



STATIONARY ASPHALT MIXING PLANT

# TYPE BA





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#### **THE TOP 5 FACTS ABOUT STATIONARY ASPHALT MIXING PLANTS (BA)**

- > WELL THOUGHT-OUT SITE CONCEPT > INDIVIDUAL CUSTOMISATION
- > HIGHEST OUTPUT PARAMETERS > HIGHEST RAP FEED RATES > UNLIMITED FACILITIES

With a production output of 240 t/h to 400 t/h, type BA stationary plants are the flagship of the BENNINGHOVEN product range. Particularly significant here is the high RAP material feed rate of up to 90 + x%. When building the stationary plants, upgradable components are put together based on customer requirements. Precise planning by the operating companies and the BENNINGHOVEN consulting team resulted in high-performance mixing plants that are fully developed in terms of process technology. In order to adapt them to the particular localities, aesthetically designed enclosures are implemented. With its outstanding characteristics in terms of quality, flexibility and environmental protection, in asphalt mixing plant construction the BA reigns supreme.

BENNINGHOVEN GMBH & CO. KG

## **THE NEW MIXING CULTURE - MADE IN GERMANY.**

We have been specialising in the construction of asphalt mixing plants from as long ago as the 1960s. A company that started with gear wheels and machine tools in 1909 now supplies the leading technology for asphalt mixing plants. With more than 600 employees in Germany and abroad, you can come to us directly for everything - from planning and assembly through to commissioning.

BENNINGHOVEN GmbH & Co. KG is a member of the Wirtgen Group, an expanding, international group of companies in the construction equipment industry.

PLANT CONCEPT  
**CLEAR SITING.**

The BA type asphalt mixing plant is impressive thanks to its unlimited size and facilities. It is always planned in the form of a site concept and tailored to suit the economic interests of the customer. With the BA, the customer is in a position to secure the market and dominate it for years.

The stationary asphalt mixing plant is created in solid container units, which are pre-assembled, wired and piped. This makes installation easy. Gangways around the plant and wide stairways make for convenient access and easy maintenance.



ASPHALT MIXING PLANT BA

// FEATURES

- > Spacious sections
- > Mastic asphalt production facilities
- > Processing and application of modified bitumen
- > Hot recycling dosing systems up to 220 t/h
- > Cold recycling dosing systems
- > The dosing of additives, fibre material, granulate and pigments for producing special asphalt
- > Plant heights up to 60 m with passenger and freight elevators

// LAYOUT OF TRANSPORTABLE ASPHALT MIXING PLANT IN CONTAINER DESIGN

- |                           |  |
|---------------------------|--|
| 01 Cold feed system       | 07 Hot bin section   |
| 02 Dryer drum with burner | 08 Mixing and weighing section   |
| 03 Dust collection system | 09 Storage silo - installed underneath in container form + long-term silos |
| 04 Filler tower           | 10 Control cabin   |
| 05 Mixing tower           |  |
| 06 Screen                 |  |



**// SUSTAINABLE AND ECONOMICAL**

Like all BENNINGHOVEN plants, the BA features high-quality, low-maintenance components with a long service life which will meet any market and environmental requirements.

The thermal insulation of the components in the heated section is exemplary, as is the low energy consumption. This contributes to the optimisation of the environmental aspect and of health and safety while increasing cost efficiency.

In addition, there is also the intelligent energy monitoring system, where lots of energy-consuming elements in the plant are closely monitored by sensors. Units only running under partial load or running idle will then be turned down or even shut off completely via software. This reduces peak loads while also lowering energy and heating requirements.

**// OPTIMALLY EQUIPPED**

Like all BENNINGHOVEN plants, the stationary asphalt mixing plants feature ultimate production quality, innovative technology, flexibility of application and are low maintenance.

The components are high-quality, so they can withstand temperatures of above 400 °C without a problem. To ensure smooth operation, all drives are intelligently designed on the outside so that they are protected from extreme heat. The customer can easily implement country-specific specifications and requirements in his recipes, guaranteed by the 6-fold screening which is fitted as standard. Frequency-controlled delivery units provide dosing that follows the recipe exactly.

Plant walk-throughs for inspection and maintenance work are implemented in such a way that servicing is made very easy, e.g. large maintenance platforms, access hatches and inspection doors.

Thanks to the modular system of the BA, the customer can expand his plant really easily, by adding cold or hot recycling systems or increasing the storage capacity of ready-mix asphalt, for example. Processing advantages, such as sufficient expansion space for water vapour when adding cold recycling, are evidence of sophisticated and innovative technology.



A TOP-CLASS PLANT  
**ASPHALT AT RECORD SPEED.**

This plant in Helsinki is the largest batch facility in the world. 720 t of asphalt is produced per hour - this corresponds to a traffic volume of one truck every 50 seconds.

// POWERFUL ALL-ROUNDER

The plant meets the full demand of this large region. It is equipped with long-term silos in order to be able to guarantee permanent availability.



The plant can produce both rolled asphalt and mastic asphalt, and provides the possibility of adding high recycling rates

// BURNER



PLANT COMPONENTS

**EQUAL RIGHTS FOR ALL: QUALITY.**

// BURNER

BENNINGHOVEN is a world market leader when it comes to burners, and the only manufacturer of 4-fuel burners. The company's essential expertise enables it to develop unique burners with excellent characteristics:

- > Simple, modular design
- > Compact structure
- > Mobile burner for easier accessibility (e.g. for servicing)
- > Easy to maintain
- > Inspection doors on both sides
- > Easy to retrofit
- > Internal fan (exclusive at BENNINGHOVEN)
- > Long service life
- > Low wear
- > Highly efficient in terms of consumption
- > Minimum pollutant emissions thanks to state-of-the-art control technology

// DRYER DRUM

For the manufacture of asphalt, it is essential to remove the moisture from the base material to ensure bonding with the bitumen. At BENNINGHOVEN, each drum is subject to a 100% final inspection.

