" explains CDE's general manager in the UK, Terry Ashby.

Given previous experience at the site Lafarge were also keen to include a number of performance guarantees with the order for the new washing plant. These covered gradings for all the final products and the lagoon water, as well as the final moisture content of the sand products. "The introduction of the performance guarantees on the plant was a critical factor for us in order to ensure that this considerable investment delivered the required results" says Andy Morris. "We were very impressed with CDE's willingness to work with us on these guarantees. It demonstrated a level of







confidence in their capability that is not the norm in our experience."

A key factor for CDE in accepting the performance guarantees requested by Lafarge was the level and clarity of information made available to them prior to the deal being done. "With access to the amount of information provided by Lafarge we were able to produce a large amount of data outlining what our plant would achieve" explains Dermot Murphy of CDE's technical specification team. "Over the last seventeen years we have continually analysed plant performance and made design adjustments where required. We know what our plants are capable of and this confidence allows us to enter into agreements around final product specification such as the one agreed for the Brooksby plant."

## Plant set up

The final plant configuration installed and commissioned by CDE at Brooksby quarry draws on a range of equipment from the CDE portfolio – hoppers, conveyors, ProGrade screens (both rinsing and dry sizing screens are included), the new AggMax attrition and classification system, and an A-series EvoWash sand plant.

The feed material is loaded into the feed hopper which feeds a horizontal ground conveyor. From here the material is then transferred to a 28m static feed conveyor on its way to the primary screening phase. Due to the levels of clay in the feed material the conveyor is fitted with Hosch scrapers to ensure the belts stay as clean as possible, minimising spillage and ultimately increasing plant efficiency.

"We offer a range of options to customers based on the individual requirements of the project" explains Terry Ashby. "The characteristics of the feed material are often the most significant consideration and by having a menu of options available, it ensures we can deliver high performance, high efficiency installations."

At the primary screening stage a ProGrade R211 double deck

rinsing screen is employed and is set up with two polyurethane decks. The screen measures 6mx 1.8m (20x6ft). The oversize (+40mm) material is discharged into a concrete bay beneath the screen while the -5mm material and waste water are sent to the EvoWash sand plant.

The 5mm to 40mm material is delivered directly to the new CDE AggMax system. This unit combines the RotoMax attrition system and ProGrade dewatering screens in a compact configuration that reduces the space required on site to accommodate the plant. The RotoMax system has been introduced to specifically tackle the level of clay in the feed material. The model at Brooksby, the RX100, is one of three models available from CDE, with the largest capable of handling up to 300tph. The RotoMax uses high specification components such as 118 chrome molybdenum blades, and has been designed to ensure maximum attrition of clay bound materials.

The waste water from the RotoMax is sent to the EvoWash sand plant to recover any of the -5mm material that made it past the first screening stage. Meanwhile, the scrubbed +5mm material is delivered from the RotoMax onto a ProGrade C-series dewatering screen before being sent to the dry sizing screen via a 20m static transfer conveyor. The dry sizing screen on this plant is a ProGrade D26 double deck screen measuring 4m x 1.5m (13x5ft) and once again set up with two polyurethane decks. The dry sizing screen classifies the products into 5-10mm, 10-20mm and +20mm aggregates which are transferred to stockpiles by three 20m static conveyors.

"The use of high specification components can be seen throughout the plant" says quarry manager, Will Laycock. "We had some fairly tight guidelines for CDE in terms of what we expected from the plant and

in order to achieve this it was essential that we took the quality route. CDE have demonstrated the benefits of this approach in relation to product quality and efficiency and the results being achieved speak for themselves."

At the sand washing phase an A-series EvoWash sand plant is employed and produces a coarse sand and a fine sand. The specification of each of these sand products is covered by the performance guarantees discussed previously, as is the moisture content of both final sand products.

