

D1 9 9 6RYER START UP QUICK REFERENCE GUIDE

**PNEG-523
1000, 2000 & 3000 SERIES
DRYER MODELS**

AIRSTREAM
a division of
THE GSI GROUP



DRYER START UP REFERENCE GUIDE

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PRIOR TO INSTALLATION, PURCHASER HAS THE RESPONSIBILITY TO RESEARCH AND COMPLY WITH ALL FEDERAL, STATE AND LOCAL CODES WHICH MAY APPLY TO THE LOCATION AND INSTALLATION.

ROOF WARNING, OPERATION & SAFETY

ROOF DAMAGE WARNING AND DISCLAIMER



GSI DOES NOT WARRANT ANY ROOF DAMAGE CAUSED BY EXCESSIVE VACUUM OR INTERNAL PRESSURE FROM FANS OR OTHER AIR MOVING SYSTEMS. ADEQUATE VENTILATION AND/OR "MAKEUP AIR" DEVICES SHOULD BE PROVIDED FOR ALL POWERED AIR HANDLING SYSTEMS. GSI DOES NOT RECOMMEND THE USE OF DOWNWARD FLOW SYSTEMS (SUCTION). SEVERE ROOF DAMAGE CAN RESULT FROM ANY BLOCKAGE OF AIR PASSAGES. RUNNING FANS DURING HIGH HUMIDITY/COLD WEATHER CONDITIONS CAN CAUSE AIR EXHAUST OR INTAKE PORTS TO FREEZE.

DRYER OPERATION

Thank you for choosing a GSI/Airstream product. It is designed to give excellent performance and service for many years.

This manual describes the start up of Airstream Portable Dryers, including the 1000, 2000 and 3000 series models. If the unit is installed and operated properly, according to specification, you can

be assured many years of service.

The principal concern of the GSI Group, Inc. ("GSI") is your safety and the safety of others associated with grain handling equipment. This manual is written to help you understand safe operating procedures, and some of the problems that may be encountered by the operator or other personnel.

As owner and/or operator, it is your responsibility to know what requirements, hazards and precautions exist, and to inform all personnel associated with the equipment, or who are in the fan area. Avoid any alterations to the equipment. Such alterations may produce a very dangerous situation, where serious injury or death may occur.

SAFETY ALERT SYMBOL

The symbol shown is used to call your attention to instructions concerning your personal safety. Watch for this symbol; it points out important safety precautions. It means "ATTENTION", "WARNING", "CAUTION", and "DANGER". Read the message and be cautious to the possibility of personal injury or death.



WARNING! BE ALERT!

Personnel operating or working around electric fans should read this manual. This manual must be delivered with the equipment to its owner. Failure to read this manual and its safety instructions is a misuse of the equipment.

SAFETY ALERT DECALS

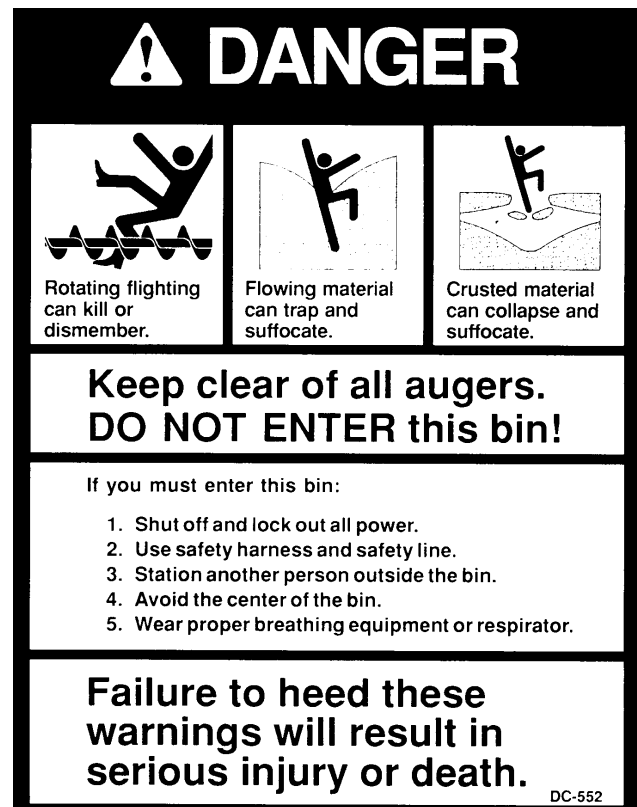
Grain Systems, Inc. recommends contacting your local power company, and having a representative survey your installation so the wiring is compatible with their system, and adequate power is supplied to your unit.