In order to attain optimum results, these come in various lengths, diameters or with a variety of installed components, which are suited to the particular circumstances such as the location, aggregates and material moisture. The dryer drum is compact, robust and easy to maintain.



// MIXER

The mixer is the key component of an asphalt mixing plant. Here, the mineral is mixed intensively with binder and filler to form a homogeneous mass. A mixing cycle, including the filling and emptying, takes 45 seconds. Due to the heavy burden with regard to wear, weight and power transmission, only the highest quality materials are installed in the mixer.

Whether it's a question of special wear plates to line the trough or mixing arms with arm protection, everything is manufactured based on the premise of optimum wear protection. This guarantees the durability of the plant and smooth processing.

// SCREENING

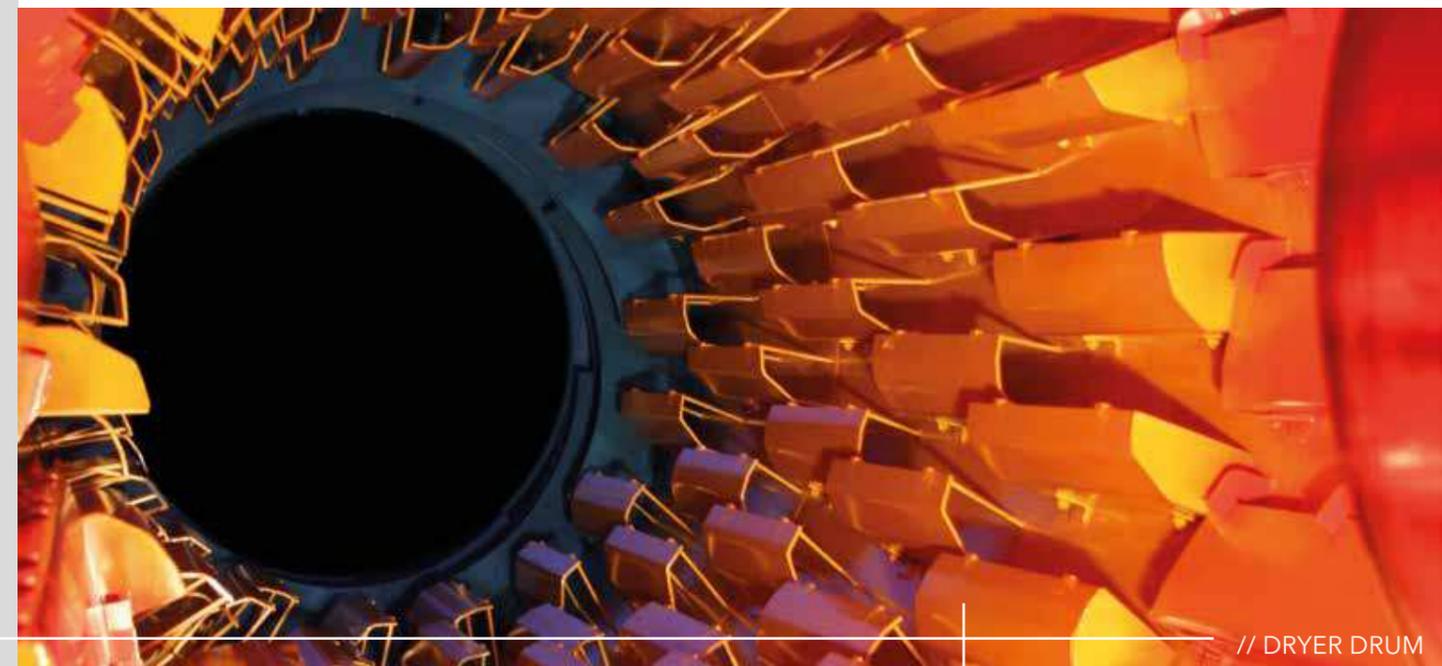
All stationary asphalt mixing plants feature 5-fold screening as standard. This enables standards and recipe requirements in the various countries around the world to be fulfilled without any problem.



// DUST COLLECTION SYSTEM

The BENNINGHOVEN dust collection system/filter is impressive thanks to its extremely compact structure and modular design. Quick installation is guaranteed thanks to the few simple interfaces.

The dust collection system is also easily accessible for inspection and maintenance; e.g. changing the filter bags is easy and can be carried out without any special tools. The vertical layout of the filter bags guarantees maximum utilisation of the surface area with efficient filter function. Thanks to their high-quality processing and heat resistance, the filter bags have a long service life. An innovative silencer system provides effective minimisation of the noise level.



// DRYER DRUM

PLANT OVERVIEW BA 3000/BA 4000/BA 5000  
**HEAVY-DUTY MODELS.**

TECHNICAL DATA PLANT OVERVIEW BA

	BA 3000	BA 4000	BA 5000
Mixing capacity (t/h)	240	320	400
Drying capacity (t/h)	220	290	360
General information	All information is based on a material moisture level of 4%, Wind load: 25 m/s, horizontal gravitational acceleration: 0.4 m/s <sup>2</sup> , snow load: 0.85 kN/m <sup>2</sup>		
Installation types	Stationary= firm concrete foundations		
Cold feed system			
Number of hoppers	6 individual hoppers		
Capacity (m <sup>3</sup> )	12	12	12
Approach ramp	On site		
Loading width (mm)	3,500	3,500	3,500
Dryer drum			
Type	TT 9.23	TT 11.26	TT 12.30
Drive rating (kW)	4 x 15	4 x 22	4 x 37
Burner			
Type	EVO JET 3 FU ÖI	EVO JET 4 FU ÖI	EVO JET 5 FU ÖI
Optional fuels	Natural gas, liquid gas, lignite - can be implemented as a combi-burner		
Rated heat output (MW)	19	23.7	35.6
Dust collection system			
Output (Nm <sup>3</sup> /h)	58,000	78,000	96,000
Screen/Hot bin section			
Capacity (0-2 mm, t/h)	240	320	400
Screening	6-fold screening		
Hot bin section	170 t in 7 bags (sand + bypass separate)		
Hot bin section optional	285 t in 7 bags (sand + bypass separate)		
Mixing and weighing section			
Mixer (kg)	3,000	4,000	5,000
Aggregate weigh hopper (kg capacity)	3,000	4,000	5,000
Filler weigh hopper (kg capacity)	300	400	500
Bitumen weigh hopper (kg capacity)	250	350	400
Mixed material storage silo/filler silos			
Mixed material storage silo total capacity	175 t (2 chambers + direct loading)		
Mixed material storage silo optional	335 t (4 chambers + direct loading) / 495 t (6 chambers + direct loading)		
Filler silos	Silo tower 1x reclaimed filler 100 m <sup>3</sup> + 2x imported filler 50 m <sup>3</sup>		
Bitumen system			
	General design stationary, with electric heating and 200 mm insulation		
Capacity (m <sup>3</sup> )	3 x 80	3 x 80	3 x 80



