

Factors Determining the Size of Sealing Clearance in Hydraulic Legs of Powered Supports

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Abstract. The factors that directly influence the formation of a sealing clearance between the piston and the working cylinder in hydraulic legs of powered supports are considered in this article, the size thereof has a direct effect on the tightness of the legs and, as a result, on the safety of work at the production face. A detailed description of these factors is given, which is supported by the dependencies obtained from the results of finite element modeling of various types of legs under various strength and geometric parameters, external load types and locations in the support section. The problems of formation of radial deformations of a working cylinder loaded with working fluid pressure are considered, and their dependence on the level of this pressure and extension. Based on the simulation results, the mechanisms for the formation of additional clearances due to rod and cylinder misalignments are described, and the conditions and causes of the resonant phenomena development are given. The classification of these factors according to the degree of generalization and the functional interaction between each other is proposed.

1 Introduction

The main trend in underground coal mining in recent decades is reduction of the total number of integrated mechanized faces with a simultaneous sharp increase in their efficiency. At the same time, this situation is accompanied by deterioration of the geological and mining conditions for functioning of such sets of equipment. Thus, in July 2017 the mine named after V. D. Yalovsky of the coal mining company SUEK-Kuzbass mined 1.5 million tons from one face setting a record of monthly production. It all poses higher requirements to the reliability of operation of integrated mechanized faces.

The main elements of the powered support, directly taking up rock pressure and ensuring reliable and safe working conditions for labour and mechanisms at the production face, are hydraulic legs, their functioning determines the operation of the set of mining equipment as a whole [1-5].

2 Materials and methods

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Radial deformations of the wall (dR) of the working cylinder are determined by the design and geometric dimensions of the hydraulic legs, the main of which are wall thickness, length, and extension [6-7].

As shown by numerous studies carried out by the authors using finite element methods on hydraulic legs of various designs [8,9] installed in powered supports of different manufacturers, the shape of a typical curve of radial deformations of the working cylinder wall is shown in Fig. 1. This curve has 5 characteristic key points. Points 1 and 5 (p.1 and p.5 in Figure 1) are located in the places of the largest deformations of the cylinder, from the piston and the bottom sides of the cylinder, respectively.

Key point 2 (p.2) corresponds to the deformations in the main part of the cylinder which are slightly smaller than deformations in pp. 1 and 5.

Point 4 (p. 4) is located at the position of the first seal on the side of the piston cavity of the hydraulic leg. Radial deformations at this point directly form a clearance to be sealed in order to prevent the flow of working fluid from the high pressure zone into the rod cavity, i.e. directly affect the tightness of the leg.

Key point 3 (p.3) is located on the deformation curve having the minimum value with a (-) sign. If this point is located within the limits of the piston, the excess of deformations in it (dR_3) of the total tolerance zone for the manufacture of the piston and cylinder will lead to damage to the working cylinder mirror in the form of longitudinal scratches through which leakages of the hydraulic fluid will occur. This will make it impossible for the leg to perform its main functions in supporting the roof and controlling the rock pressure.

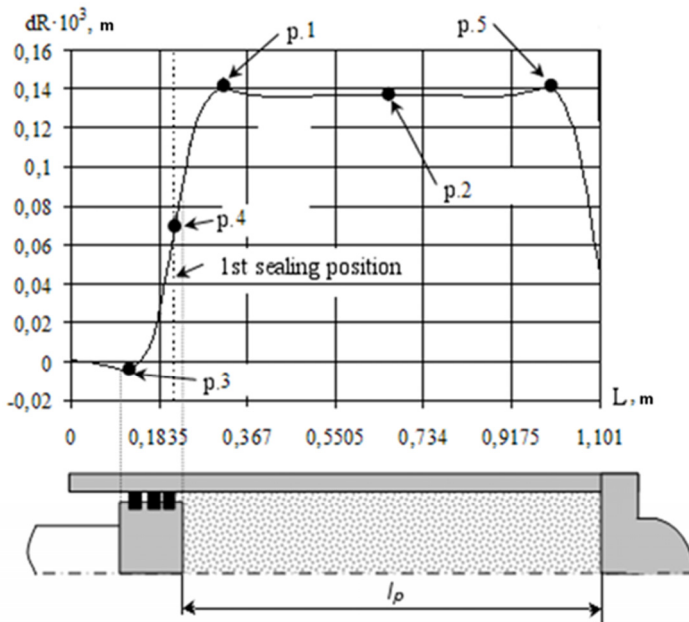


Fig. 1. Example of radial deformations (dR) of the working cylinder of M130 support hydraulic leg along the length of the working cylinder (L) at its full extension (l_p), working liquid pressure 50 MPa, and location of key points (p.1-p.5)

The value of radial deformations of the working cylinder in the area of the sealing gap (dR_4) is also determined by the pressure of the working fluid in the piston cavity of the hydraulic leg and its expansion. These dependences are linear in nature and they are shown for hydraulic legs of different types of powered supports in Fig. 2 and Fig.3.