The EvoWash sand plant has a 4mx1.8m (13x6ft) polyurethane screen deck which is split to allow for dual sand production. The slurried waste water and -5mm sand product is delivered to the sump of the sand plant where it is then pumped through the first of two 500mm cyclones. The material is then discharged onto the first side of the split screen where the aperture is set to allow the fine material to fall through to the sump with the waste water. The coarse sand product is dewatered on the screen which is powered by two 9kw high frequency vibrating motors. This ensures maximum dewatering of the sand product, ensuring it is ready for market straight from the belts.

The fine sand material is then pumped through the second of the 500mm cyclones. The -63 micron material and waste water is removed via the cyclone overflow and sent to a ground sump in close proximity to the sand plant. This material is then pumped to on site lagoons. The fine sand product is delivered to the second side of the split dewatering screen where it is dewatered to approximately 12% moisture content, once again ensuring it is ready for market straight from the belts.



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# Beating the Credit Crunch

## Used should not be abused

**Buying used equipment can in many scenarios provide a cost effective solution, particularly in the current economic climate, providing the buyer sticks to reputable sources.**

Recessionary pressures are causing companies in all sectors to drive down costs and look at procuring ever more efficient equipment solutions, particularly as the credit crunch is making capital scarce. Investing in new machinery for quarrying, recycling and bulk materials handling applications will deliver cost savings, production efficiencies and in many cases make possible what wasn't previously. The pages of this magazine are full of such solutions and applications. However, there are some users who will find a business case for using used equipment for certain applications or prolonging the life of existing equipment through rebuilding programmes. With used equipment there is the advantage of a lower initial investment capital cost and the possibility of picking up a bargain.

Michael Cumming, used equipment manager at Marubeni-Komatsu reports that the construction industry, like others, has been hit hard by the current economic climate. *"For these reasons customers are being more cautious when looking to purchase new machines and may be more attracted to low hour, tidy used equipment."* He adds: *"In uncertain economic times, there are often many low-hour, high-quality used machines on the market. With finance companies being more reluctant to lend money or if new equipment is not financially feasible, it may be more cost-effective to purchase used equipment."* When the time comes to trade in used machinery for a newer model, the customer can also gain a good residual value.

Bob Aldridge, sales and marketing manager for Bell UK also sees a place for used, refurbished and

remanufactured units. He says: *"The most suitable scenarios would be customers who have short-term requirement or contract, customers who need to increase their rental fleet at lower cost, and in jobs which have either very severe conditions such as sea defence or very light duties."*

Scenarios identified by Peter Craven, marketing and sales support manager at CDE include *"when a new process is being introduced and a used equipment installation provides a cost effective 'trial' option for the customer before deciding to proceed with a new equipment installation."*

As an example of this, in 2007 CDE supplied some used equipment to Severn Trent Water as part of a trial plant at their Minworth Sewage Treatment works. The plant processed waste from wet wells and digesters and since operation it has reduced waste to landfill volumes by over 50% while also recovering materials for use in electricity generation. Following the success of this trial plant, Severn Trent Water recently ordered a new plant for its Coleshill site, based on the success of the initial project.

*"Used equipment can also be used to provide for a solution to a temporary problem, such as the cleaning of dust stockpiles,"* Peter Craven adds pointing out that there are "obvious short term cost savings to be made if you look at the initial purchase cost of the equipment as a stand alone item". He adds: *"We believe that in more cases that not, a new equipment purchase can offer customers a more cost effective option in the long term."*

Such scenarios can also be catered for by rental contracts for equipment. The advantage of this approach over used equipment in the majority of cases is that it is possible to offer new plant to customers on a weekly / monthly rental contract.

Rental offers customers all the benefits of a new machine, while removing the burden of the initial capital investment. There are a variety of terms under which these rental contracts can be put together depending on the availability of finance in the first

instance. "We have found in a lot of cases that the rental can actually be easily covered within the maintenance budget for the operation," says Peter Craven.