// BA 4000

	BA 3000	BA 4000	BA 5000
Control	BENNINGHOVEN control system BLS 3000: switching and power element, air conditioning unit and low-voltage main distribution system		
Recycling dosing systems			
Dosing system into the mixer	30% RAP material		
Multivariable dosing system	40% RAP material		
Parallel drum	70 % RAP material		
RPP	80 % RAP material		
Parallel drum in counterflow with hot gas generator	90% + x RAP material		

// FINLAND



IMPRESSIONS  
**RIGHT ON THE SPOT, ALL OVER THE WORLD.**



// AUSTRIA



// FRANCE



// BELGIUM



// GERMANY



// GERMANY



// FINLAND



// GERMANY



// GREAT BRITAIN



// GERMANY



// GERMANY



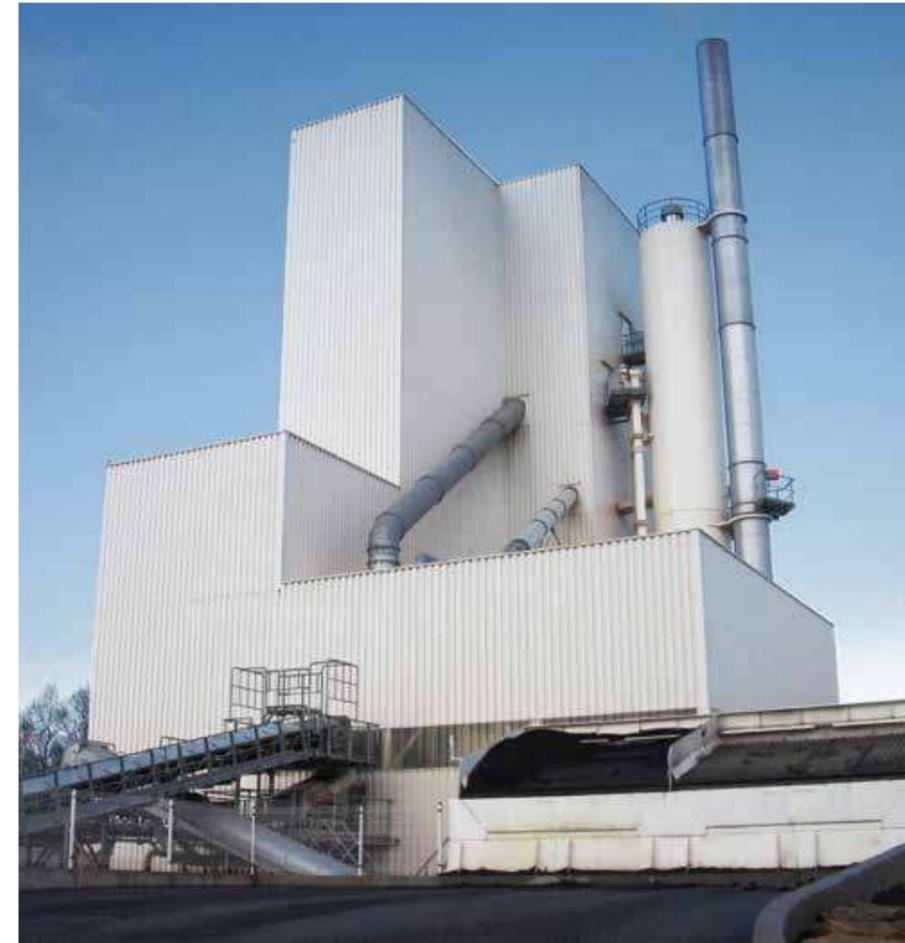


OPTIONS  
**WHEN THAT LITTLE BIT EXTRA IS REQUIRED.**

// COLD FEED SYSTEM

Individual hoppers with 12, 16 or 20 m<sup>3</sup> capacity are available to the customer for precise pre-classification of the white material. The loading width of 3500, 3800 or 4220 mm per feed hopper enables smooth, effective feeding. The hoppers are arranged in series above the collecting belt, with infinitely variable, frequency-controlled extraction belts, material flow monitor and material shortage warning indicator.

The different versions offer flexibility of installation, adapted to the local conditions.



// ENCLOSURE

The BA plant type can be partially or completely enclosed to keep noise and dust emissions to a minimum. The encapsulation further optimises the heat radiation and the energy footprint.