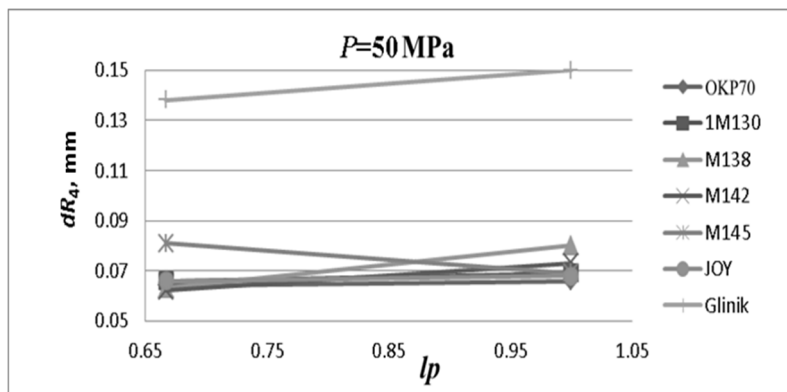


Fig. 2. Dependences of radial deformations of the working cylinder in the area of sealing (dR_4) on pressure of the working liquid in the piston cavity of the leg (P) at its full extension (lp)

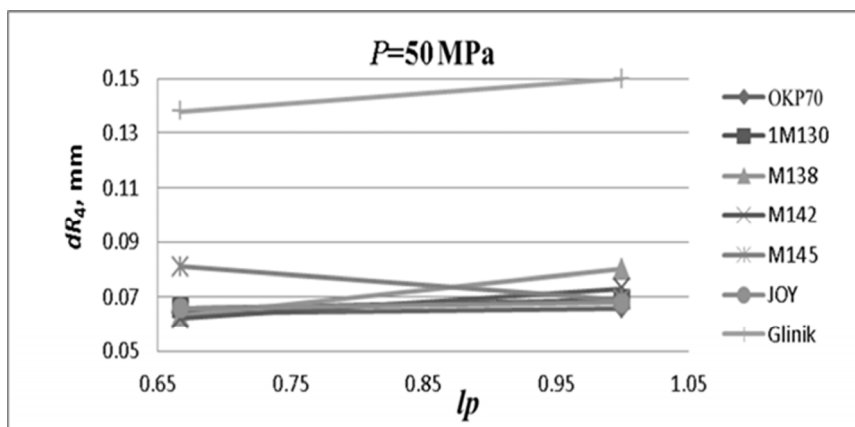


Fig. 3. Dependences of radial deformations of the working cylinder in the area of sealing (dR_4) on extension of the hydraulic leg (lp)

In order to increase the passages for the movement of miners, hydraulic legs are installed at angle α to the support elements of the support section (Fig. 4). In this case, the load on the rod and the bottom of the cylinder is applied eccentrically, that is, the direction of the forces from these loads do not coincide with the longitudinal axis of the leg. In this case, additional forces F_a and F_b arise in the leg, under the action of which the axis of the rod deviates from the axis of the cylinder by angle γ , the value of which is determined by the angle of inclination of the hydraulic leg to the support surfaces in the support section, by the leg extension, and also by the clearances in the joints between the rod and the sleeve, and clearances in the joints between the piston and the working cylinder.

The location of the hydraulic leg in the section of the powered support, the scheme of forces application, and the formation of the clearance are shown in Fig. 4.