A key question is the length of time that you need the equipment to work for you in order for it to be the most cost effective solution in the long term. *"If the project you are undertaking is likely to run for a considerable period of time, and you are happy with the system that you are introducing, it may be the case that a new installation provides the most cost effective option in the long term,"* Peter Craven says. *"With new plant you are obviously benefiting from extended warranty terms compared to used equipment, reduced spares costs in the initial lifetime of the plant, and increased comfort that your plant will now be in operation for a long period of time. The key message from us to all our customers is to focus on the lifetime cost of the plant, rather than the initial purchase cost."*

## Finding good used equipment

Many may be perturbed at the thought of touring the second hand dealers in search of a bargain that they hope will not turn into a money pit. Thumbing through media publications (such as HUB, of course) particularly the classified sections is one way to avoid pounding the streets, surfing the Internet and manufacturers' web sites is another. The most direct approach however would also be to go straight to source.

*"Probably the best used equipment would come out of principal dealers or manufacturers' representatives who generally have better control and a vested interest in selling good used equipment,"* says Bob Aldridge. Peter Craven also believes going direct to the supplier would be the best approach. *"The main reason for this is that all of our used equipment is given a thorough health check before it leaves, with any remedial work being completed prior to it being sent out."* ►



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Finding used equipment should be easier at the moment as Allan Kane, marketing manager, Blue reports, "there's lot of used equipment available at the moment due to the economic climate." Michael Cumming adds: "Marubeni-Komatsu regularly receives traded-in machines for customers who are coming to the end of leasing agreements. This ensures that there's good availability of quality, Dealer Qualified used equipment."

When it comes to assessing the quality of the used equipment Bob Aldridge points out: "A piece of used equipment's wear or goodness is really up to the purchaser's requirements and expectations and realistic market price."

In fact there are a several key points to consider when buying used equipment. The first thing to do is look at the supplier itself. Buyers should be aware of mistreated or neglected equipment and are advised to purchase

machinery from reputable distributor/dealer. Customers should ask themselves: 'who are you are buying it from and are they reputable?' Many suppliers operate schemes that will ensure the machine has passed through all of the stringent testing of our dealer qualified programme. Allan Kane advises: "Always buy from a reputable company and where possible, be sure to see the equipment before you buy it, preferably working."

Services history, utilisation hours, tyre condition, body and trim, basic HSE requirements, number of previous owners and previous work environment are other aspects. "It's vital to know the hours, working condition and the application the machine has been working in," Allan Kane adds, "though age may not necessarily be the be all and end all; an older machine may have had an easy life or have low hours for example."

There are, of course, potential pitfalls, in buying used equipment so buyers need to go in with eyes wide open and make the right decisions. "In many cases you are buying the unknown," says Bob Aldridge. "The warranties will generally be shorter than new equipment. Chances are you will have higher repair and service cost. Reliability and company image might also be factors. Look for a rating system, which many dealers use and deal with reliable, renowned dealers. The best-case scenario would be OEM representative officers or dealers."

New equipment is often customised to the specific requirements of the project concerned. This ensures performance is at an optimum level, which increases production efficiency and ensures the payback period is as short as is

possible. "Obviously, purchasing used equipment means that the advantages that come with the customisation approach are not as many as would be the case with a new equipment purchase," says Peter Craven.

There are potential issues with increased spares costs in comparison to new equipment and the lack of warranty when purchased from third party suppliers and the exact information regarding the time served by the plant and the amount of production it has been subject to. Peter Craven adds: "When equipment is purchased from us we will have details of when the plant was first installed, what capacity it has done, what wear parts have been replaced and when and what material has been processed. With all our installations our service engineers are on site on a regular basis so we will know more about the history of the plant than a third party supplier."

However, used equipment can deliver a cost effective solution providing you obey the golden rules on used equipment.

"Stick to reputable brands," says Bob Aldridge. "Manufacturers most times have machine histories, ask to see these, deal with people you are comfortable with and have a reliable reputation." Peter Craven's final tip is: "Make sure you know what you are buying – where it has been, what it has been processing, what it is set up to process, what the capacity of the plant is, what are the likely spares issues, when was the equipment last serviced. To use the car industry analogy, be very cautious of the 'one careful elderly lady owner'. ►



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## How do the contributors to this article serve the used market?

Bob Aldridge: "Bell has a used equipment division. We grade our machine quality using a 1, 2 and 3 star rating. We are also able to remanufacture units or rebuild machines to the customer's required specification using original parts and factory trained engineers, and we are always able to back up our used equipment with a respectable warranty."