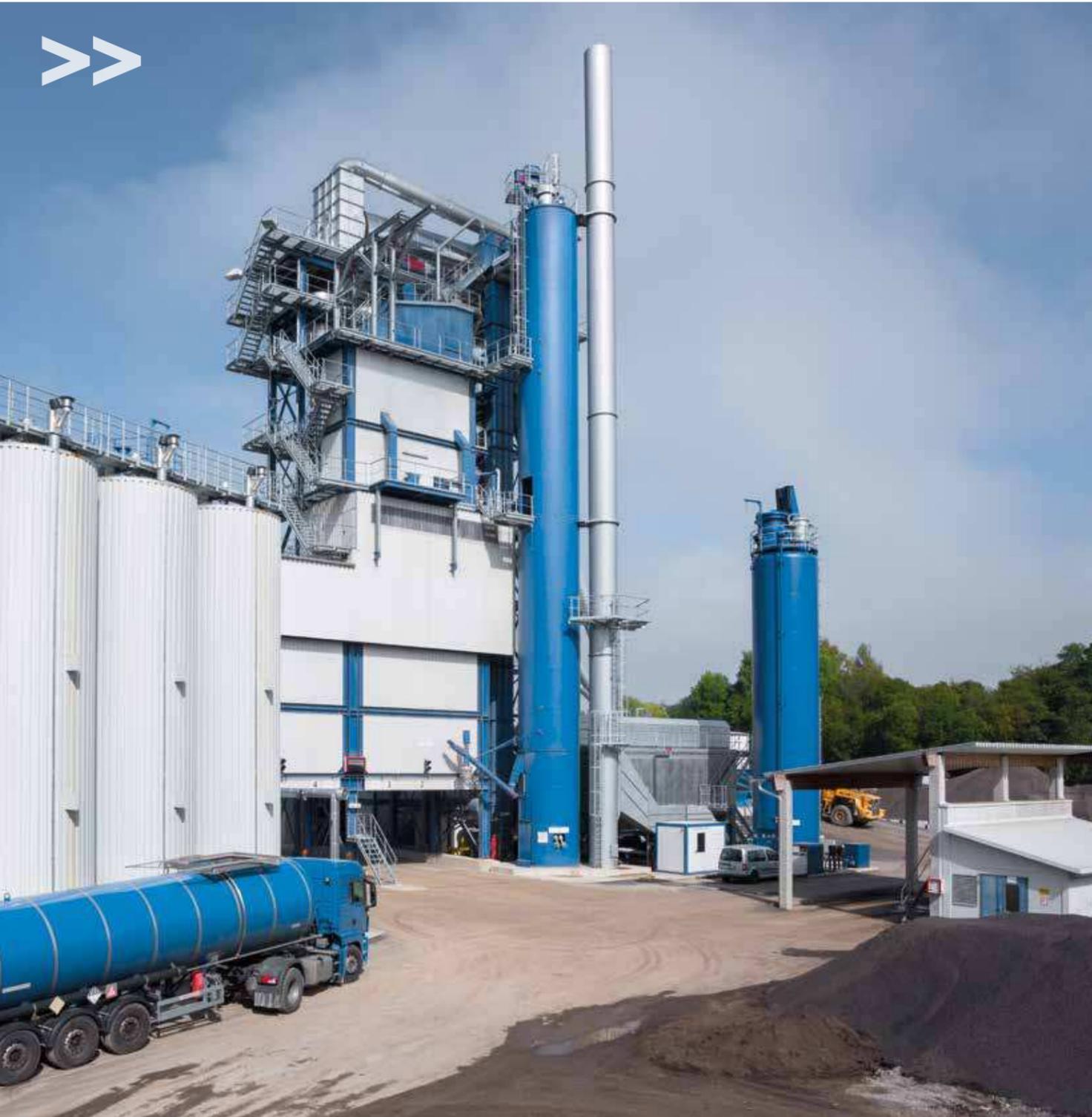
Aesthetic styling and colouring may be customised to fit in with the surroundings or are determined by national regulations or customer requirement.



// FUEL CHANGE

The customer has the option of operating his burner, which is responsible for drying and heating the base material, with different fuels. These combi-burners are capable of changing fuel at the touch of a button, guaranteeing independence and flexibility.

A combi-burner also has the advantage of eliminating downtimes for the plant due to a shortage of raw materials or delivery problems. In the event of price fluctuations for any particular fuel, the cheapest can always be selected.



// STORAGE SILO INSTALLED UNDERNEATH IN CONTAINER FORM

Examples of mixed material storage silos installed underneath with horizontal distributor system. The ingenious modular system makes it feasible to expand it by

adding other components at any time. Total capacities of 175 t, 335 t and 495 t are available.