Safety decals should be read and understood by all people in the grain handling area. The bottom right decal should be present on the inside bin door cover of the two ring door, 24" porthole door cover and the roof manway cover.

If a decal is damaged or is missing contact:

Grain Systems, Inc.
1004 E. Illinois St.
Assumption, IL 62510
217-226-4421

A free replacement will be sent to you.



START UP PROCEDURE

Standard electrical safety practices and codes should be used when working with a dryer. Refer to the National Electric Code Standard Handbook by the National Fire Protection Association. *A qualified electrician should make all wiring installations.*



**ALWAYS DISCONNECT
AND LOCK OUT POWER
BEFORE WORKING ON OR
AROUND DRYER**

FULL START UP CHECK

This start up procedure assumes the following:

1. That you have read and understand the DRYER OPERATION AND SERVICE MANUAL.
2. That you have taken special note of all SAFETY PRECAUTIONS.
3. That all safety shields are in place.
4. That all meter roll access doors have been opened and all foreign objects have been removed.
5. That you have done a pre-start up check out.
6. That all motors have been checked for proper rotation.
7. That all heaters have been test fired.
8. That the fuel has been turned on at the tank.
9. That the electric power has been turned on.
10. That the main disconnect switch on the dryer is on.
11. That you have wet grain in the wet holding bin.
12. That you know the incoming grain moisture.
13. That you have the dry grain take away equipment in place.
14. That you have the grain going to the proper bin.
15. That all switches have been set to the off position.
16. That the load mercury switch box is installed with the side stamped up, in the up position.

FILLING THE DRYER

1. Turn the green CONTROL POWER knob to ON. It should light up, go through 4 screens and end with the time and date.
2. Turn the DRYING MODE switch to CONTINUOUS FLOW.
3. Push the RESET on the computer key pad to activate the computer.
4. Make sure the UNLOAD switch is in the OFF position.
5. Push the DRYER POWER start switch, it should light up.
6. Turn the LOAD AUGER switch to the MANUAL position to fill the dryer. The load auger should start and run until the dryer is full, then shut off automatically. (If the switch is set to the AUTO position the dryer will shut down each time the out of grain timer times out, and will have to be restarted.)
7. When the dryer has filled, turn the LOAD AUGER switch to the AUTO position.

START UP PROCEDURE

STARTING THE DRYER

This start up procedure is for a cold start on wet grain for continuous flow operation.

1. Set the MAXON or FAST ACTION HAND VALVE on the incoming fuel line to the ON position.
2. Make sure the MOISTURE CONTROL switch is in the OFF position.
3. Turn the FAN switch (or switches if a multi-fan dryer) to the ON position. The light in the switch should light when the fan comes up to about half speed.
4. Adjust the AIR PRESSURE SWITCH if necessary.
5. Turn the HEATER switch (or switches if a multi-fan dryer) to the ON position. The heater will purge for about 10 seconds then ignite. The light in the heater switch will come on during ignition and will stay on if the heater ignites. If the heater does not ignite, the light will go out after trial for ignition and the dryer will shut down, indicating that it did not light. If this happens check gas supply, and all valves in the fuel line to make sure they are ON.