Michael Cumming: "The 'Dealer Qualified' Used Equipment programme from Marubeni-Komatsu was launched in 2005. It aimed to raise industry standards for used equipment and to provide peace of mind for anybody purchasing a previously owned Komatsu machine."

We believe that the quality of our used equipment is better than ever and that our Used Equipment programme is above and beyond any of our competitors. During more difficult times our customers demand first class and reliable machines - which they get with the Dealer Qualified Used Equipment programme."

Peter Craven: "CDE always have a range of equipment on offer and all of this equipment is given a thorough health check prior to dispatch with any required remedial work being undertaken. Also, we offer warranty terms on the used equipment we offer which gives customers an added degree of comfort. Once a used plant is installed, customers are also able to avail of our service in relation to Preventative Maintenance contracts and regular service visits to ensure that their plant remains operational for as close to 100% of the time as possible."

Allan Kane: At Blue we have an extensive range of used equipment, from crushers and screens to shredders and picking stations."



## Dealer qualified Komatsu works in Antarctic

Following a stringent tender and selection process, British Antarctic Survey (BAS) has taken delivery of their first Komatsu, a PC130-6 tracked excavator, for use at its Halley Research Station on the Brunt Ice Shelf in Antarctica.

The excavator began its journey to Antarctica at the beginning of December, sailing from Grimsby via Capetown, arriving at the site just after Christmas. The PC130-6, which has been put through the Komatsu Dealer Qualified programme and provided by sole distributor Marubeni-Komatsu, will be used for snow management and general snow operations around the site during the construction of a new research station.

The new complex, the sixth to be constructed since 1956, replaces the current Halley V Research Station. Located 10,000 miles from the UK on the Brunt Ice Shelf, the new station will allow long-running research on global change to continue at the site where the ozone hole was discovered.

To ensure the machine is reliable in a climate where typical Antarctic summer temperatures are around -20°C, a number of modifications have been made to the excavator by BAS. Aviation fuel will be used in the machine as normal fuel would simply freeze over. Jet A-1 fuel can be used in temperatures as low as -47°C but gives a 5% reduction in performance. This is then compensated for by dense air conditions.

With the Marubeni-Komatsu Dealer Qualified Scheme, the machine is put through a rigorous assessment and inspection process; any parts that need to be replaced are of course, genuine Komatsu parts. All Dealer Qualified machines come with a 3 month/500 hour power line warranty.

The Cambridge-based British Antarctic Survey (BAS) is a world leader in research into global environmental issues. With an annual budget of around £45 million, five Antarctic Research Stations, two Royal Research Ships and five aircraft BAS undertakes an interdisciplinary research programme and plays an active and influential role in Antarctic affairs. BAS has joint research projects with over 40 UK universities and has more than 120 national and international collaborations. It is a component of the Natural Environment Research Council.



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# Used equipment showrooms opened across the UK

**Jungheinrich has announced the opening of seven specialist used forklift truck showrooms throughout the UK. The showrooms are located alongside the company's existing regional facilities at Warrington, Sheffield, Birmingham, Milton Keynes, Bristol, Llanelli and Cumbernauld and stock an extensive collection of products from Jungheinrich's Ready To Go range.**

All of the used forklift trucks in the Jungheinrich Ready To Go collection have been rebuilt at the Jungheinrich Group's specialist used truck refurbishment centre in Dresden, Germany. Jungheinrich has recently doubled the capacity of the Dresden plant and the economies of scale created by this investment mean that the company is now able to offer significant cost efficiencies across its entire European used equipment fleet.

"While it will depend upon the specification, a used truck will, on average, cost around 60 per cent of the selling price of an equivalent new model," says Neil Warren, Jungheinrich UK used equipment and short term rental director.

"And," he adds, "because all of the truck's in Jungheinrich's Ready To Go range are rebuilt to the same high standard at the Dresden facility, the operating cost will be the same as a new model, which means that our clients have the peace of mind that comes with the knowledge that they are acquiring a product that will give many years of efficient and productive service."