// STORAGE SILO INSTALLED UNDERNEATH IN CONTAINER FORM

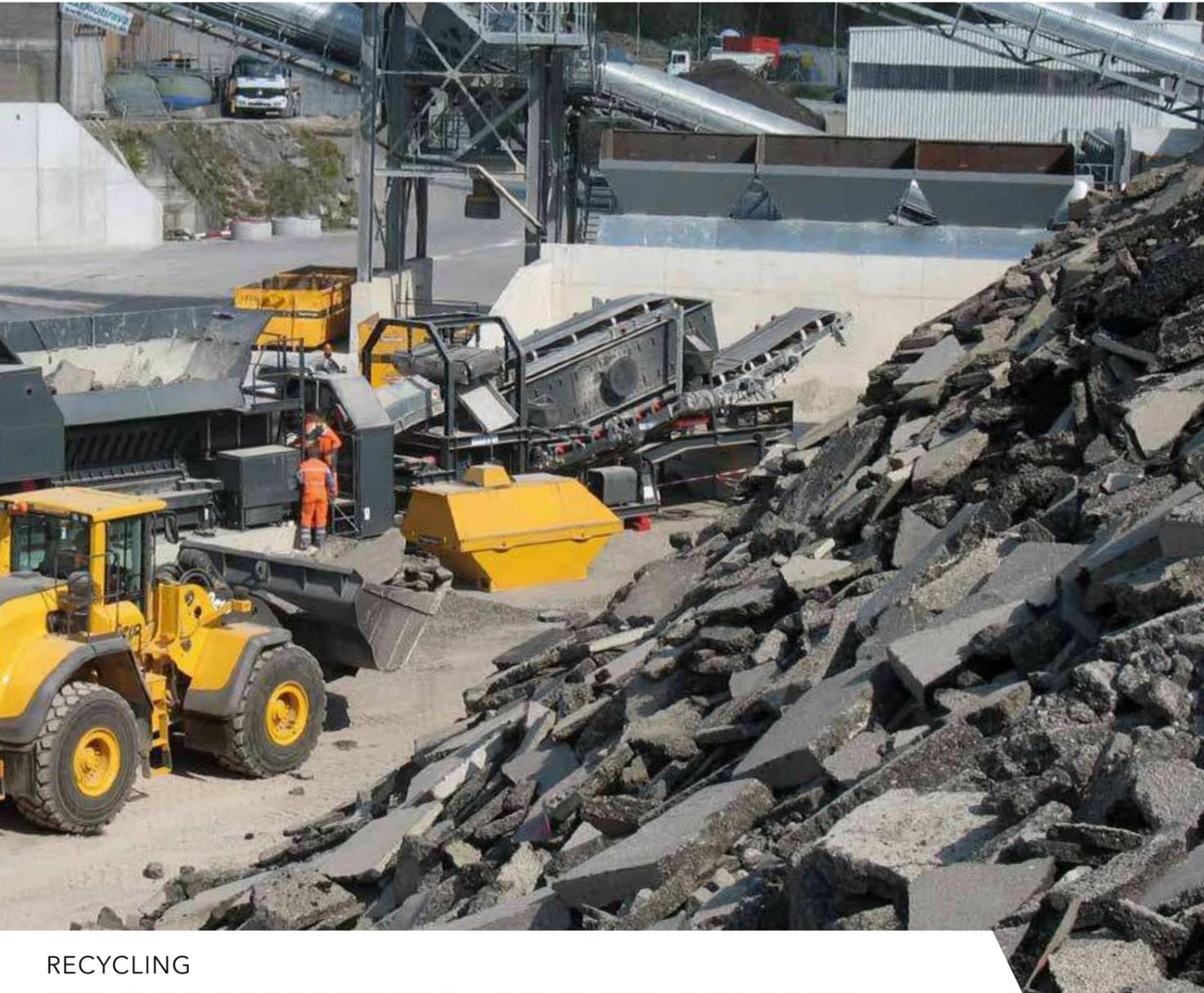
// GRANULATE FEED SYSTEM

In order to optimise the properties of the asphalt, additives can be added to the asphalt mixture. Here, BENNINGHOVEN offers the option of a single or double dosing system and dosing in container design with integrated craneway and enclosure.

// MORE OPTIONS

- > Liquide additive
- > Foam bitumen system
- > Additives in bags
- > Filler loading set
- > Filler water mixer





RECYCLING  
**FROM VALUE TO ADDED VALUE.**

As a competent partner, BENNINGHOVEN offers a wide range of services in the field of recycling dosing systems. Whether the cold or hot method is used, everything is carried out based on the premise of optimum asphalt mixture quality.

The recycling components are also customised to suit requirements and integrated to make it possible to retrofit existing plants from all manufacturers.

With the BA plant, you can choose between cold and hot feed systems depending on your requirements or in line with normative specifications and national requirements. This promotes environmental awareness, resulting in low CO2 emissions and conserving resources.

As an innovative company, BENNINGHOVEN is already meeting the standards of the future and striving for prudent use of resources. BENNINGHOVEN is the ideal company to help you produce asphalt economically, flexibly and in an eco-friendly way.



>> **COLD RECYCLING SYSTEMS**



The asphalt mixing plant can be equipped with a cold recycling dosing system or it can be retrofitted at any time.



// **MIXER DOSING**

- > Easy retrofitting of existing plants from all manufacturers
- > RAP material enters the mixer directly via inclined conveyor or RAP elevator
- > The RAP elevator is a space-saving alternative to the inclined conveyor



// **MULTIVARIABLE DOSING**

- > Highest possible feed rates in cold recycling
- > Smooth, sequential feeding to the mixer
- > Easy retrofitting of existing plants from all manufacturers
- > Prevention of steam hammering during steam expansion
- > Material- and component-friendly
- > Production of hydraulically bound base and cold asphalt possible

## >> HOT RECYCLING SYSTEMS

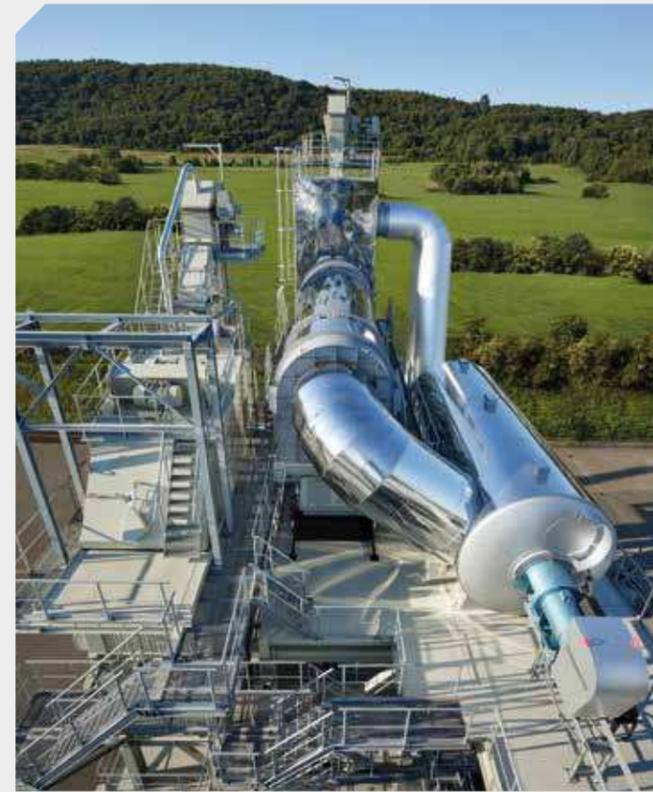


// PARALLEL DRUM



// PARALLEL DRUM

- > Parallel-flow drum system
- > Proven solution for RAP hot feed systems



// HOT GAS GENERATOR



// HOT GAS GENERATOR

- > Parallel drum in counterflow with hot gas generator
- > Highest possible feed rates of RAP material
- > Indirect heating of the material
- > Lowest emission rates
- > Significant positive overall energy balance of the plant



// RPP



// RPP

- > RPP - Recycling Priority plant
- > The determining factor in the plant design is the main component of the RAP material.
- > Mixer is arranged precisely vertical beneath the parallel drum
- > RAP material takes the straight, easy route through the entire system - no deflection of the RAP material, which could result in blockages and adhesions/ deposits



// HOT GAS GENERATOR



CONTROL  
**SUCCESS AT THE TOUCH OF A BUTTON.**

The BLS 3000 control system features simple, intuitive operation, a very clear structure and perfectly realistic visualisation. All functions and operating elements of the process control system are displayed clearly in the computer animation and controlled with a mouse or keyboard.