ADJUSTING THE TEMPERATURE

1. Set the HI-LOW FIRE PLENUM THERMOSTAT on the left side of the dryer to the drying temperature that you want to run (180 deg. to 200 deg.). On multiple fan dryers set the heat chambers 30 to 60 degrees apart. Hottest at the top, most cool at the bottom.
2. On LP gas models adjust the PRESSURE REGULATOR (high fire) on the burner fuel line, so that burner will reach the thermostat setting and switch to (low fire) (pressures may be required up to 25 lbs.). Natural gas does not have a regulator, but uses a LARGE BALL VALVE close to the vertical supply line for adjustment (pressures may be required up to 18 lbs.).
On LP gas models adjust the small RED HANDLED BALL VALVE (low fire) so that the burner maintains flame then switches back to (high fire). Natural gas has a BALL VALVE close to the burner control box, for low fire adjustment.
3. Adjust the burner pressure so that the burners CYCLES 4 times per minute (approx. 10 sec. on HIGH--approx. 5 sec. on LOW). When on HIGH FIRE increasing the pressure with the pressure regulator **DECREASES** the time spent on high fire. When on LOW FIRE increasing the low fire pressure with the RED BALL VALVE **INCREASES** the time spent on low fire.
4. On LP gas models adjust the VAPORIZER so the fuel pipes going to the burner from the regulator are warm to the touch (not hot and cold).

How much gas pressure do I use? See step number two in the *Adjusting The Temperature* section.

How often should my burner cycle? See step number three in the *Adjusting The Temperature* section.

START UP PROCEDURE

How often do I make speed adjustment? See step number ten in the *Full Heat-Continuous Flow Operation* section.

The vaporizer can be adjusted two ways. First, by loosening the bolt in the hinging mechanism and swinging it to a hotter or cooler position. Second, by loosening the two bolts in the hinge pipe and sliding the vaporizer in or out to a cooler or hotter position. Either one or both methods may have to be used to get the vaporizer to the proper temperature. Natural gas does not use a vaporizer.

FULL HEAT-CONTINUOUS FLOW OPERATION

1. Look in your operators manual in the DRYER START UP section (CONTINUOUS FLOW METER ROLL SETTINGS-FULL HEAT). You will see the settings for (Initial Moisture) (Moisture Removed) (Approx. Dry Time) (1 Speed) (2 Speed Low) (2 Speed High) pick the line that has your initial starting moisture. These are the settings we will be referring to during this start up procedure.
2. Make sure the UNLOAD switch is OFF.
3. Make sure the MOISTURE CONTROL switch is OFF.
4. Run the fan(s) and heater(s) for about 10% longer than the (APPROX. DRYING TIME) required for the moisture you are trying to dry.
5. Example: 10% removal would be about 54 minutes, 15% removal would be about 76 minutes and 20% removal would be about 100 minutes. Add 10 minutes to insure that the grain is dry.
6. After the time in step 4 turn the UNLOAD to 1 SPEED and set the METER ROLL SPEED, (HIGH SPEED) pot. to the setting for 1 SPEED operation. Grain should begin to run at this time. Run time for this is about 10% longer than the (APPROX. DRYING TIME) required for the moisture you are trying to dry, as shown in the example #5 above. This allows the moisture in the dryer to reach an even gradient top to bottom without having any highs or lows in it. It will however, over dry some of the corn a little.
7. Increase the drying temperature to 190 deg. for single fans or for multiple fan dryers set the heat chambers 30 to 60 degrees apart. Hottest at the top, most cool at the bottom.
8. DO NOT TRY TO ADJUST THE DRYER FOR MOISTURE DURING THIS PROCESS OR YOU WILL ESTABLISH HIGH AND LOW SWINGS IN THE MOISTURE CONTROL. IT WILL TAKE SEVERAL HOURS TO WORK ITSELF OUT.
9. After the run time in step 6 you are ready to set up the moisture control. Now turn the MOISTURE CONTROL to the ON position. Set the temperature to about 100 deg.
10. Turn the UNLOAD to 2 SPEED. Set the METER ROLL SPEED, LOW SPEED and HIGH SPEED pots. to the settings listed for them. Let the dryer run on these settings as shown in the example #5 before trying to

START UP PROCEDURE

adjust moisture or meter roll settings. These settings will not have your grain moisture adjusted exactly where you want it, but will be a good place to start initially. A little different moisture at the bottom of the storage bin is not usually a problem as long as you have full floor aeration.

