2002
GSI Drying Systems Portable Dryer Sales Manual

Effective: June 16, 2002

PNEG-561-02

a division of
THE GSI GROUP

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100 Series Dryer Features

All screens, augers, bearings and sheet metal parts are the guage as the 1200 Series Dryer. Only the electronic controls are different.

Low Profile perforated wet bin enhances preheating; Allows dryer to fit in places others cannot.

The auger drive pulley is visible through the perforated cover, to verify operation

Work light doubles as a shutdown indicator

Air mixing chambers thoroughly mix heat and air before it enters the drying chamber

Level auger mounted on oil impregnated wood hanger bearings aids in long life and dependablility

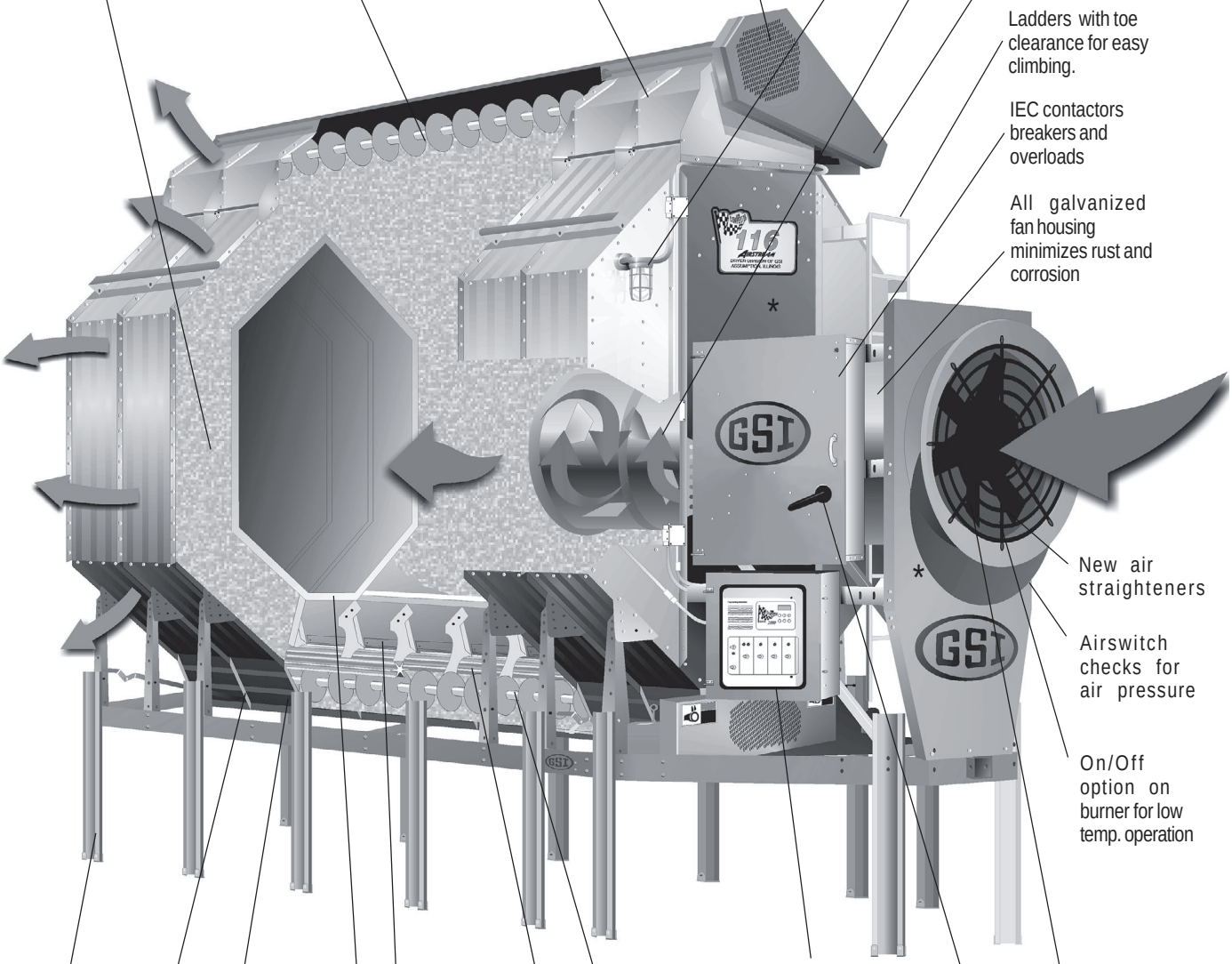
14" grain columns for maximum capacity and even, efficient drying

Turnbuckle belt tightener

Ladders with toe clearance for easy climbing.