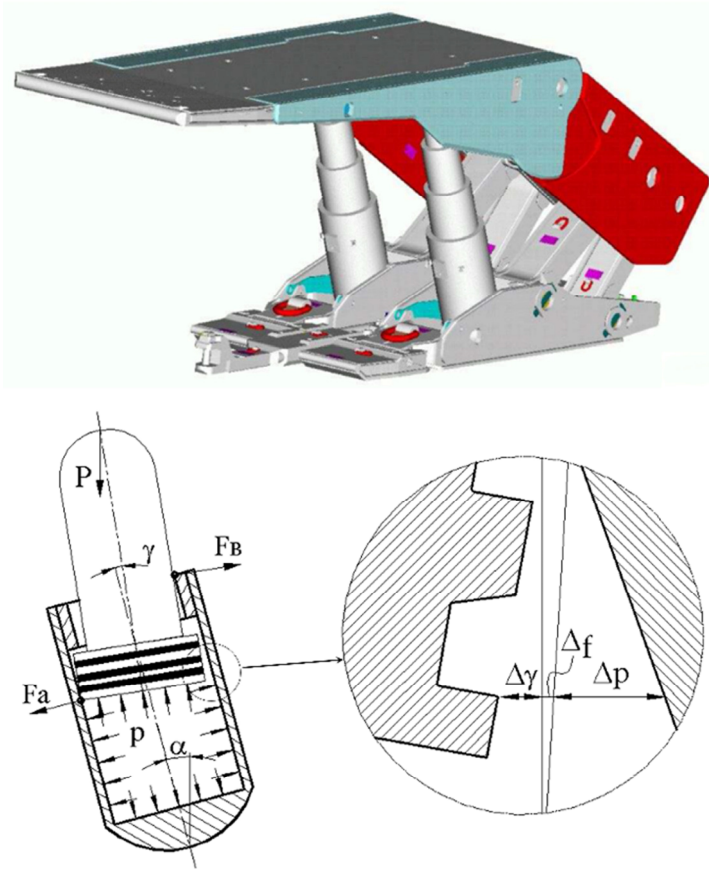


Fig. 4. Location of the hydraulic leg in the section of DBT powered support крепи DBT and the scheme of a sealing clearance formation when rod misalignment occurs

Due to its kinematic connections, the angle of installation of the hydraulic leg in the support section (α) also depends on the extracting seam thickness, i.e. in fact, on the leg extension.

To study the effect of the parameters of this phenomenon, a special finite element model was developed that takes into account the geometric dimensions of the cylinder, piston, rod, bush, leg extension, the direction of the external load from the rod and cylinder supports, the pressure of the working fluid in the piston cavity, the clearances between the piston and the cylinder, as well as between the rod and the bushing, determined by their tolerance zones, and the properties of the cylinder material.

The solution was carried out in two stages. First, the deformations of the cylinder from the action of the working fluid pressure (Δp) were identified, the identified values were used to define forces F_a and F_b (see Figure 4), arising in the joints due to the misalignment of the rod and the cylinder. After this, the final calculation is performed and the total deformations from all loads ($\Delta p + \Delta f$) are determined.

The total largest clearance to be sealed is

$$\Delta = \Delta\gamma + \Delta p + \Delta f,$$

where $\Delta\gamma$ – the clearance determined by the dimension tolerance zones and mutual location of the piston in relation to the cylinder;

Δp – radial deformations caused by working fluid pressure;

Δf – radial deformations caused by the additional forces F_a and F_b resulting from misalignment of the rod in relation to the cylinder.

Fig. 5 shows the results of the calculations made using the model described above applied to displacement (dR) of the internal walls of the working cylinder (1 and 3) of the hydraulic leg (M130 powered support) along its length (L) at the nominal operating resistance, zero installation angle, maximum extension and sealing of the cylinder support. The symmetry axis displacement is shown as a dotted line (2).

Analysis of calculation results showed that the initial maximum possible clearance in the compaction area determined by the tolerance zones of the cylinder and piston ($280 \mu\text{m}$) increased under load up to $490 \mu\text{m}$ (on the right side in Figure 4), which could result in its insufficient overlapping by the piston seals.

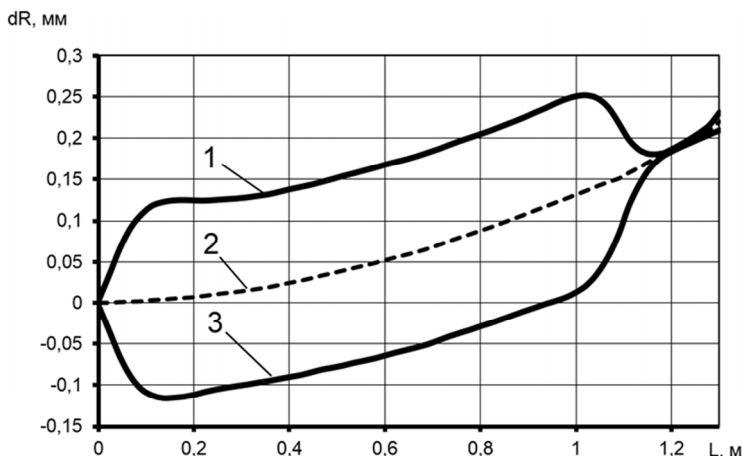


Fig. 5. Displacements of M130 leg cylinder walls dR under load taking into account rod misalignment