11. After the run time in step 10 you are ready to adjust the moisture control, and the meter roll speeds if required. Each time you make an adjustment to the moisture control it will take about the time shown in example #5 to see the results of this adjustment.

I 100 & I 200 SERIES CONTINUOUS FLOW METERING ROLL SETTINGS

Initial Moisture	Moisture Removed	Full Heat			
		Approx. Dry Time	1 Speed	2 Speed Low	2 Speed High
17%	2 pts.	16 min.	625	317	875
18%	3 pts.	21 min.	476	270	775
19%	4 pts.	26 min.	385	241	675
20%	5 pts.	31.5 min.	317	213	575
21%	6 pts.	37 min.	270	196	476
22%	7 pts.	41.5 min.	241	185	385
23%	8 pts.	47 min.	213	172	317
24%	9 pts.	51 min.	196	161	270
25%	10 pts.	54 min.	185	150	241
26%	11 pts.	58 min.	172	140	213
27%	12 pts.	62 min.	161	132	196
28%	13 pts.	66.5 min.	150	123	185
29%	14 pts.	71.5 min.	140	116	172
30%	15 pts.	76 min.	132	110	161
31%	16 pts.	81 min.	123	104	150
32%	17 pts.	86 min.	116	100	140
33%	18 pts.	91 min.	110	096	132
34%	19 pts.	96 min.	104	087	123
35%	20 pts.	100 min.	100	082	116

These are approximate starting points.

START UP PROCEDURE

DRY AND COOL- CONTINUOUS FLOW OPERATION FOR DRYERS WITH TWO OR MORE FANS

1. Look in your operators manual in the DRYER START UP section (CONTINUOUS FLOW METER ROLL SETTINGS-DRY & COOL). You will see the settings for (Initial Moisture) (Moisture Removed) (Approx. Dry Time) (1 Speed) (2 Speed Low) (2 Speed High) pick the line that has your initial starting moisture. These are the settings we will be referring to during this start up procedure.
2. Make sure the UNLOAD switch is OFF.
3. Make sure the MOISTURE CONTROL switch is OFF.
4. Run the bottom fan(s) and heater(s) (to be used for cooling later) for about 20 minutes. This will start the bottom drying so we can cool it before we begin to discharge grain.
5. Take the remaining number of burners to be started, divide that into the total drying time required, working up, start each burner that many minutes apart. Run them about 10% longer than the (APPROX. DRYING TIME) total required for the moisture you are trying to dry.
6. Example: 10% removal would be about 60 minutes, 15% removal would be about 85 minutes, and 20% removal would be about 110 minutes. Add 10 minutes to insure that the grain is dry.
7. After the required drying time turn the bottom heater (OFF) cool this section for about 20 minutes. Set the upper plenum thermostats to the decreed temperature (190°-230°F)
8. Turn the UNLOAD to 1 SPEED and set the METER ROLL SPEED (HIGH SPEED) pot. to the setting for 1 SPEED operation. Run time for this is about 10% longer than the (APPROX. DRYING TIME) required for the moisture you are trying to dry, as shown in the example #6. above. This allows the moisture in the dryer to reach an even gradient top to bottom without having any highs or lows in it. It will however, over dry some of the corn a little.
9. DO NOT TRY TO ADJUST THE DRYER FOR MOISTURE DURING THIS PROCESS OR YOU WILL ESTABLISH HIGH AND LOW SWINGS IN THE MOISTURE CONTROL. IT WILL TAKE SEVERAL HOURS TO WORK ITSELF OUT.
10. After the run time in step 8 you are ready to set up the moisture control. Now turn the MOISTURE CONTROL to the ON position. Set the temperature to about 130 deg.
11. Turn the UNLOAD to 2 SPEED. Set the METERING ROLL SPEED, LOW SPEED and HIGH SPEED pots. to the settings listed for them. Let the dryer run on these settings as shown in the example #6 before trying to adjust moisture or meter roll settings. These settings will not

What temperature should I dry at? See step number seven in the *Dry and Cool-Continuous Flow Operation for dryers with Two or More Fans* section.