IEC contactors breakers and overloads

All galvanized fan housing minimizes rust and corrosion



New air straighteners

Airswitch checks for air pressure

On/Off option on burner for low temp. operation

Exclusive, optional galvanized support legs

Column access doors allow for easy, fast column unloading if necessary, and access to meter rolls

Clean out doors allow easy cleaning of bottom auger

Large 15" door for access to unload auger

Adjustable gates regulate grain flow and allow manual column emptying

Heavy 8" auger with 1/4" flighting for fast unloading and longer life

Full length, aluminum meter rolls with over the top operation ensure gentle, accurate grain flow and low horse-power

State of the art 100 Series control system for trouble-free operation-no relays or moving parts

Can be easily remote mounted with only a few small control wires

All low speed composite fan blades for less noise and long life

Safety disconnect circuit breaker for safe, economical installation

Air Switch

The air switch on the dryer has been changed to a BEC type and is mounted on the front of the dryer. The air switch will be reading air pressure in the plenum instead of airflow from the fan. This will aid in problems with erratic air movements and blockage of the air tube.

Entrelec Terminals

Entrelec terminals are used for all computer control circuits connections.

Two Transformers in 440 Volt Dryers

Control transformer wiring for the 110V control circuit and the 220V SCR drive circuit are separated on all 440V dryers.

IEC Branch Breakers

IEC controls are heavier and meet additional codes. 440 volt dryers have branch breakers. This is needed to meet code in some states or areas.

Ground Rod

A ground rod is included with each dryer. We require that each dryer have a properly installed ground rod.

8" Flight

All unload auger flighting has been standardized to eight inches for fast unloading and longer life.

IEC Motor Overloads

IEC overloads allow for more adjustment. All the motors on the dryer have been modified so that only the motor overload in the control box can sense a shutdown. All internal overloads in the motors have been removed.

Control Box Rails

The upper and lower control box are being mounted on vertical rails instead of only the horizontal rails as in earlier years. This makes it easier for us to lower or raise the control boxes if a customer is going to mount his dryer on taller pedestals.

User Supplied Safety

This shows that periphery equipment shut the dryer down.

Plenum and Grain Temperature Set Points

The plenum and grain temperature set points can be programmed from the control panel of the 100 series dryer. This allows you to monitor and change the grain and plenum temperatures from the control box.

Out of Grain (Unload Cleanout)

The computer knows the difference between a safety that opened indicating a problem with the dryer and a shutdown that occurs during normal operation. For instance if the out of grain timer shuts down the dryer this is not looked at as a safety hazard. So before the dryer completely shuts down the computer will first allow the unload auger and any take away augers to run long enough to clean themselves out. The amount of time they will run is determined by the setting of the unload time delay.

Air Mix Chambers

Complete mixing of heat and ambient air makes for even drying temperature in plenum chamber, front and back and side to side. (New air straighteners enhance the effectiveness of the mixing chambers).

Vane Axial Fans

Low speed fan blades for low noise level. More efficient (cfm/bu/hp) than centrifugal fans, less electrical costs.

Work Light and Shutdown Indicator

The light on the outside of the dryer doubles as a shutdown indicator. When the light switch is placed in the auto position the light will go off whenever the dryer shuts down. The light will also work in the on position even if the dryer is shutdown.

Stainless Steel Trash Pan

A trash pan is available to help distribute trash in the top of the dryer. This will help to keep the grain flowing in the back columns.