For double- and triple-acting legs, this effect is enhanced, because the total misalignment value is determined by the total clearances at all stages of the hydraulic leg in the joints between pistons and working cylinders and joints between bushings and rods.

When the external loads, which are dynamic or periodic in nature, influence the powered support, the frequency of these influences can coincide with the natural oscillation frequency of both the hydraulic leg and the system as a whole "support section - roof - coal seam" [10-15]. In this case, a phenomenon of resonance may occur, in which the radial deformations are further increased reducing the tightness of the legs.

Such loads are possible during secondary settling of the main roof when periodic fluctuations of fragile rock blocks occur. In addition, the frequency component of the load on the support can be transferred from the closely located rotating cutting body of the shearer crushing the coal mass of the seam.

As shown by theoretical studies, the frequencies of natural oscillations of the "powered support-roof-seam" system are close to the possible frequencies of external loads, and, consequently, the development of resonant phenomena has a very high probability.

3 Results and discussions

From all said above, it is possible to highlight main factors affecting the radial deformations of the working cylinders of hydraulic legs and formation of clearances that are to be relia-

bly sealed to prevent loss of legs tightness and to maintain the working capacity of the complete set of mining equipment.

Fig. 6 shows the main factors that form the size of sealed clearances on hydraulic legs of the powered supports. Arrows indicate the direction of the subordination of factors and their increasing impact. For example, the frequency of natural oscillations (2) is determined by the geometric parameters (4) and the pressure of the working fluid (8).

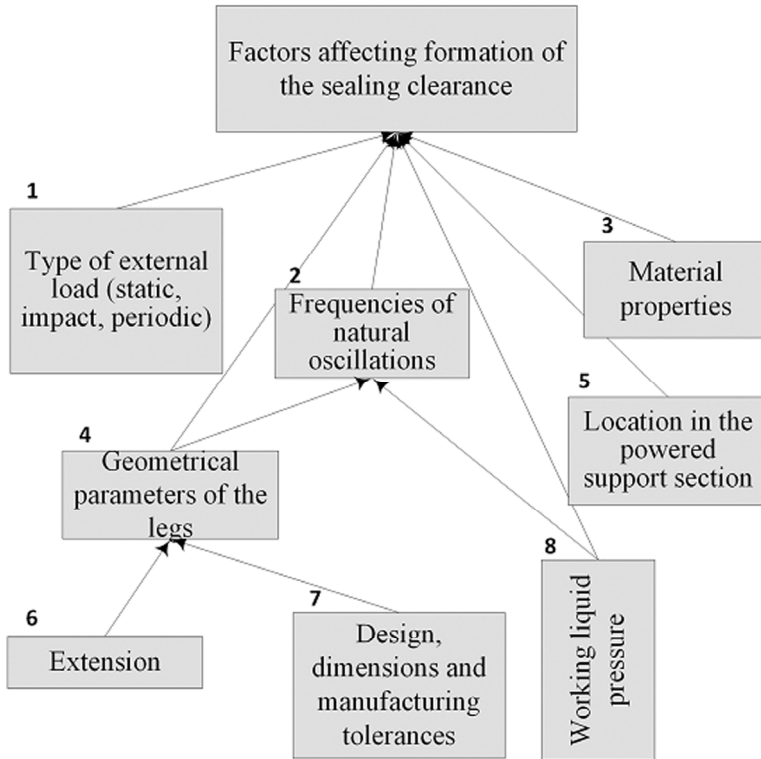


Fig. 6. Classification of factors affecting formation of the sealing clearance of the hydraulic leg

4 Conclusions

The size of the sealing clearance in the hydraulic legs of the powered supports is determined by their strength and geometric parameters, their location in the support section, properties of the materials and the type of external load. The integrated record of these parameters for the specific operating conditions of the mining set of equipment will help to avoid loss of tightness of the main support assembly and increase reliability and safety of mining operations.

