

Americas'

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MINES & QUARRIES

LOS FILOS

Making History with Hitachi



The newest of Goldcorp's portfolio of mines, Los Filos, has made history:

- *It's the first major gold mine to break ground in Mexico in decades.*
- *It's Mexico's first above-ground gold mine.*
- *It's the first to feature hydraulic shovels.*

STARTING AT THE TOP

Unlike many mines, Los Filos starts at the hilltop and works down. Named for the crest of the hill on which it sits, the mineralized gold deposit at Los Filos extends across the surface for a total of 3,900 feet (1200 meters) and then down both sides of the hill in varying depths. The overburden is a composite of granodiorite and marble — both of which are tough to drill, hard to blast cleanly, and hard to load.

Conventional open-pit mining techniques are being used to develop the ore body. The pit design has 32-foot (10-meter) benches with a final average slope of 52 degrees. The haul roads have a grade of 10 percent. The operational cycle features the drilling of 6.9-inch (17.5-cm) and 4.5-inch (11.4-

cm) diameter blast holes in both the barren and mineral strata. After the material is fragmented, two Hitachi hydraulic shovels and one front-end loader, each with 19.6-cubic-yard (15-cubic-meter) buckets, load the blasted material into a fleet of twelve 100-ton-capacity haul trucks.

Why were Hitachi hydraulic shovels the choice? According to Ing. Roberto Díaz Colunga, general manager of the Los Filos project, the decision was made based on equipment start-up costs, anticipated production capabilities of the excavators, and long-term fuel and maintenance costs. To make sure the mine has long-term control of maintenance costs, a Maintenance-And-Repair Contract (MARC) has been provided by Hitachi and their dealer, MinePro Services of Mexico.

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Right downriver from a very big steel arch an even bigger project is underway. Bloomsdale Excavating is facilitating the digging, blasting, and trucking required to efficiently tuck a massive cement plant within the stoic hills and quiet oaks of rural Missouri. In fact, the plant is the world's largest single-kiln concrete plant.

DRURY DUTY

Upon his return from the Second World War, Marvin Drury and his brother Ralph set up their excavating shop in anticipation of the postwar building boom. Concurrent with the explosion of new construction was the baby boom, and Marvin was successful with both, fathering many Drurys to take the reins of the family business. In fact, during our visit, current Bloomsdale President Tom Drury was making final arrangements for his dad's 80th birthday party, complete with carnival rides for the kids.

Despite the big project — the company's largest in 60 years — and Dad's birthday, it wasn't difficult to get Tom Drury to pose with the brand-spanking-new Hitachi Zaxis 850LC-3. "With the heavy loads we work with, we need a machine this size with its longer boom, bigger stick, and larger bucket," says Tom.

Bloomsdale Excavating's Equipment Manager Steve Fallert and Owner Tom Drury.



AN OBVIOUS PLANT

And with that, we're off to the grounds of the cement plant with Equipment Manager Steve Fallert. "Actually, we're not Hitachi guys," says Steve, "or Cat or Volvo guys, for that matter. We look at each machine — usually by demo-ing a few different brands. But, I'll tell you, these Hitachi trucks are built for longevity. Bloomsdale strives for 95-percent uptime from our fleet, and these Hitachi trucks do wonders in helping us achieve that goal. And while I'd like to take credit for the six orange 65-ton trucks and the six 100-ton trucks you'll see working here today, it was a quarry owner in Kentucky who proved to me that the Hitachi trucks are the ones to buy. He had data on his computer detailing the life of key truck components of Cat and Hitachi, and the orange trucks had longer engine lives. And he got between 2,000 and 3,000 more hours out of the Hitachi components over the same systems in his Cats."