Auxiliary Auger IEC Contactors/ Overloads

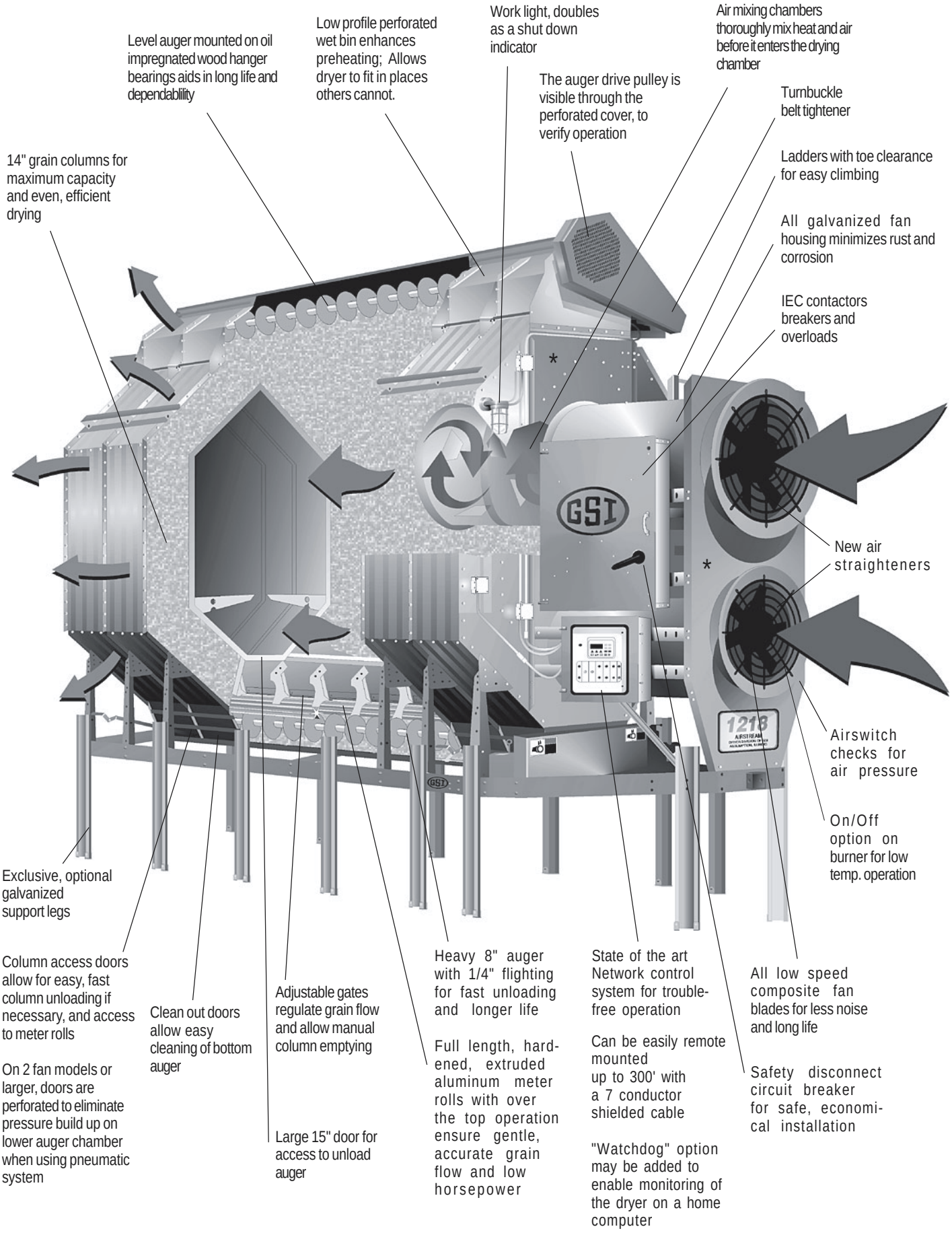
There are no heaterstrips on IEC controls. If a different size motor is to be used these contactor overloads must be changed. Notify GSI and it will come from the factory correct.

Low Temp Burner Options

The on-off fire burner, as opposed to the hi-low fire, is excellent for specialty grain operations.

Dryer Shutdowns

Each of the common shutdowns on the 100 series are displayed individually, so there is no guesswork when these shutdowns occur.


Level auger mounted on oil impregnated wood hanger bearings aids in long life and dependablility
Low profile perforated wet bin enhances preheating; Allows dryer to fit in places others cannot.
Work light, doubles as a shut down indicator
Air mixing chambers thoroughly mix heat and air before it enters the drying chamber
The auger drive pulley is visible through the perforated cover, to verify operation
Turnbuckle belt tightener
14" grain columns for maximum capacity and even, efficient drying
Ladders with toe clearance for easy climbing
All galvanized fan housing minimizes rust and corrosion
IEC contactors breakers and overloads
New air straighteners
Airswitch checks for air pressure
On/Off option on burner for low temp. operation
Exclusive, optional galvanized support legs
Column access doors allow for easy, fast column unloading if necessary, and access to meter rolls
On 2 fan models or larger, doors are perforated to eliminate pressure build up on lower auger chamber when using pneumatic system
Clean out doors allow easy cleaning of bottom auger
Adjustable gates regulate grain flow and allow manual column emptying
Large 15" door for access to unload auger
Heavy 8" auger with 1/4" flighting for fast unloading and longer life
Full length, hard-ened, extruded aluminum meter rolls with over the top operation ensure gentle, accurate grain flow and low horsepower
State of the art Network control system for trouble-free operation
Can be easily remote mounted up to 300' with a 7 conductor shielded cable
"Watchdog" option may be added to enable monitoring of the dryer on a home computer
All low speed composite fan blades for less noise and long life
Safety disconnect circuit breaker for safe, economi-cal installation
GSI
1213

Network Controls

The Network control system uses digital communications between the main control box and each fan/heater unit. The digital communications allow each dryer equipped with Network controls to have added features and simplified wiring. Control wiring on stack models has been reduced to 5 wires. This is a reduction over 100 wires on stack dryers. Installation time should be greatly reduced on all stack dryers.

Temperatures

The Network control system allows the user to both monitor and adjust all temperatures on the dryer from the main control panel. Each burner has it's setpoint and actual temperature displayed on the main control box located at eye level. You may adjust all temperatures here or they can be adjusted on the fan/heater unit.