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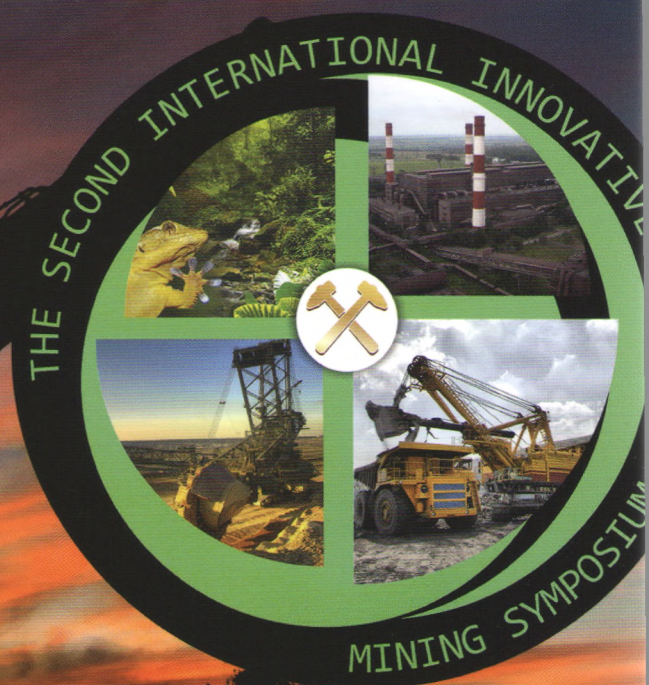
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Edited by:

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Contents

00001 Preface: Innovative Competencies of Mining engineers in Transition to the Sustainable Development

A. Krechetov, A. Khoreshok and V. Blumenstein

00002 Preface: From Mining Innovations to Sustainable Development: Keynote Speakers of the First to the Second International Innovative Mining Symposium

M. Cehlár, J. Janočko, N. Demirel, S. Anyona, S. Vöth, M. Tyulenev and S. Zhironkin

Environment Saving Mining Technologies

01001 Gas Hydrates of Coal Layers as a Methane Source in the Atmosphere and Mine Working

V. Dyrdin, S. Shepeleva and T. Kim

01002 The Mine Working's Roof Stress-strain State Research in the Perspective of Development of New Coal Deposits of Kuzbass

S. Kostyuk, N. Bedarev, O. Lyubimov and A. Shaikhislamov

01003 Carbon-Containing Waste of Coal Enterprises in Magnetic Sorbents Technology

E. Kvashevaya, E. Ushakova and A. Ushakov

01004 Predicting the Possibility for Deep Hydroprocessing of Some Kuzbass Coals

I. Petrov and B. Tryasunov

01005 Development and Substantiation of Parameters of Environmentally Friendly Technology for Filling the Vertical Mine Workings with Autoclaved Slag-Concrete

A. Uglyanitca and K. Solonin

01006 Rock Deformation Behavior Near Excavations Under the Influence of High Tectonic Stress in Coal Seam V-12, "Severnaya" Mine, JSC "Urgalugol"

P. Grechishkin, E. Razumov, O. Petrova, A. Kozlov and E. Aushev

01007 New Technical Solution for Vertical Shaft Equipping Using Steel Headframe of Multifunction Purpose

E. Kassikhina, V. Pershin and Y. Glazkov

01008 Research of the Quality of Quarry Dumpers Engine Crankshafts Sliding Bearings of Various Manufacturers

A. Korotkov, L. Korotkova and D. Vidin

01009 New Opportunities to Expand Information on Intense-Strained State of the Earth's Crust in the Areas of Development Mineral Resources During Monitoring Creation