In addition to the models on display at the new showroom facilities, Jungheinrich is able to source trucks from across the group. Typically, if a customer requires a model that is not in stock at his or her local showroom, the desired truck can be sourced and delivered within 8 weeks.

"Because we operate a large contract hire fleet across Europe we know exactly what trucks are coming back and when," explains Neil Warren. "Over the next three years we'll have over 100,00 trucks coming back from contract hire packages across the group, so if we can't find the truck you want it probably doesn't exist."

Details of the current Ready To Go stock held at the Jungheinrich showrooms can also be viewed on the company's website – [www.jungheinrich.co.uk](http://www.jungheinrich.co.uk)

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# Spares for growing rebuild market

As well as a replacement spares service for day-to-day downtime reduction, Blue Spares is also concentrating on what it has noticed is an increasing activity brought about by the recession, where end-users are taking the prudent option of rebuilding and refurbishing old but faithful plants to give them a second life.



Off-the-shelf availability – 24 hours delivery and sometimes even same-day – plus a range of crusher, screener and shredder spares for most leading makes are augmented by a planned series of special promotions. Genuine OEM spares are offered and, says Blue Spares, the economy of quality that this represents means that, whether it's parts for rebuild to keep the older kit at work, or replacement wear parts to minimise downtime, Blue can provide quality spares that fit first time fast, efficiently and cost-effectively.

Commenting on Blue Spares' plans and promotional schemes for the coming months, managing director Sean Warburton says: "We shall be running a series of very attractive special offers over the coming months and would encourage our customers and any discerning company operating screening, crushing and shredding equipment to get in touch and keep a close eye on our website [www.bluegroup.co.uk](http://www.bluegroup.co.uk) for spares promotions and some very special offers planned for the future".

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# QMS Expands Machining Capacity

**Quarry Manufacturing & Supplies has further expanded its machining capacity with the purchase of a Doosan Puma 700LM Mill Turn Centre. The Puma 700 Series turning centre is the most powerful machine in its class. Designed for heavy and interrupted cutting, holding long term accuracies, and maintaining superior finishes. High metal removal rates along with rapid positioning and high speed turret indexing, guarantee unmatched cycle times when real performance is essential.**

The addition of the Puma 700 increases the manufacturing capacity at QMS complimenting an already superb infrastructure which allows for every kind of breakdown problem to be dealt with quickly and economically. The Puma machine joins a range of existing Machine Tools which together enable all turning, milling, cutting and boring operations required for the manufacture of high quality crusher spares. Because QMS's Machine Shop is available 24 hours a day emergency breakdowns can be rectified as quickly as possible minimising downtime for the end user. Combined with extensive welding and fabrication facilities there is no need to contract work out to third parties, enabling a repair to be completed from start to finish in house.

Having all the repair facilities available in one location and managed by a single team means that QMS can exert total control over its work schedule enabling it to respond to its customer's requirements as quickly as needed. A one stop solution for crusher repair and maintenance also means that QMS is able to offer competitive prices on a variety of repairs across a whole range of crushers.

The addition of the Puma 700 illustrates QMS ongoing commitment to quality and flexibility as they aim to respond to customers demands in an uncertain market. QMS' ability to offer quick, cost effective, high quality repairs and servicing throughout the UK and abroad sets it apart from other aftermarket service providers.

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**SPECIFICATION**



# Crusher & Screen Repairs – The Genuine Alternative



**All Crusher and Screens repairs are completed considering original factory tolerances by our own factory trained engineers under the direct guidance of our dedicated Technical Department.**

Our knowledgeable staff have unrivalled expertise in Crushing, Screening and Asphalt Plants with many previously being employed by some of the most highly regarded Original Equipment Manufacturers.

As CMS Cepcor are the only aftermarket supplier that also incorporates Goodwin Barsby, one of the most reputable and long standing Original Equipment Manufacturers our appreciation of Original factory tolerances and material specifications are second to none.