Out of Grain-Refill Timer

When activated the refill timer monitors when the out of grain timer calls for a shutdown. Instead of shutting down the complete dryer, the burners and the unload system will shutdown. They will stay shutdown for a period of time that you program into the computer. If during this refill time the dryer fills back up with grain, the dryer will start the burners and unload and return to normal operation. If the refill time reaches zero the rest of the dryer will shutdown.

Fan/Heater Bypass

The Network controls can keep your dryer running. If you have a shutdown in one of the fan/heater units today, the dryer will shutdown and it will not restart until the problem has been corrected. This may mean a service call from your dealership. By using the **Fan/Heater Bypass** feature you can bypass the fan/heater with the problem. The rest of the dryer will operate normally, while the fan/heater with the shutdown is eliminated from the circuit. This can keep a dryer going until help has arrived.

Out Of Grain (unload cleanout)

The computer knows the difference between a safety that opened indicating a problem with the dryer and a shutdown that occurs during normal operation. For instance if the out of grain timer shuts down the dryer this is not looked at as a safety hazard. So before the dryer completely shuts down the computer will first allow the unload auger and any take away augers to run long enough to clean themselves out. The amount of time they will run is determined by the setting of the unload time delay.

Remoting the Control Box

The Network control box can be remote mounted easier than ever before. The number of wires here have also been reduced. We have decreased the number of wires that run from the power box to the main control box to 7. That is also a reduction of over 100 wires from last years models. This should be a 7 conductor shielded cable, but by using the shielded cable you should be able to remote mount the main control box up to 300 feet away from the dryer.

The "Watchdog" Remote Monitoring System

A system has been designed that will enable a user to "watch" his dryer on a home computer screen. This is for viewing only and will not control the dryer. All switches will be monitored along with the output for each contactor. All temperatures can be monitored. You will be able to see actual temperatuers as well as the burner setpoints. Bushels per hour, meter roll setpoints, and RPM will also be indicated so a person can keep a record of all the grain he has dried even if he resets the total bushels on the dryer. All safety shutdowns are also monitored and stored in the computer. This will allow a record of all shutdowns (not just the 256 stored in the dryer) to be kept. You will be able to view or print a graph of grain and plenum temperatures. A picture of the actual front control panel of the dryer can be displayed showing all switch positions and screen displays.

High/Low Speed Averaging

Because the meter roll speed pots are now monitored directly by the Network controls the computer can caluclate the amount of time the meter rolls spend on high and low speed. The operater can use this to tell if his meter rolls are adjusted properly.

Meter Roll Reverse

All Network dryers have the ability to use the meter roll reversal feature. This is a very important feature if you are ever drying during extremely trashy conditions. Here is how it works. You will activate the Meter Roll Reverse feature and then set an amount of time that you want the meter rolls to run before they reverse. Then you will set an amount of time that you want the meter rolls to run in reverse. So the rolls will run in the normal direction for a while and then come to a complete stop. Then they will reverse direction for a preset period of time. Another complete stop and resure normal rotation. If you have any trash gathered around the meter rolls this should pass it through the system.

Unit of Measure

Network controls have programming that allow the user to decide what unit of measure that they want to be displayed. You can choose between Fahrenheit and Celcius, and also between Bushels per Hour and Metric Tons.

Error History Viewing

Network controls monitor and log all types of shutdown when they occur. When a shutdown happens it is immediately displayed and recorded in the computer history. When you reach the dryer you will be able to see what shut the dryer down and also the time and date that the shutdown happened. The log is kept in a hard memory that never forgets. If power is pulled from the dryer it will still keep the permanent log of shutdowns and the time and date. The number of shutdown that will be logged is 256.

Additional Features:

Trash Pan

A trash pan is available to help distribute trash in the top of the dryer. This will help to keep the grain flowing in the back columns. **Trash pans are stainless steel on all models.**

Vane Axial Fans

Low speed fan blades for low noise level. More efficient (cfm/bu/hp) than centrifugal fans, less electrical costs.

IEC Branch Breakers, Contactors and Overloads

IEC controls are heavier and meet additional codes. 440 volt dryers have branch breakers. This is needed to meet code in some states or areas. Overloads allow for adjustment.

8" Flight

All unload auger flighting has beenstandardized to eight inches for fast unloading and longer life.

Two Transformers In 440 Volt Dryers

Control transformer wiring for the 110V control circuit and the 220V SCR drive circuit are separated on all 440V dryers.

Wind Buttress For Stack Dryers

In 1995, we started using commercial bin stiffeners in place of the wind buttress. This will allow for easier erection, and less concrete work. The dryer will be approximately 9' overall width.

Ground Rod

A ground rod is included with each dryer. We require that each dryer have a ground rod installed per local code .

Air Mix Chambers

Complete mixing of heat and ambient air makes for even drying temperature in plenum chamber, front and back and side to side. New air straighteners enhance the effectiveness of the mixing chambers.

100 Series Pricing

All screens, augers, bearings and sheet metal parts are the same as the 1100 Series dryers. Only the electronic controls are different.