V. Pershin and A. Solovitskiy

- 01010 The Extent of Destruction Zones Within Protective Pillars in Jsc “Suek-Kuzbass” Underground Mines
N. Pirieva and I. Ermakova
- 01011 Prerequisites for the Establishment of the Automated Monitoring System and Accounting of the Displacement of the Roof of Underground Mines for the Improvement of Safety of Mining Work
A. Abramovich, E. Pudov and E. Kuzin
- 01012 Increasing Stability of Mine Surface Facilities on the Fill-Up Ground
M. Sokolov and S. Prostov
- 01013 Logistic Principles Application for Managing the Extraction and Transportation of Solid Minerals
A. Tyurin
- 01014 Promising Technologies of Mining and Processing of Solid Minerals
S. Shabaev, S. Ivanov and E. Vakhianov
- 01015 Three-Dimensional Computer Simulation as an Important Competence Based Aspect of a Modern Mining Professional
O. Aksenova and A. Pachkina
- 01016 Unmanned Mine of the 21st Centuries
I. Semykina, A. Grigoryev, A. Gargayev and V. Zavyalov
- 01017 Determination of the Geometric Form of a Plane of a Tectonic Gap as the Inverse Ill-posed Problem of Mathematical Physics
D. Sirota and V. Ivanov
- 01018 Parameters of Solidifying Mixtures Transporting at Underground Ore Mining
V. Golik and Y. Dmitrak
- 01019 Drilling Rig Operation Mode Recognition by an Artificial Neuronet
F. Abu-Abed and N. Borisov
- 01020 Perspectives for application of moulded sorption materials based on peat and mineral compositions
O. Misnikov
- 01021 Technogenic Rock Dumps Physical Properties’ Prognosis via Results of the Structure Numerical Modeling
S. Markov, V. Martyanov, E. Preis and A. Abay
- 01022 Modeling of Energy-saving System of Conditioning Mine Air for Shallow Underground Mines
A. Nikolaev, T. Miftakhov and E. Nikolaeva

- 01023 Knowledge Assessment Software in Mining Specialist Training
V. Lebedev and O. Puhova
- 01024 Modeling of Three Flat Coal Seams Strata Developing at Open Pit Mining
T. Gvozdkova, S. Markov, N. Demirel and S. Anyona
- 01025 Parameters of Transportation of Tailings of Metals Lixiviating
V. Golik and Y. Dmitrak
- 01026 Ecological and Economic Prerequisites for the Extraction of Solid Minerals from the Bottom of the Arctic Seas
A. Myaskov and A. Gonchar
- 01027 Efficiency of Low-Profile External Dumping at Open Pit Coal Mining in Kemerovo Region
A. Selyukov, V. Ermolaev and I. Kostinez
- 01028 Numerical Simulation of Aerogasdynamics Processes in a Longwall Panel for Estimation of Spontaneous Combustion Hazards
S. Meshkov and A. Sidorenko
- 01029 The Development of Environmentally Friendly Technologies of Using Coals and Products of Their Enrichment in the Form of Coal Water Slurries
V. Murko and V. Hamalainen
- 01030 Assessing the Effects of Underground Mining Activities on High-Voltage Overhead Power Lines
V. Gusev, A. Zhuravlyov and E. Maliukhina
- 01031 Using of Wide Stopes in Coalless Zones Mined by Shovels and Backhoes
V. Kolesnikov, O. Litvin, J. Janočko and A. Efremenkov
- 01032 Intelligent Mining Engineering Systems in the Structure of Industry 4.0
M. Rylnikova, D. Radchenko and D. Klebanov
- 01033 Causes of Low Efficiency of Combined Ventilation System in Coal Mines in Resolving the Problem of Air Leaks (Inflows) Between Levels and Surface
V. Popov, Y. Filatov, Hee Lee and A. Golik
- 01034 Problem of Methane-Air Mixture Explosions in Working Faces of Coal Mines at Mining Intensification and Ways of its Solution
S. Novoselov, V. Popov, Y. Filatov, Hee Lee and A. Golik
- 01035 Coal Squeezing-Out, its Description and Conditions of Development
S. Kostyuk, A. Gegreen, V. Meljnik and M. Lupeey

Environment Problems in Mining Regions

- 02001 Energy and Resource-Saving Sources of Energy in Small Power Engineering of Siberia
M. Baranova
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V. Efremenko, R. Belyaevsky and E. Skrebneva
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M. Basarygin
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S. Prostov and E. Shabanov
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M. Baev, V. Khyamyalyaynen and A. Shevtsov

02019 Increasing the Reliability of the Work of Artificial Filtering Arrays for the Purification of Quarry Waste Water

M. Tyulenev, Y. Lesin, O. Litvin, E. Maliukhina and A. Abay

02020 Organizational-Legal and Technological Aspects of Ensuring Environmental Safety of Mining Enterprises: Perspective Analysis in the Context of the General Enhancement of Environmental Problem