PERFORMANCE



THESE OPERATORS AIN'T STANDING BY

After watching stuff blow up, thanks to Bloomsdale's TNT crew, we watch the EH1000s and the EH1700 being fed a steady diet of rock by resolute front-end loaders. The trucks line up and the cycles are choreographed like a Broadway musical. Impressive. Finally, the lunch whistle blows — our cue to ruin everyone's break with a lot of questions. Like those asked of EX750 operator Mike Grass. "This 750 is a dream to operate," says Mike between bologna sandwich bites. "Smooth controls and awesome hydraulic power, and the cab is cushioned so it's comfortable no matter how many trucks you load each shift."

Then we asked the operators about driving the EH1000s and the EH1700, or "Eucs," as they call them. "They want us to move between 30 and 40



Bloomsdale Excavating found that Hitachi trucks had longer engine and component lives than Cats.

loads a shift," said Brad Gammon. "They're great trucks to drive — I especially like the 1700. It's a great all-around truck." "I think these trucks are

great, too," adds fellow operator Trevor Michael. "We had some other trucks early on in the project. When I got stuck driving one, I called it 'the penalty box.'" Ouch!

We give the final word to our great customer, Tom Drury. "In this business, you have to make deadline or lose a valued customer. We'd just as soon make deadline. When you specialize in the private-sector design-build work we do, you form many alliances. Satisfy these customers and they come back again and again. We have the right people on staff — surveyors, associate engineers, project managers, and equipment operators. Give them the best and most reliable equipment, and the projects will get done on time and on budget. And that's why you saw 12 Hitachi trucks today."

Bloomsdale Excavating is serviced by Rudd Equipment.

The Hitachi trucks are built for longevity.
— Steve Fallert, Equipment Manager
"The Hitachi trucks are built for longevity."
— Steve Fallert, Equipment Manager

History with Hitachi

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A 50,000-TON TARGET

Assisted by a wheel loader, two Hitachi EX2500 hydraulic shovels load 50,000 tons of material per day. The ore is classified into run-of-mine or crush leach. It's then fed to the heap for leaching or the crushing circuit for crushing into a smaller size before leaching. The gold-rich solution is then recovered, dried, and smelted into gold bars. Target mill ratio is 0.991 grams of gold per ton of ore.

BUCKING THE TREND — WHY SHOVELS?

William Clements, Hitachi Sales Manager for Mexico, and Hitachi Mining Engineer Eric Berkheimer prepared a study for Los Filos management. The study had compelling documentation that the hydraulic shovel was the most cost-effective solution for this application. The study, prepared with proprietary CONSULT software, also provided facts and figures supporting the choice of 100-ton trucks. The study also helped the Hitachi dealer submit a bid on an extremely competitive MARC (see below).

Los Filos is serviced by MinePro Services of Mexico.



The MinePro Services Mexico team (L-R): Mario del Rincon, Enrique Prado, Aquilino Beltran, Raul Morales, Sergio Diaz, Miguel Vargas.



Enrique Prado Ortiz,
MinePro Services
Project Manager

MinePro Services Mexico SA CV

A major confidence factor for Roberto Díaz Colunga and the Los Filos management group was the creation of a Maintenance-And-Repair Contract (MARC) that satisfied their concerns about future costs. The plan provides mine-site maintenance facilities, parts, and a full-time, round-the-clock staff of MinePro mechanics. The plan is expertly managed by Enrique Prado Ortiz, Project Manager.

MinePro Contract Services is known for providing technical expertise to mining operations all over

Central and South America. Their customers depend on well-trained, well-equipped MinePro technicians to keep their equipment running efficiently and their owning and operating expenses low.

The MARC agreement at Los Filos covers all routine service on shovels as well as all primary repairs and parts. Major overhauls or replacement of critical parts with factory-rebuilt components are already figured into the contract cost — so there are few, if any, expense surprises.

MinePro Services Mexico is headquartered in Hermosillo, Sonora, Mexico.



ALL OVER THE WORLD AND RIGHT IN YOUR BACKYARD!

At hundreds and hundreds of mine and quarry sites all over the world, Hitachi excavators and trucks are helping to keep production costs down. Highly productive. Extremely reliable. Low maintenance costs. High uptime — even with high hours. Excellent field support.

To find out more on how Hitachi can help your operation, contact us.

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