100 Series System

Full heat continuous flow or auto batch

Dry and cool auto batch

Full safety control system

See through control panel door

Load and unload auxiliary starters

Waterproof controls

Solid state ignition

Externally adjustable vaporizers

Low speed vane axial fans with Blue Burn System on LP models

Internal and external meter roll cleanout

Heavy duty meter rolls and drive

Solid dividers, every two feet

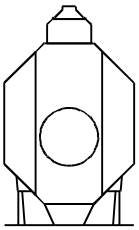
Galvanized fan housing, control cabinet and auger housing

Perforated wet bin standard on all models

Model Number	Electrical Power Phase	Voltage	Fuel	List Price Less Transport	Approx. Dryer Wt.	Wet Bushels Full Heat 10 pt.*	Wet Bushels Full Heat 5 pt.*	Wet Bushels Dry & Cool 10 pt.*	Wet Bushels Dry & Cool 5 pt.*
ALL Models are Equipped with a Perforated Wet Bin									
108	1 or 3	ALL	ALL	$27,720.00	4,300 lbs.	190	310	120	155
110	1 or 3	ALL	ALL	$31,340.00	5,000 lbs.	240	385	150	200
112	1 or 3	ALL	ALL	$39,470.00	6,300 lbs.	335	525	205	270
114	1 or 3	ALL	ALL	$48,760.00	7,000 lbs.	390	610	245	320
116	1 or 3	ALL	ALL	$50,940.00	7,500 lbs.	440	710	280	370
118	3	ALL	ALL	$53,850.00	8,000 lbs.	505	815	320	430
120	3	ALL	ALL	$58,460.00	8,700 lbs.	560	905	360	475
122	3	ALL	ALL	$66,250.00	9,500 lbs.	610	990	390	520
126	3	ALL	ALL	$73,510.00	11,000 lbs.	715	1,155	455	605

If a Standard Top is Desired, Consult Page 14 for Deduct Pricing

***Measured in wet bushels per hour (BPH).**
****See page 21 for wet bin pricing, if needed.**



100 & 1100 Series

For CGA approval on above models add $1100. list.

For small grain perforations (0.050") add 2% to list price of dryer. Prices and specifications subject to change without notice

June 16, 2002

1100 Series Pricing

Network Control System

Fan/Heater bypass

Every shutdown monitored and saved in the error shutdown history

Out of Grain--Unload Cleanout

Full heat continuous flow or auto batch

Remote capable control center

See through control panel door

Load and unload auxiliary starters

Low speed vane axial fans with Blue Burn System

Solid state ignition

Externally adjustable vaporizers

Internal and external meter roll cleanout

Heavy duty meter rolls and drive

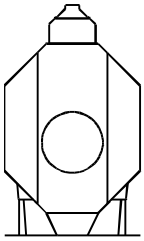
Solid dividers, every two feet

Perforated wet bin standard

Waterproof controls

Model Number	Electrical Power		Fuel	List Price Less Transport	Approx. Dryer Wt.	Wet Bushels Full Heat		Wet Bushels Dry & Cool	
	Phase	Voltage				10 pt.*	5 pt.*	10 pt.*	5 pt.*
1108	1 or 3	ALL	ALL	$33,400.00	4,300 lbs.	205	335	130	170
1110	1 or 3	ALL	ALL	$37,000.00	5,000 lbs.	260	420	165	220
1112	1 or 3	ALL	ALL	$45,150.00	6,300 lbs.	345	560	220	290
1114	1 or 3	ALL	ALL	$49,960.00	7,000 lbs.	405	650	260	340
1116	1 or 3	ALL	ALL	$55,400.00	7,500 lbs.	440	710	280	370
1118	3	ALL	ALL	$60,080.00	8,000 lbs.	505	815	320	430
1120	3	ALL	ALL	$64,770.00	8,700 lbs.	560	905	360	475
1122	3	ALL	ALL	$68,570.00	9,500 lbs.	610	990	390	520
1126	3	ALL	ALL	$77,440.00	11,000 lbs.	715	1,155	455	605

***Measured in wet bushels per hour (BPH).**



1100 Series

For CGA approval on above models add $1100. list

For small grain perforations (0.050") add 2% to list price of dryer. Prices and specifications subject to change without notice
Example: 1108 dryer LP small grains $31,395. x 1.02=$32,023. list. All items F. O. B. Newton, Illinois. June 16, 2002

1200 Series Pricing

Network Control System (See page 6)

All temps set at main control box

Watchdog remote monitoring system

Fan/Heater bypass

Every shutdown monitored and saved in the error shutdown history

Continuous flow or staged batch

Out of Grain--Unload Cleanout

Easily remoteable control center

Load and unload auxiliary starters

Galvanized fan housing, control cabinet and auger housing

Low speed vane axial fans, LP models have the exclusive "Blue Burn System"