CMS Cepcor has heavily invested in new technology in order to set the standard for aftermarket quality assurance, reverse engineering and metallurgy. We have successfully supplied replacement Jawstocks, Flywheels, Mainframes and Pitman's amongst other major components during the course of Crusher repairs

Independent professional Non destructive testing for fatigue cracks is recommended including Dye Penetrant, Ultrasonic and Magnetic Particle offering you complete peace of mind and a certificate of conformity. Eccentric and Concentric shafts are checked for straightness between centers with the total indicator reading logged in the repair file.

Once stripped and full inspected a full written report and quotation is issued to the customer ensuring an informed decision can be made on the scope of work to be authorised. The customer is encouraged to visit our Crusher Repair Center to make their own inspection and discuss the repair in detail.

CMS Cepcor hold long standing direct accounts with Europe's major Bearing Manufacturers. Our large stocks of premium branded Spherical Roller Bearings, Withdrawal Sleeves, Hydraulic Nuts, Locknuts and Lock Washers to suit all popular Jaw Crushers allows our engineers to complete repairs to your Jaw Crusher minimising downtime and offering genuine cost savings.

Bearing induction heaters, together with specialised hydraulic fittings tools are used by CMS Cepcor Engineers ensuring the precision spherical roller bearings are fitted in accordance with the manufacturer's specifications. Bearing Roller clearances and housing dimensions are recorded in the repair



**CMS Cepcor have supplied many pre-used factory reconditioned Crushing and Screening plants over the last 20 years establishing a Worldwide reputation for the supply of quality equipment.**

As we are Europe's largest supplier of aftermarket spares we can ensure that each approved Crusher or Screen is reconditioned by our own engineers observing original factory tolerances using any new parts where required.

Unlike many machine dealers all CMS Cepcor approved used crushers and screens that undergo reconditioning can be seen test running in our Workshops prior to despatch, giving you complete peace of mind.

Importantly all Crushers and Screens offered for sale are wholly owned by CMS Cepcor and free of any third party interest. All and can be inspected at our Coalville Head Office subject to prior sale and a full plant list is available on request. Optional Spares packages are available for each machine to ensure your downtime is kept to a minimum.



where the Original Equipment Manufacturer has deemed these components obsolete and the plant would otherwise be deemed as scrap. Our Crusher Repair Center is equipped with specialist tooling and has 50 tonne overhead craneage. Standard repair procedure involves stripping the crusher to component form, cleaning and then inspecting to manufacturing drawings to assess for re-use, repair or replacement with new parts.

State of the art co-ordinate measuring equipment is used alongside traditional and calibrated tools by our experienced Quality Engineering Inspectors with all aspects of critical technical data and dimensions recorded.

file and available upon request. On completion of Crusher and Screen repairs the machines are subjected to rigorous test procedures on our custom built test bed. Jaw crushers and screens are run for an extended period of, during which time the bearing temperature and vibration are closely monitored using the latest digital monitoring equipment. Cone crushers have their oil temperature, oil pressure and head spin closely monitored. Regular measurements are taken and recorded, and are available for customer inspection. Our portfolio of repairs includes many Crushers and Screen for the leading Quarry, Demolition and Recycling operations with CMS Cepcor offering a cost-effective solution to meet your needs.

We also purchase used crushing and screening plant for stock and would be pleased to be given the opportunity to tender during the disposal process of any of your surplus equipment including Scrap, Seized, Broken, Incomplete or simply mothballed machines



