Benninghoven │ REVOC System Proven in Practice

Retrofitting of an Existing Asphalt Mixing Plant Reduces Ctot Emissions by 50%

The REVOC Retrofit solution has been installed at an existing asphalt mixing plant in Nentershausen/Hesse. The ‘catalytic converter for asphalt mixing plants” is one of the innovative technologies developed by Benninghoven to enable more sustainable asphalt production.

High-Quality Asphalt Mixes for Highway, Road, and Infrastructure Construction Projects

The TBA plant from Benninghoven, manufactured in 2007, is situated on the site of a basalt quarry and produces 80,000 to 100,000 t of high-quality asphalt mixes per year for highway, road, and infrastructure construction projects. To enable even more sustainable asphalt production in the future, the plant operator made the decision to retrofit the plant with the catalyzer for asphalt mixing plants.

“We chose the REVOC system because it enables us to reliably comply with total carbon (Ctot) emission standards, even with the addition of a high proportion of reclaimed asphalt pavement.” explains Peter Bach, CEO of WWA Westerwald Asphalt.

A Critical Contribution to Safeguarding the Future of the Production Facility

Thanks to the patented, pioneering technology, the plant operator is now in the position to increase the maximum feed rate of reclaimed asphalt pavement (RAP) from the previous 30–40% to 50% and simultaneously reduce Ctot emissions by more than 50%. The initial practical experience with the retrofitted plant is extremely positive. Another important factor for the asphalt producer was that the use of this system safeguards the long-term viability of the plant.

Sustainable asphalt production is determined by two factors: on the one hand, the ability to increase the RAP feed rate with the goal of conserving valuable resources and the expedient re-use of old material. Because, the higher the RAP feed rate, the less fresh bitumen is needed, which in turn leads to a correspondingly smaller carbon footprint. On the other hand, it is essential that the strict Ctot threshold values of <50 mg/m³ stipulated in Germany’s official regulations on air quality, “TA-Luft” are fulfilled.

Higher RAP Feed Rates and Simultaneously Low Emission Values

Although reclaimed asphalt pavement (RAP) can already be reliably fed into the production process by utilizing established cold or hot recycling technologies, the total carbon emissions are higher. When reclaimed asphalt is heated, part of the Ctot concentration evaporates out of the bitumen contained in the recycling material. Ctot possesses a higher greenhouse gas potential than CO₂, and is a hazard to health in higher concentrations.

In the past, solving the conflicting objectives of high RAP feed rates while nevertheless assuring sustainability in the production process were effectively impossible. Thanks to the efficient and effective REVOC system, these two aspects can now be reconciled: reducing Ctot emissions by up to 50% and realizing higher RAP feed rates of up to 60%.

REVOC – an Ecologically and Economically Viable Solution

The system works like a catalyzer. The fumes generated in the mixer of the asphalt mixing plant are extracted at source and passed to the REVOC system for thermal processing. Thanks to the reduction of emissions, the plant operator can add a larger proportion of RAP to the mixing process without exceeding the stipulated threshold values. The method not only conserves primary resources, but also cuts the costs of the production process.

Emission Monitoring Confirms Results

The entire project was closely monitored from the start – on-site, by telephone, or by telemaintenance. This included, above all, regular measurement of the emission values and fine tuning of the plant on the basis of the results. The results significantly exceeded all expectations with regard to emission reduction and were repeatedly confirmed by independent measurements.

Good Future Prospects for Operators of Old Plants

Improved plant performance, high RAP feed rates, and reduced emissions: existing plants with the REVOC system installed as a Retrofit solution can also be made fit to face future challenges. The design concept allows plant operators to enjoy the benefits of the system by integrating it into their existing plants from other manufacturers.

**Photos:**

  
Benninghoven\_Nentershausen\_01  
The REVOC system from Benninghoven was installed in the existing asphalt mixing plant in Nentershausen. The Retrofit solution enables the reduction of Ctot emissions by more than 50%.

  
Benninghoven\_Nentershausen\_02

The REVOC system was custom-tailored to fulfill the requirements of the Benninghoven TBA plant. It produces 80,000 to 100,000 t of high-quality asphalt mixes for highway, road, and infrastructure construction projects per year.

  
Benninghoven\_Nentershausen\_03

Thanks to the catalyzer for asphalt mixing plants, the emissions are extracted from the process at source.

  
Benninghoven\_Nentershausen\_04

Higher RAP feed rates and lower Ctot emissions increase the sustainability of the asphalt production process.

Note: the photographs shown here are only previews. If you wish to publish them in other media, please download the higher resolution (300 dpi) versions from the link provided here.

For further information, please contact us at:

WIRTGEN GROUP

Public Relations

Reinhard-Wirtgen-Straße 2

53578 Windhagen

Germany

Phone: +49-2645-131-1966

Fax: +49-2645-131-499

E-mail: PR@wirtgen-group.com

www.wirtgen-group.com