Solid state ignition and flame sensing

Externally adjustable vaporizers

Internal and external meter roll cleanout

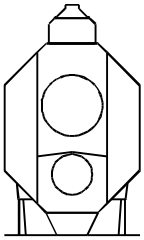
Heavy duty meter rolls and drive

Solid dividers, every two feet

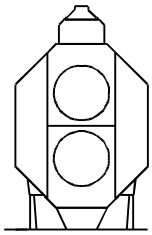
Perforated wet bin standard

Waterproof controls

For CGA approval on 1200 & 1200s Series add $2200. list



1200 Series



1200S Series

1200 SERIES

Model Number	Electrical Power Phase	Voltage	Fuel	List Price Less Transport	Approx. Dryer Wt.	Wet Bushels Full Heat 10 pt.*	Wet Bushels Full Heat 5 pt.*	Wet Bushels Dry & Cool 10 pt.*	Wet Bushels Dry & Cool 5 pt.*
1214	1 or 3	ALL	LP or NG	$53,930.00	7,600 lbs.	415	680	250	400
1216	1 or 3	ALL	LP or NG	$58,010.00	8,200 lbs.	475	765	290	465
1218	1 or 3	ALL	LP or NG	$62,710.00	9,000 lbs.	520	840	315	505
1220	1 or 3	ALL	LP or NG	$69,700.00	9,800 lbs.	590	950	345	560
1222	3	ALL	LP or NG	$77,050.00	10,500 lbs.	650	1,055	395	640
1226	3	ALL	LP or NG	$84,640.00	12,000 lbs.	730	1,180	450	725

1200S SERIES

1214S	1	ALL	LP or NG	$60,220.00	9,500 lbs.	381	680	220	325
1218S	1	ALL	LP or NG	$69,460.00	11,500 lbs.	520	840	240	385
1220S	1	ALL	LP or NG	$77,140.00	14,500 lbs.	590	950	280	425
1222S	1	ALL	LP or NG	$85,260.00	15,500 lbs.	650	1,055	300	485
1226S	1	ALL	LP or NG	$93,390.00	18,500 lbs.	730	1,180	375	600

***Measured in wet bushels per hour (BPH).**

For small grain perforations (0.050") add 2% to list price of dryer. Prices and specifications subject to change without notice

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STACKABLE SERIES MODELS

2300 SERIES

Model Number	Stackable Units	Electrical Power Phase	Electrical Power Voltage	Fuel	List Price Less Transport	Approx. Dryer Wt.	Wet Bushels Full Heat 10 pt.*	Wet Bushels Full Heat 5 pt.*	Wet Bushels Dry & Cool 10 pt.*	Wet Bushels Dry & Cool 5 pt.*
2314	2	1 or 3	ALL	LP or NG	$92,720.00	16,000 lbs.	900	1,455	615	995
2318	2	3	ALL	LP or NG	$113,090.00	19,000 lbs.	1,120	1,805	770	1,235
2320	2	3	ALL	LP or NG	$119,320.00	21,000 lbs.	1,245	2,010	850	1,375
2322	2	3	ALL	LP or NG	$126,550.00	22,500 lbs.	1,355	2,195	930	1,500
2326	2	3	ALL	LP or NG	$141,240.00	25,000 lbs.	1,670	2,700	1,130	1,835

2400 SERIES

2414	2	1 or 3	ALL	LP or NG	$99,730.00	16,500 lbs.	900	1,455	615	995
2418	2	1 or 3	ALL	LP or NG	$120,880.00	19,500 lbs.	1,120	1,805	770	1,235
2420	2	3	ALL	LP or NG	$127,220.00	21,500 lbs.	1,245	2,010	850	1,375
2422	2	3	ALL	LP or NG	$134,900.00	23,500 lbs.	1,355	2,195	930	1,500
2426	2	3	ALL	LP or NG	$160,050.00	26,000 lbs.	1,670	2,700	1,130	1,835

***Measured in wet bushels per hour (BPH).**

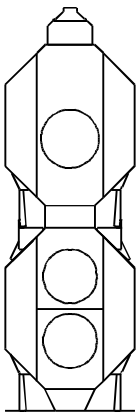
For CGA approval add $3300.00 for 2300 Series, and add $4400.00 for 2400 Series.

Pedestal Bases for Stack Stiffner Supports included in List Price of Dryer.