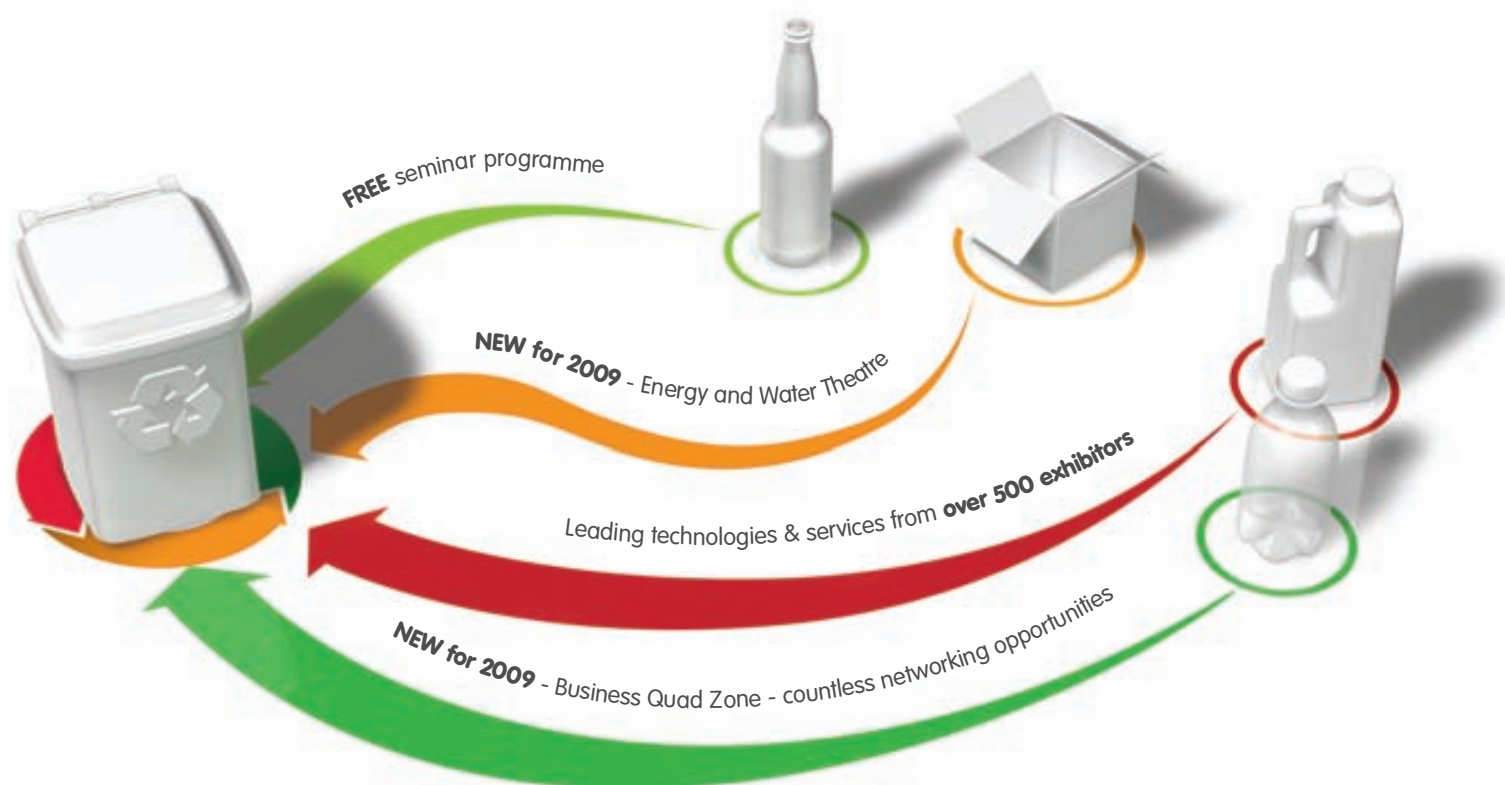
**We look forward to hearing from you!**  
**The Genuine Alternative – Setting the Standard**

CMS Cepcor and Goodwin Barsby are brand names of Crusher Manganese Steels Limited and please note the registered company name and registered number 2390549 remains unchanged since 1989.