E. Vorontsova, A. Vorontsov and Y. Drozdenko

02021 Belt Aligning Revisited

V. Yurchenko

02022 Spectral Study of Modified Humic Acids from Lignite

S. Zhrebtsov, N. Malyschenko, L. Bryukhovetskaya and Z. Ismagilov

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03001 Substantiation of the Necessity for Design of Geohod Control System

V. Aksenov, I. Chicherin, I. Kostinez, A. Kazantsev and A. Efremenkov

03002 Dependence of Reliability and Resource of the Elements of the Design of Quarry Automatics with the Degrees of their Downloads

D. Stenin and N. Stenina

03003 Functional Quality Criterion of Rock Handling Mechanization at Open-pit Mines

Y. Voronov and A. Voronov

- 03004 Definition of Static Voltage Characteristics of the Motor Load for the Purpose of Increase in Energy Efficiency of Coal Mines of Kuzbass
F. Nepsha and V. Efremenko
- 03005 Disk Rock Cutting Tool for the Implementation of Resource-Saving Technologies of Mining of Solid Minerals
L. Mametyev, A. Khoreshok, A. Tsekhin and A. Borisov
- 03006 Technical Diagnostics of Ventilation Units for Energy Efficiency and Safety of Operation
E. Kuzin, V. Shahmanov and D. Dubinkin
- 03007 Load Cases Relevant for Proof of Competence of Fast Running Hoists
S. Vöth
- 03008 The Influence of Parameters on the Generatrix of the Helicoid Form Guide of Geokhod Bar Working Body
V. Aksenov, V. Sadovets and D. Pashkov
- 03009 Application of Mathematical and Three-Dimensional Computer Modeling Tools in the Planning of Processes of Fuel and Energy Complexes
O. Aksenova, E. Nikolaeva and M. Cehlár
- 03010 Justification of the Shape of a Non-Circular Cross-Section for Drilling With a Roller Cutter
G. Buyalich and M. Husnutdinov
- 03011 Improving the Repair Planning System for Mining Equipment on the Basis of Non-destructive Evaluation Data
M. Drygin and N. Kuryshkin
- 03012 The Raising Influence of Information Technologies on Professional Training in the Sphere of Automated Driving When Transporting Mined Rock
A. Kosolapov and S. Krysin
- 03013 Estimation of Energy Efficiency of Means of Transport According to the Results of Technical Diagnostics
A. Shalkov and M. Mamaeva
- 03014 Innovations of Engineering Company and Competitiveness in the Mining Equipment Market
V. Pogrebnoi, L. Samorodova, L. Shut'ko, Y. Yakunina and O. Lyubimov
- 03015 Increasing the Technical Level of Mining Haul Trucks
Y. Voronov, A. Voronov, S. Grishin and A. Bujankin
- 03016 Forecasting of a Thermal Condition of Pneumatic Tires of Dump Trucks
A. Kvasova, B. Gerike, E. Murko and D. Skudarnov

03017 Perfection of Methods of Mathematical Analysis for Increasing the Completeness of Subsoil Development

M. Fokina

03018 Factors Determining the Size of Sealing Clearance in Hydraulic Legs of Powered Supports

G. Buyalich, K. Buyalich and M. Byakov

Mining Regions' Sustainable Development

04001 Individual Learning Route as a Way of Highly Qualified Specialists Training for Extraction of Solid Commercial Minerals Enterprises

E. Oschepkova, I. Vasinskaya and I. Sockoluck

04002 Sustainable Development vs. Post-Industrial Transformation: Possibilities for Russia

S. Zhironkin, M. Gasanov, G. Barysheva, E. Gasanov, O. Zhironkina and G. Kayachev

04003 Neo-Industrial and Sustainable Development of Russia as Mineral Resources Exploiting Country

M. Prokudina, O. Zhironkina, O. Kalinina, M. Gasanov, F. Agafonov

04004 Viral Management as a New Type of Enterprise Management in Coal Industry

O. Garafonova, S. Grigashkina and A. Zhosan

04005 The Regional-Matrix Approach to the Training of Highly Qualified Personnel for the Sustainable Development of the Mining Region

E. Zhernov and E. Nehoda

04006 Improvement of the System of Training of Specialists by University for Coal Mining Enterprises

V. Mikhailchenko and I. Seredkina

04007 The Concept of Resource Use Efficiency as a Theoretical Basis for Promising Coal Mining Technologies

V. Mikhailchenko

04008 Ideological Paradigms and Their Impact on Environmental Problems Solutions in Coal Mining Regions

V. Zolotukhin, N. Zolotukhina, M. Yazevich, A. Rodionov and Marina Kozyreva

04009 The Prospects of Accounting at Mining Enterprises as a Factor of Ensuring their Sustainable Development

T. Tyuleneva

04010 Tools of Realization of Social Responsibility of Industrial Business for Sustainable Socio-economic Development of Mining Region's Rural Territory