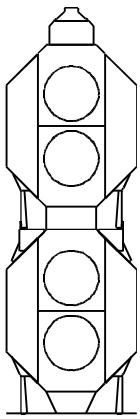
Standard on all Stack Dryers.
D01-1100** 36" Base Unit
LEG-036*** 36" Tall Leg

Available for all Stack Dryers
D01-1104** 18" Base Unit
LEg-018*** 18" Tall Leg

**6 required on 12' & 14' series.
8 required on 18' series
10 required on 20' & 22' series.
12 required on 26' series.



2300 Series



2400 Series

For small grain perforations (0.050") add 2% to list price of dryer. Prices and specifications subject to change without notice

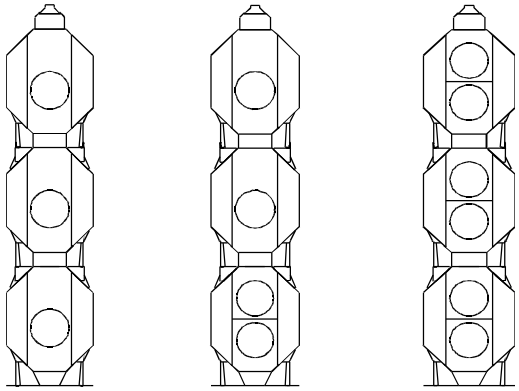
June 16, 2002

STACKABLE SERIES MODELS

Model Number	Stackable Units	Electrical Power		Fuel	List Price Less Transport	Approx. Dryer Wt.	Wet Bushels Full Heat		Wet Bushels Dry & Cool	
		Phase	Voltage				10 pt.*	5 pt.*	10 pt.*	5 pt.*
3312	3	1 or 3	ALL	LP or NG	$109,860.00	22,000 lbs.	1,045	1,690	640	1,035
3314	3	1 or 3	ALL	LP or NG	$120,100.00	23,000 lbs.	1,355	2,190	840	1,340
3318	3	3	ALL	LP or NG	$142,800.00	28,500 lbs.	1,680	2,720	1,035	1,665
3320	3	3	ALL	LP or NG	$156,270.00	28,500 lbs.	1,825	2,950	1,120	1,800
3322	3	3	ALL	LP or NG	$165,510.00	30,000 lbs.	2,040	3,300	1,250	2,015
3326	3	3	ALL	LP or NG	$186,100.00	34,000 lbs.	2,475	4,000	1,520	2,445
3414	3	1 or 3	ALL	LP or NG	$124,770.00	23,000 lbs.	1,355	2,190	840	1,340
3418	3	3	ALL	LP or NG	$148,260.00	26,500 lbs.	1,680	2,720	1,035	1,665
3420	3	3	ALL	LP or NG	$161,060.00	29,500 lbs.	1,825	2,950	1,120	1,800
3422	3	3	ALL	LP or NG	$170,410.00	30,500 lbs.	2,040	3,300	1,250	2,015
3426	3	3	ALL	LP or NG	$191,440.00	35,000 lbs.	2,475	4,000	1,520	2,445
3614	3	1 or 3	ALL	LP or NG	$133,560.00	24,000 lbs.	1,355	2,190	840	1,340
3618	3	1 or 3	ALL	LP or NG	$157,720.00	28,000 lbs.	1,680	2,720	1,035	1,665
3620	3	1 or 3	ALL	LP or NG	$176,300.00	31,000 lbs.	1,825	2,950	1,120	1,800
3622	3	1 or 3	ALL	LP or NG	$185,100.00	33,000 lbs.	2,040	3,300	1,250	2,015
3626	3	3	ALL	LP or NG	$219,820.00	38,000 lbs.	2,475	4,000	1,520	2,445

***Measured in wet bushels per hour (BPH).**

For CGA approval add $3300.00 for 3300 Series, add $4400.00 for 3400 Series, AND $6600.00 for 3600 Series.



3300 Series 3400 Series 3600 Series

Pedestal Bases for Stack Stiffner Supports included in List Price of Dryer.

Standard on all Stack Dryers.
D01-1100** 36" Base Unit
LEG-036*** 36" Tall Leg

Available for all Stack Dryers
D01-1104** 18" Base Unit
LEg-018*** 18" Tall Leg

**6 required on 12' & 14' series.
8 required on 18' series
10 required on 20' & 22' series.
12 required on 26' series.

For small grain perforations (0.050") add 2% to list price of dryer. Prices and specifications subject to change without notice

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STAINLESS STEEL TRASH PAN

Part Number		List Price
TP-08	Trash Pan Kit, 8' Dryer	$200.00
TP-10	Trash Pan Kit, 10' Dryer	$250.00
TP-12	Trash Pan Kit, 12' Dryer	$290.00
TP-14	Trash Pan Kit, 14' Dryer	$430.00
TP-16	Trash Pan Kit, 16' Dryer	$480.00
TP-18	Trash Pan Kit, 18' Dryer	$510.00
TP-20	Trash Pan Kit, 20' Dryer	$560.00
TP-22	Trash Pan Kit, 22' Dryer	$700.00
TP-26	Trash Pan Kit, 26' Dryer	$780.00

WET BIN

All combination dryers are equipped with wet bins as standard equipment, to price with a standard top please deduct the galvanized steel list price from price of dryer.

Wet Bin prices are in lieu of standard top.