START UP PROCEDURE

have your grain moisture adjusted to exactly where you want it, but it will be a good starting place to adjust from. A little different moisture at the bottom of the storage bin is not usually a problem as long as you have full floor aeration.

12. After the run time in step 11, you are ready to adjust the moisture control and the meter roll speeds if required. Each time you make an adjustment to the moisture control it will take about the time shown in example #6 to see the results of this adjustment.

I 100 & I200 SERIES CONTINUOUS FLOW METERING ROLL SETTINGS

Initial Moisture	Moisture Removed	Dry & Cool			
		Approx. Dry Time	1 Speed	2 Speed Low	2 Speed High
17%	2 pts.	18 min.	363	187	650
18%	3 pts.	24 min.	272	163	550
19%	4 pts.	30 min.	218	145	450
20%	5 pts.	35 min.	187	131	363
21%	6 pts.	40 min.	163	119	272
22%	7 pts.	45 min.	145	109	218
23%	8 pts.	50 min.	131	101	187
24%	9 pts.	55 min.	119	093	163
25%	10 pts.	60 min.	109	087	145
26%	11 pts.	65 min.	101	082	131
27%	12 pts.	70 min.	093	077	119
28%	13 pts.	75 min.	087	073	109
29%	14 pts.	80 min.	082	069	101
30%	15 pts.	85 min.	077	065	093
31%	16 pts.	90 min.	073	061	087
32%	17 pts.	95 min.	069	057	082
33%	18 pts.	100 min.	065	053	077
34%	19 pts.	105 min.	062	049	073
35%	20 pts.	110 min.	059	045	069

These are approximate starting points.