In addition to fully automatic mode, the control system also offers the option of a manual operating level. This allows the mixing operator to control all drives and valves separately. The real time representation of the

mixing process with graphical and alphanumerical monitoring of set values and actual values is displayed on the 24" monitor.



CONTROL  
**SOPHISTICATED CONTROL.**

// MIXING PROCESSES AND DOCUMENTATION

All the plant's mixing processes can be freely selected, so the scales can be filled and the mineral, filler, bitumen and RAP material added to the mixer in any order. Continuous tare compensation is also integrated, and corrections can be made subsequently on the basis of previous mixtures. The uninterruptible power supply ensures operational safety.

The control system for the entire mixing plant is documented in detail and monitored:

- > Statistical long term recording of individual components in a database
- > Documentation via printer or on the hard drive with data back-up
- > Batch record manager for evaluating and viewing the batch report with detailed search capability
- > Histogrammic analysis of components (graphical presentation of frequency distributions)

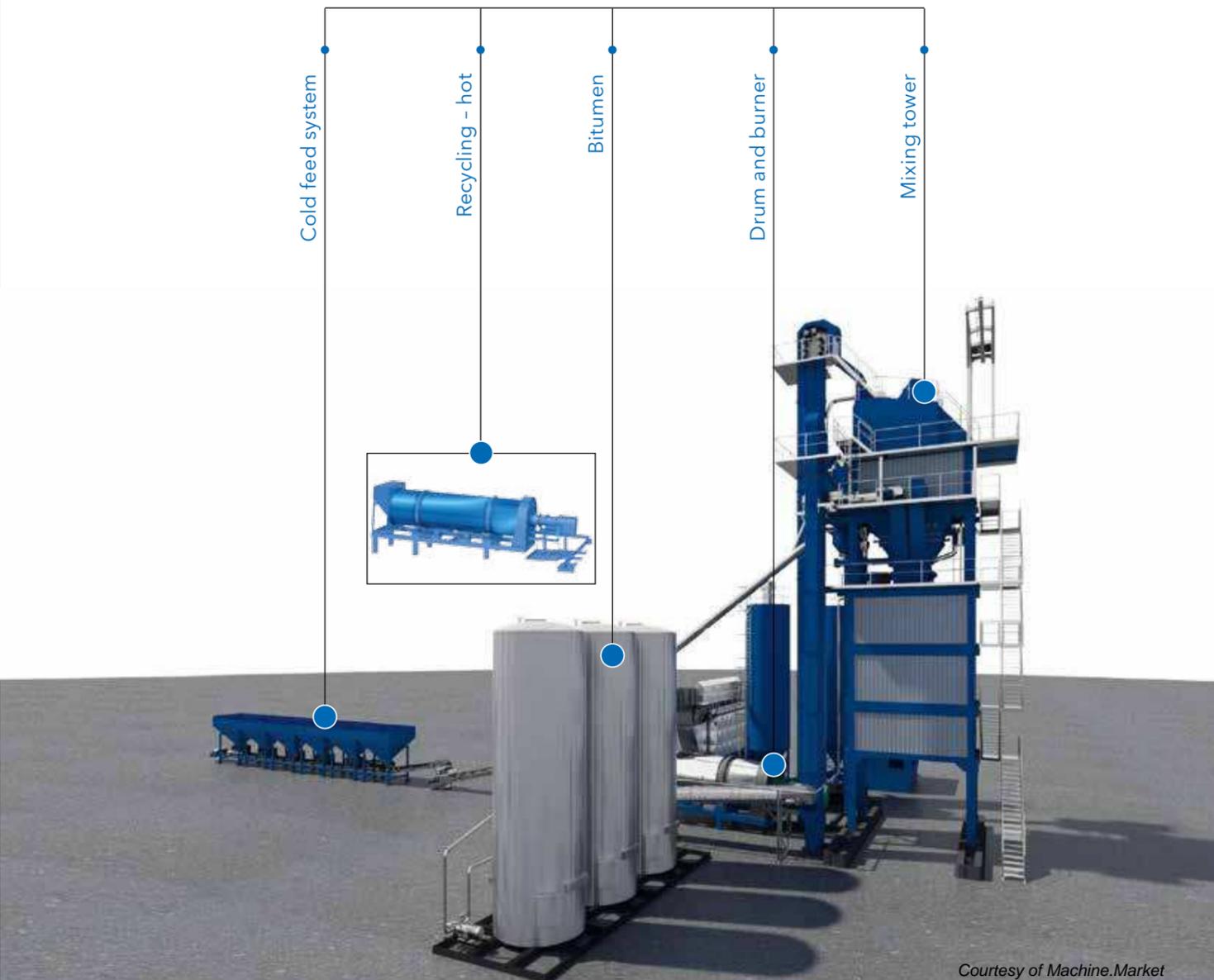
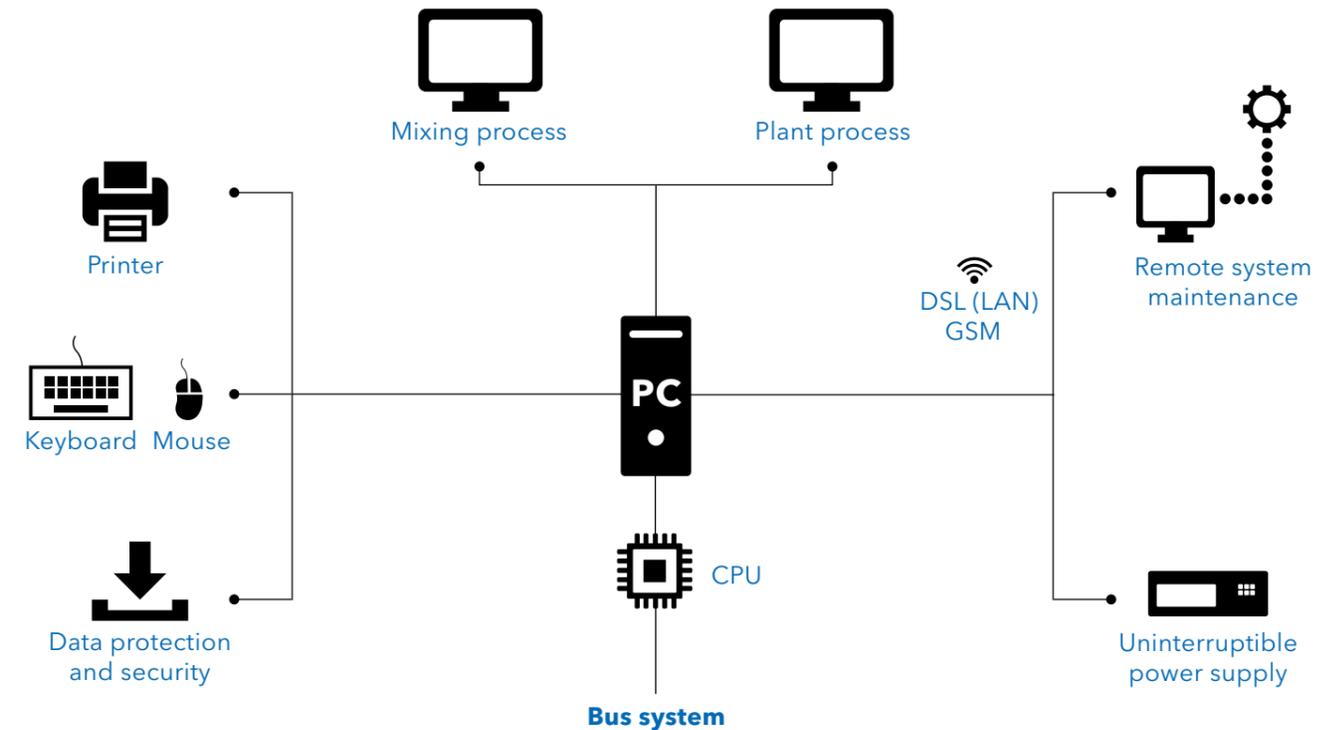
// RECIPES AND ORDERS