T. Jurzina, N. Egorova, N. Zaruba and P. Kosinskij

- 04011 Score Mining Rents in Terms of Investment Attractiveness of Peat Mining
G. Alexandrov and A. Yablonev
- 04012 Mastering Foreign Language Competence of Ecology and Environment Managers for Mining Industry of Kuzbass
O. Greenwald, R. Islamov and T. Sergeychick
- 04013 NBIC-Convergence as a Paradigm Platform of Sustainable Development
E. Dotsenko
- 04014 Sustainable Development Strategy for Russian Mineral Resources Extracting Economy
E. Dotsenko, N. Ezdina, A. Prilepskaya and K. Pivnyk
- 04015 Humanity and Environment Co-influence in the Shadow of Technological Convergence
N. Ezdina
- 04016 Modern Trends of Additional Professional Education Development for Mineral Resource Extracting
O. Borisova, V. Frolova and E. Merzlikina
- 04017 Corporate Social and Ecological Responsibility of Russian Coal Mining Companies
N. Ravochkin, V. Shchennikov and V. Syrov
- 04018 Diversification of the Higher Mining Education Financing in Globalization Era
V. Frolova, O. Dolina and T. Shpil'kina
- 04019 Andragogical Model in Language Training of Mining Specialists
E. Bondareva, G. Chistyakova, Y. Kleshevskyi, S. Sergeev and A. Stepanov
- 04020 Improving Occupational and Industrial Safety Management System at Coal Mining Enterprises
S. Smagina, O. Kadnikova, K. Demidenko, G. Chistyakova and A. Rolgayzer
- 04021 Education within Sustainable Development: Critical Thinking Formation on ESL Class
I. Pevneva, O. Gavrishina, A. Smirnova, E. Rozhneva and N. Yakimova
- 04022 Some Diversification Factors of Old Industrial Regions' Economy and Transition to the Innovative Development
O. Tabashnikova
- 04023 Key Trends in Institutional Changes Under Sustainable Development
O. Karpova, I. Pevneva, I. Dymova, T. Kostina and S. Li
- 04024 Integration of MOOCs in Advanced Mining Training Programmes

I. Saveleva, O. Greenwald, S. Kolomiets and E. Medvedeva

04025 Innovative Technological Development of Russian Mining Regions (on Example of Kemerovo Region)

E. Shavina and O. Kalenov

04026 Age-Sex Structure of the Population and Demographic Processes in Environmentally Challenged Mining Region (on the example of Kemerovo region)

T. Leshukov, O. Brel, A. Zaytseva, Ph. Kaizer and K Makarov

04027 The Distribution of the Informative Intensity of the Text in Terms of its Structure (On Materials of the English Texts in the Mining Sphere)

L. Znikina and E. Rozhneva

04028 Training of Engineering Personnel for the Innovative Coal Industry: Problems and Ways of Solution

N. Zaruba, T. Fraltsova and T. Snegireva

04029 Innovative Model of Practice-Oriented Training of Employees of the Town-Forming Enterprise in the Mining Region (by the Example of JSC "SUEK-Kuzbass")

S. Kulay and G. Kayachev

04030 Improvement and Development of the Motivation System in the Occupational and Industrial Safety Field

A. Pavlov and D. Gavrilov

The sustainable development of mining regions requires synchronous impetus of innovations in mineral resources extracting and processing, environment protection technologies, mining machinery and social-and-economic activities. The whole industrial complex of the region including subsoil use, modernization of mining equipment and the development of human capital should become a platform for sustainable development. The aim of The 11nd International Innovative Mining Symposium (Devoted to Russian Federation Year of Environment) is to create a workshop for international discussion of urgent issues of resource sector's environment-friendly development worldwide by specialists, experts and researchers. The leading role in this discussion belongs to the mineral resource universities – the centers of innovative development of the mining regions.

ISBN: 978-2-7598-9026-2



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11nd International Innovative Mining Symposium (Devoted to Russian Federation Year of Environment), 20-22 November 2017, Kemerovo, Russian Federation

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