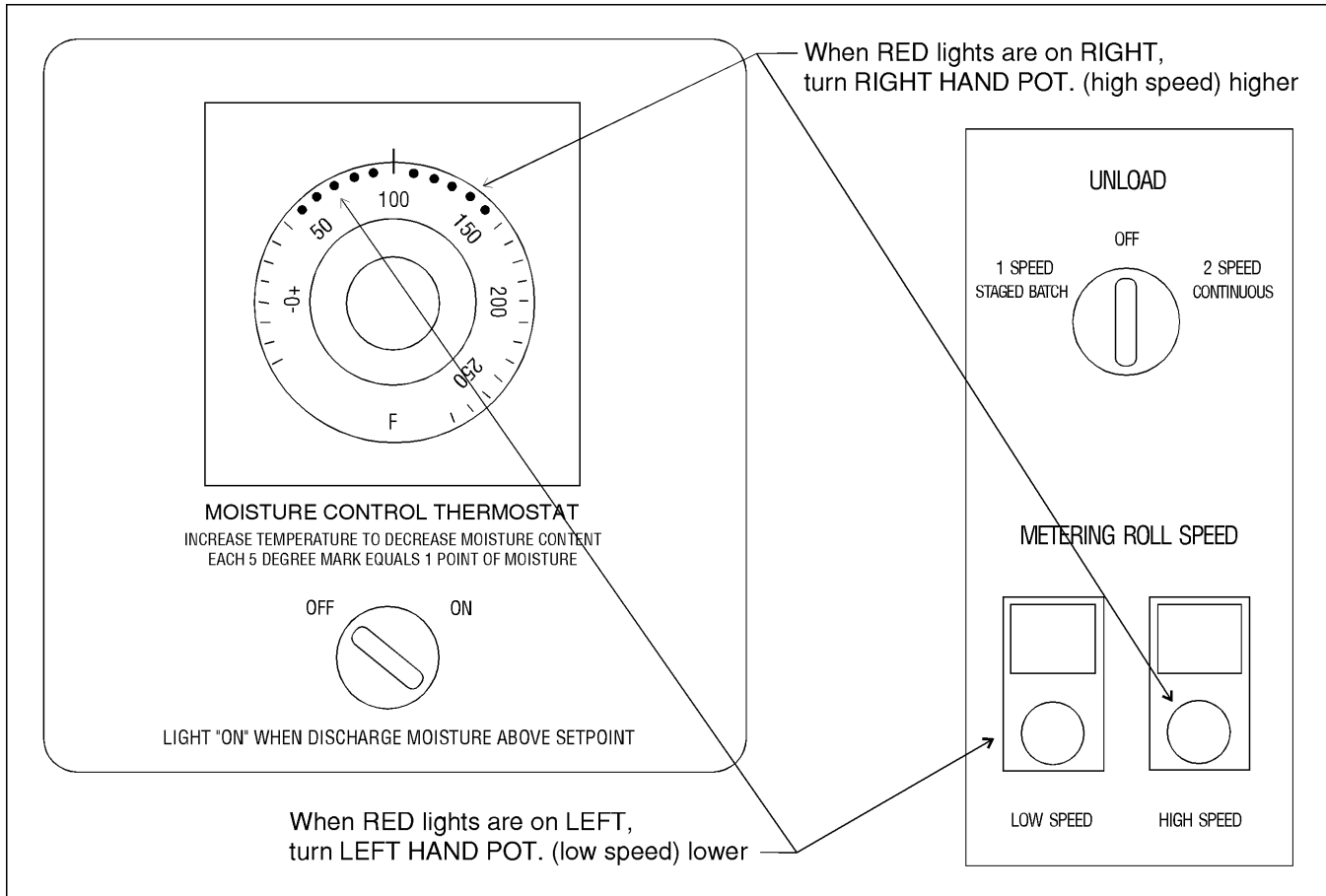
START UP PROCEDURE

How do I set my moisture control? See step number one in the *Adjusting The Moisture Control* section.

ADJUSTING THE MOISTURE CONTROL

1. Each 5 deg. on the MOISTURE CONTROL will change the output moisture by about 1%. Example: you have 100 deg. set, you are getting 16% corn out, you want 17% corn out, so you would reduce the MOISTURE CONTROL temperature by 5 deg. to 95 deg. and this should change the moisture out to about 17%. If you wanted the corn to come out dryer, you would raise the temperature on the MOISTURE CONTROL.
2. There are 4 sensors that are averaged together for sensing MOISTURE CONTROL temperature, 1 on each side of the dryer in the front, and 1 on each side of the dryer in the back. They are located about 1/3 of the way up the grain column from the bottom, and in from the side about 4 inches.
3. The small lights behind the temperatures on the MOISTURE CONTROL indicate the temperature of the grain at this sample point.
4. The 2 lights in the center are green, the lights to the right or to the left of these are red.
5. When the grain temperature has the dryer cycling HIGH and LOW speed on the green lights the moisture setting is being maintained correctly.
6. Set the METER ROLL SPEED in relation to the small red lights behind the temperatures on the MOISTURE CONTROL.
7. RED lights to the left indicate that the grain at the sample point is too cool or wetter than desired. With this condition turn the (LOW SPEED) left pot. to a lower number. This will slow down the meter rolls and dry the grain longer, warming it up.
8. RED lights to the right indicate that the grain at the sample point is too hot or dryer than desired. With this condition turn the (HIGH SPEED) right pot. to a higher number. This will speed up the meter rolls and remove the grain quicker, cooling it down.
9. If the MOISTURE CONTROL switches to LOW and only stays on low for a minute or two and switches back to HIGH, speed up the (LOW SPEED) left pot. It is set too slow.
10. If the MOISTURE CONTROL switches to HIGH and only stays on low for a minute or two and switches back to LOW, slow down the (HIGH SPEED) right pot. It is set too fast.
11. The MOISTURE CONTROL should stay on HIGH about 50% of the time and on LOW about 50%, give or take 25%. There is a broad range that will work. It should be switching low to high and back to maintain the desired moisture. A control that does not switch, will not maintain an evenly dried grain moisture, when the incoming wet grain moisture is varying.
12. When adjusting the meter roll speeds it is better not to change the speed more than 20 points at a time.