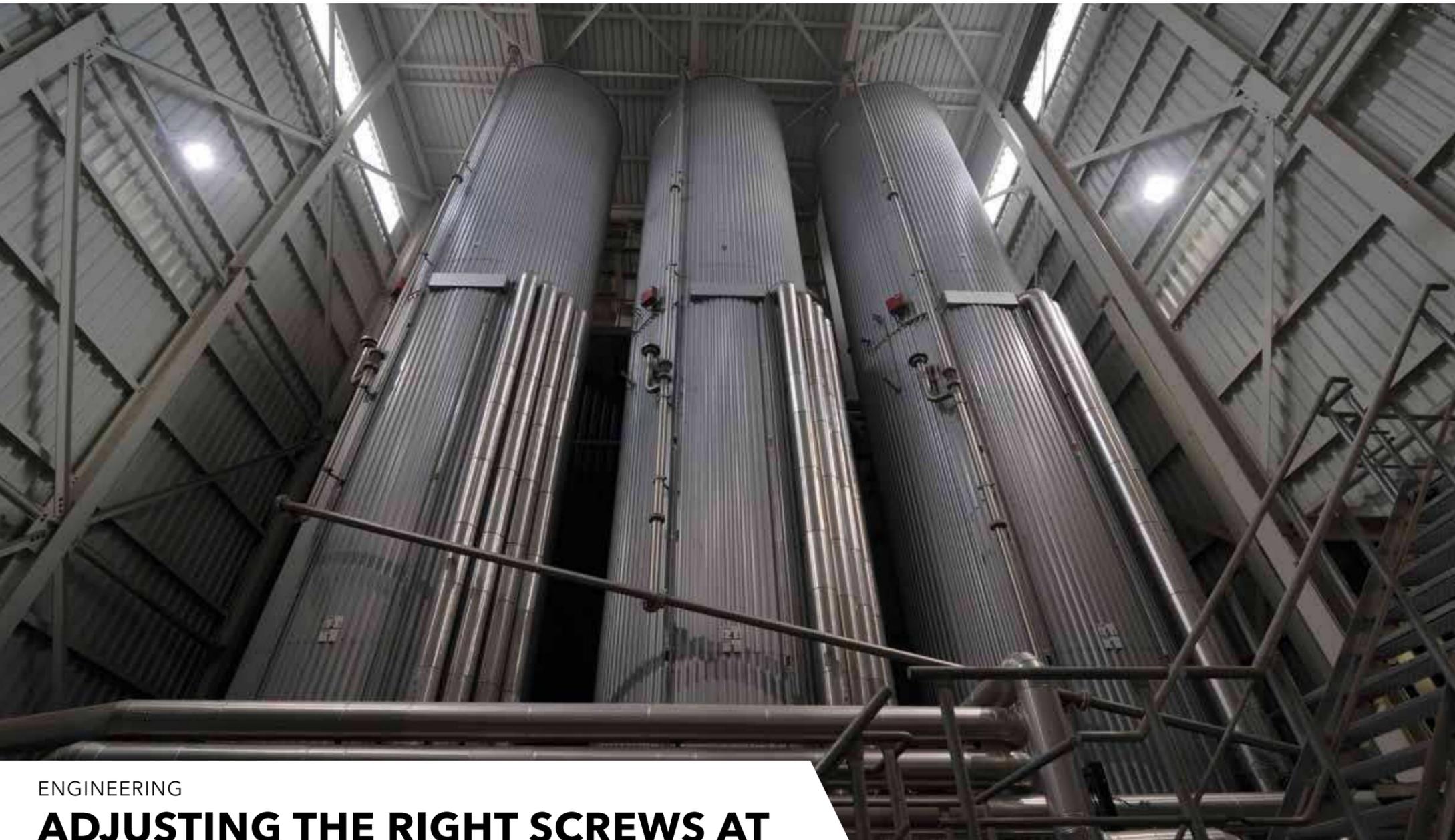
Via the control system, any number of recipes can be input and managed. Base parameters and pre-input can be changed during the mixing operation. Recipe selection and creation, accounting with daily, monthly and annual logs as well as parametrisation are all carried out via the user interface.