 [www.hub-4.com/directory/1761](http://www.hub-4.com/directory/1761)



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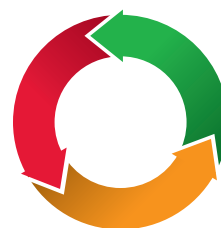
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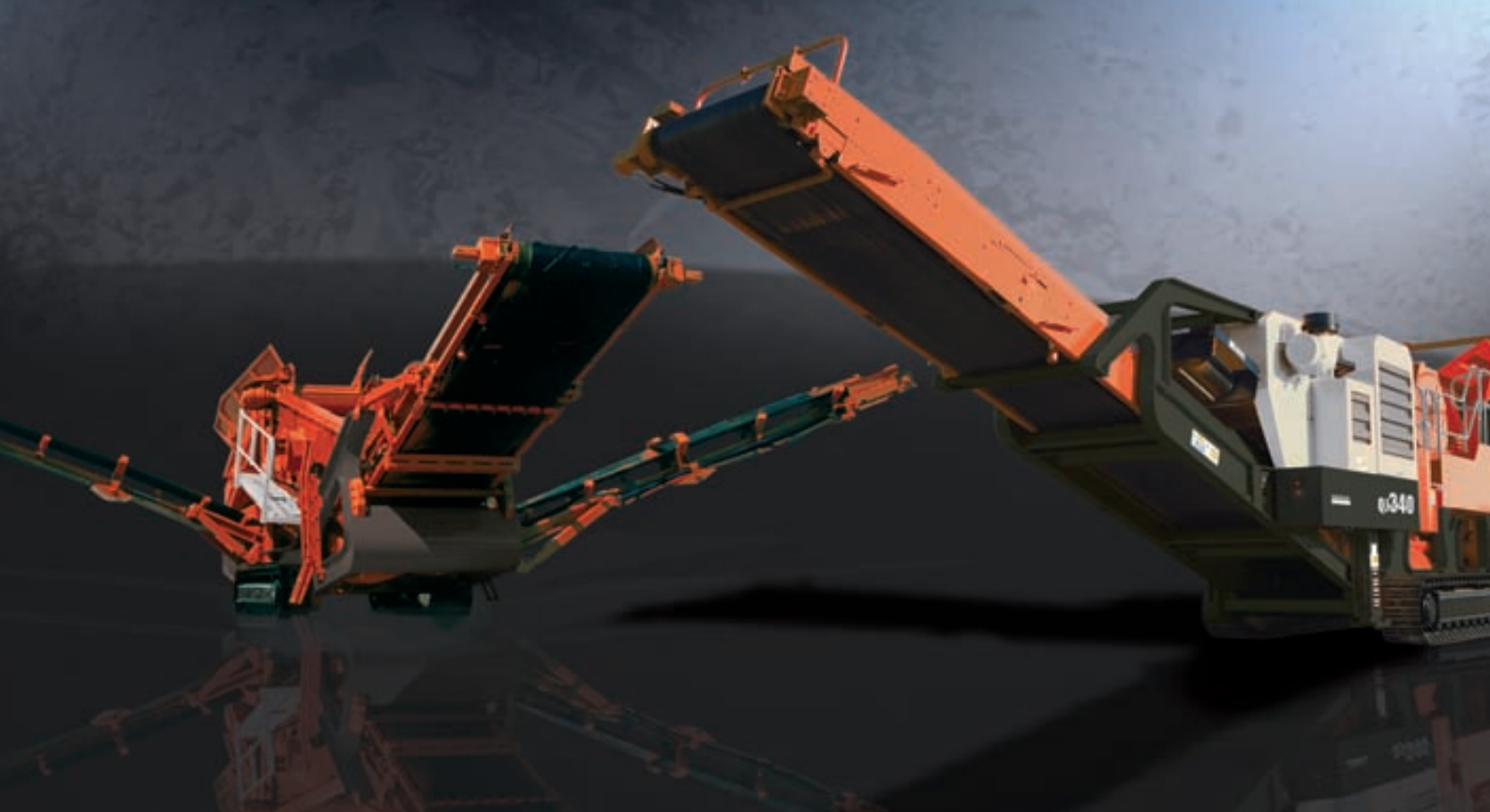
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The unification of the Extec and Fintec brands within the Sandvik group of companies has created the world's most comprehensive and dynamic line-up of mobile crushing and screening equipment. The Sandvik Mobile Screening and Crushing range now delivers all the familiar characteristics of productivity, versatility and exceptionally low running costs, but they are now combined with levels of durability and aftersales support that are synonymous with the Sandvik name. New name, improved service, same great product.