START UP PROCEDURE



QUICK START UP PROCEDURE

Please read the manual for your dryer model, before using the quick reference.

ELECTRONIC MONITORING CONTROL SYSTEM-QUICK REFERENCE

IMPORTANT! To activate the controller after turning on the control power, press the RESET button.

Setting the DRY, COOL, UNLOAD & OUT OF GRAIN timers:

- Press the DRY, COOL, UNLOAD or OUT OF GRAIN button.
- Press the MODIFY button.
- Press the INCREASE or DECREASE button to get desired setting.
- Press the ENTER button when desired setting is reached.

Setting the LOAD & UNLOAD DELAYS:

- Press the LOAD or UNLOAD button.
- Press the MODIFY button.
- Press the INCREASE or DECREASE button to get desired setting.
- Press the ENTER button when desired setting is reached.

Pressing the INCREASE and DECREASE buttons simultaneously will access the following programming features:

- SAFETY CIRCUIT SHUTDOWN LOG
- DRYER MODEL NUMBER
- FAN DELAY
- BPH FACTOR
- METERING ROLL MONITOR DISABLING FEATURE
- AIR SWITCH DISABLING FEATURE

These features are accessed sequentially as listed above. Press the INCREASE or DECREASE buttons to change a setting. Press the ENTER button to move from feature to feature.

Pressing and holding the RESET button for five (5) seconds will access the following programming features:

- CALENDAR YEAR SETTING
- CALENDAR MONTH SETTING
- CALENDAR DAY SETTING
- CLOCK HOUR SETTING
- CLOCK MINUTE SETTING
- BUSHEL COUNTER RESET
- BATCH COUNTER RESET

These features are accessed sequentially as listed above. Press the INCREASE or DECREASE buttons to change a setting. Press the ENTER button to move from feature to feature.

Changing the Marquee on the LCD display:

- Press and hold the MODIFY button while turning on the control power.
- To change a character press the INCREASE or DECREASE button.
- To move the cursor to right press the UNLOAD button.
- To move the cursor to the left press the DRY button.
- To delete a character press the COOL button.
- Press ENTER when the desired marquee is displayed.

QUICK START UP PROCEDURE

Read and understand the full start up procedure before using this quick abbreviated guide.

1. Control Power--ON
2. Drying Mode--CONTINUOUS FLOW
3. Push the computer RESET
4. Push dryer power START SWITCH
5. Unload--OFF
6. Load Auger--MANUAL, after dryer is full switch to AUTO
7. Maxon or Fast Action Hand Valve--ON
8. Moisture Control--OFF
9. Fan Switch--ON
10. Heater--ON
11. Plenum Thermostat--180 deg. to 200 deg. to start dryer
12. Adjust gas pressure regulators
13. Adjust vaporizers

Check settings listed in main manual.

STARTING THE DRYING PROCESS FOR FULL HEAT OPERATION

1. Unload--OFF
2. Moisture Control--OFF
3. Run fan and heater--designated time plus--10% to 15%
4. After 1st hour--Unload to 1 SPEED
5. Increase drying temperature--190 deg. to 230 deg. as desired
6. Readjust vaporizers if required
7. Meter roll speed (HIGH SPEED)--set as chart specifies
8. After 2nd hour--Moisture Control--ON--set at about 100 deg.
9. Unload--2 SPEED
10. Meter roll--LOW SPEED and HIGH SPEED
11. After 3rd hour--adjust moisture as required
12. Do not make corrections to the moisture more than once per hour

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