Order input is also possible in any quantity. Orders can even be divided into partial orders. In addition, customer orders may be interrupted and others given priority, whereby the remaining amount is stored and can be called up again if required.

// REMOTE SYSTEM

- > Remote maintenance - First Level Support
- > Connection to the plant's control system is possible at any time (following go-ahead from the customer/operator)
- > Diagnosis and support
- > Fault rectification on site with the customer's personnel
- > Cost-effective





ENGINEERING

# ADJUSTING THE RIGHT SCREWS AT THE RIGHT TIME.

Our services commence before the order is even signed, and they don't simply come to an end once the product is commissioned either. At BENNINGHOVEN, comprehensive customer support starts much earlier in the run-up to a project.

An asphalt mixing plant needs to be designed in such a way that all substances are available in sufficient quantity, at the correct temperature, at precisely the right time and at the relevant location. Moreover, the processing needs to be carried out in a way that is safe, economical and eco-friendly. We work with each customer individually to process all these requirements, specifically for his site.

- Possible site requirements are:
- > Industrial area, nature conservation area or mixed-use area
  - > Topography (plant on a hill or in the valley)
  - > Requirements of the neighbouring communities (enhance the stack, odour filters and vibration dampers, to combat dust, odours and noise)
  - > Tailored colouring or enclosure, if the plant should not be recognised as such

## // OUR SERVICES DURING THE PRELIMINARY STAGES

- > Technical plant and service description
- > Creation of layout and site plans
- > Assistance with measuring emissions
- > Provision of data for the expected noise emissions
- > Description of the safety equipment for each plant
- > Structural analysis of each plant and location (wind loads, earthquake areas, etc.)
- > Advice on the current standards
- > Ship and truck loading
- > Planning optimum logistics routes at the plant or infrastructure across the entire mixing location



## // SHIP LOADING IN NORWAY

Here the finished asphalt is either loaded into trucks or onto a ship. This makes it possible to deliver asphalt to the remote fjords.

## CUSTOMER SUPPORT AT BENNINGHOVEN RUNS LIKE CLOCKWORK.



### // TECHNICAL SUPPORT

- > Troubleshooting
- > Service interval consulting
- > Field service
- > Application consulting
- > Specialist staff-sharing in the event of holiday or illness



### // INFORMATION SYSTEMS

- > Telephone support
- > Troubleshooting via remote maintenance
- > Online support
- > Software updates
- > Replacement of old control elements



### // LOGISTICS

- > Transportation organisation and planning, up to 100 trucks/project
- > Assistance with approval procedures
- > Organisation of special transportation
- > Customs clearance



### // TRAINING

- > Safety briefing
- > Plant briefing
- > Operation
- > For service technicians
- > For plant personnel



### // SPARE PARTS

- > 24/7 via special courier service
- > Planning
- > Logistics
- > Creation of customer-specific spare parts packages



### // PREVENTION

- > Prevention and plant inspection
- > Individual spare parts consulting
- > Consulting on innovative wear protection to extend service life
- > Heat and energy optimisation for the plant
- > Perfectly prepared for the new season

## // RETROFITTING AT BENNINGHOVEN

When you consider that asphalt mixing plants have a service life or operating period of more than 40 years, during this period it is obvious that technology, requirements and standards will change and research findings will conquer the markets.

Accordingly, this creates the need for the asphalt mixing plants to remain in good condition, both internally and externally - by replacing components or general retrofitting of the plants. There are many reasons for this:

- > Normal wear
- > Upgrading to increase capacity
- > Environmental awareness and tighter emission laws

- > Reduction of the overall energy balance (e.g. use of heating media for drying, standby mode for units which are temporarily not being used)
- > Control system retrofitting, from console control to PC
- > Enabling RAP dosing
- > Attaining the status quo for plants
- > Improving efficiency

BENNINGHOVEN is able to retrofit components not just on its own plants but also on all third-party plants. As a technology leader, BENNINGHOVEN offers ideal solutions for optimising your mixing plants in many areas, e.g. burner technology, RAP systems or bitumen technology.



Spacious gangways to all sections offer ideal inspection and maintenance conditions.

CUSTOMER SUPPORT

**RIGHT NEXT TO OUR CUSTOMERS.**

Our local contacts in sales and service companies provide comprehensive support for all issues and queries relating to our products. This includes diagnosis and technical support, ordering original spare parts and advice on using our products.

Rapid technical support is our top priority. We guarantee a short response time and rapid solutions thanks to a close-knit network of offices, their experienced service technicians and the additional support of our home factory.

Knowing exactly how to operate our plants is the key to using them successfully. To provide your employees with the specialist knowledge they need, BENNINGHOVEN offers a wide range of training courses at our main factory in Mülheim - or we can come to you.

We develop training courses specifically adapted to our customers' needs, which are then delivered by competent employees from our specialist departments.



MORE THAN

107

YEARS OF CUSTOMER FOCUS

MORE THAN

600

MOTIVATED SPECIALISTS



// ASPHALT MIXING PLANT



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