

“We cut maintenance costs by 50% and increased capacity up to 1.5 million tons per year thanks to Stedman & Innovative.”



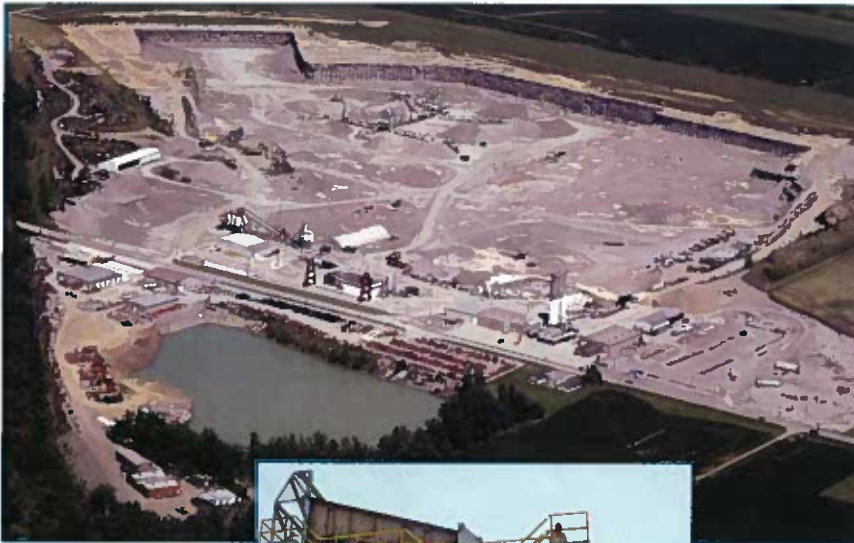
*Jim Duff
Owner
Duff Quarry*



Duff Quarry, Inc., Huntsville, Ohio, bought a Mega Slam™ 5460 Impactor and Stedman Grand Slam™ 6460 to crush limestone in their automated quarry. To complement the crushers, Innovative Processing

Solutions designed a complete plant including an automated control system. Jim Duff stated, “I’m concerned about longevity, not just today — that’s why we keep coming back to Stedman.”

Automated plant operates with just two people



Duff Quarry Inc. (Huntsville, OH) began a new limestone crushing plant in the spring of 2005 to replace their previous plant, opened in 1956. While building and designing this new quarry, James Elder Duff, owner of Duff Quarry, focused on creating a state-of-the-art plant. "See, markets change and we wanted to go into something where we had the flexibility to do different things and different sizing," Duff says.

In order to create a flexible, modern plant, Duff Quarry turned to Innovative Processing Solutions, an affiliate of Stedman, who designed and fabricated the automated material handling solutions for the quarry.

Duff Quarry installed a 5460 Mega Slam™ and 6460 Grand Slam™ crusher, along with a complete automated plant system from Innovative Processing Solutions.

The new plant can produce up to 1.5 million tons of limestone a year running at full capacity. "We have the capabilities of stock-piling 155,000 tons of rock underneath this plant," Duff adds, "155,000 tons of finished product."

Duff Quarry also purchased numerous conveyors, stackers, sensors, controls, vibrating screens, feeders and other equipment through Innovative Processing Solutions plus installed Apex electronics and control systems to create and design a programmable logic controller. Each conveyor at the limestone crushing plant is equipped with



terminal strips that are all wired to communicate information to one main processor.

"There are too

many conveyors for one guy to stand there and say he knows what's going on. So this brings all of this information together in one place," explains Bill Page, Maintenance Supervisor. Page worked with Apex in designing the control and information system.

Duff Quarry was able to more than double their production capacity with the help of the automated plant.

"When we ordered the plant we received it as we had planned, no problems," Duff notes. "Any help that we needed, which was a lot,

we got from Innovative and Stedman. I can't say anything but good things on what they've done for us."

Benefits of Automation

With the ability to monitor the speed of the conveyors and feeders, the quarry can keep an eye on production and can troubleshoot maintenance issues. "The reason for having an automated control system is that if something goes wrong on one of those conveyors, you aren't going to see it fast enough to stop a catastrophe," Page states. "And a catastrophe means that we have to dig out a conveyor. But now if

something goes wrong, the computer takes over and begins dropping conveyors, discharging material and shutting the feeder down."



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