Dryer Length	Galvanized Steel List Price	Stainless Steel List Price	Additional Price For Stainless Wet Bin on Dryers With Wet Bin
8 ft.	$639.00	$1,092.00	$453.00
10 ft.	$772.00	$1,344.00	$572.00
12 ft.	$1,130.00	$1,796.00	$666.00
14 ft.	$1,313.00	$2,090.00	$777.00
16 ft.	$1,489.00	$2,384.00	$895.00
18 ft.	$1,709.00	$2,704.00	$995.00
20 ft.	$1,886.00	$2,993.00	$1,107.00
22 ft.	$2,051.00	$3,276.00	$1,225.00
26 ft.	$2,426.00	$3,875.00	$1,449.00

STAINLESS STEEL PRICING

Model	Column Length	All Outside Screens	Top Outside Only	Top & Sides Outside Only	*Rice Option All Inside & Outside Screens
108, (short sides)	8	$1,654.00	$536.00	$971.00	$2,966.00
110, (short sides)	10	$2,063.00	$672.00	$1,208.00	$4,022.00
112	12	$2,767.00	$803.00	$1,733.00	$4,289.00
114, 1214, 1214S	14	$3,229.00	$945.00	$2,037.00	$6,332.00
116, 1216	16	$3,691.00	$1,076.00	$2,326.00	$7,245.00
118, 1218, 1218S	18	$4,148.00	$1,208.00	$2,615.00	$8,138.00
120, 1220, 1220S	20	$4,615.00	$1,349.00	$2,914.00	$9,056.00
122, 1222, 1222S	22	$5,077.00	$1,481.00	$3,202.00	$9,949.00
126, 1226, 1226S	26	$5,996.00	$1,748.00	$3,791.00	$11,750.00
		Complete	**Partial 1**	**Partial 2**	
2314, 2414	14	$6,458.00	$4,174.00	-	$12,747.00
2318, 2418	18	$8,295.00	$5,355.00	-	$16,380.00
2320, 2420	20	$9,230.00	$5,964.00	-	$18,197.00
2322, 2426	22	$10,154.00	$6,563.00	-	$20,097.00
2326, 2426	26	$11,996.00	$7,744.00	-	$23,730.00
3312	12	$8,295.00	-	$4,505.00	$16,170.00
3314, 3414, 3614	14	$9,692.00	-	$5,271.00	$19,425.00
3318, 3418, 3618	18	$12,453.00	-	$6,773.00	$24,738.00
3320, 3420, 3620	20	$13,839.00	-	$7,529.00	$27,500.00
3322, 3422, 3622	22	$15,225.00	-	$8,285.00	$30,240.00
3326, 3426, 3626	26	$17,997.00	-	$9,791.00	$35,721.00

Partial 1: All outside screens of top module and top outside angle of bottom module.
Partial 2: All outside screens of top module and top and side outside screens of middle module.
Small grain perforations (0.050") not available in stainless steel. *GSI recommends this option for drying rice.

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GRAIN SAMPLER

Item	Part Number	List Price
Grain Sampler (Standard on new dryer)	D01-0405	$78.00

HEAT RECLAIMER

	Dryer	Part Number	List Price
Heat Reclaimer	1214	1214-HR01	$5,950.00
	1216	1216-HR01	$6,180.00
	1218	1218-HR01	$6,360.00
	1220	1220-HR01	$6,570.00
	1222	1222-HR01	$6,820.00
	1226	1226-HR01	$8,090.00
	2000 Series		
	12 ft.	2012-HR01	$12,480.00
	14 ft.	2014-HR01	$13,180.00
	18 ft.	2018-HR01	$14,780.00
	20 ft.	2020-HR01	$15,540.00
	22 ft.	2022-HR01	$16,300.00
	26 ft.	2026-HR01	$17,830.00
	3000 Series		
	12 ft.	3012-HR01	$16,500.00
	14 ft.	3014-HR01	$17,710.00
	18 ft.	3018-HR01	$19,520.00
	20 ft.	3020-HR01	$20,380.00
	22 ft.	3022-HR01	$21,350.00
	26 ft.	3026-HR01	$23,050.00

NOISE SUPPRESSOR KIT

	Dryer	Part Number	List Price
Noise Suppressor Kit	108, 110, 112, 114, 116, 118, 120, 122, 126	1100-NS01	$1,390.00
	1214, 1216, 1218, 1220, 1222, 1226	1200-NS01	$2,600.00
	12, 14, 18, 20, 22, & 26 ft. stacked series	1200S-NS01 2000-NS01 3000-NS01	$4,680.00 $7,860.00 $11,090.00
For Use With Heat Reclaimer	All Multi Fan Models With Heat Reclaimer	1200-NSHR 2000-NSHR 3000-NSHR	$1,560.00 $4,510.00 $7,740.00

SERVICE PLATFORM

Service Platform		Part Number	List Price
(extra unit)	All	SP-01	$1,764.00

Moisture Manager

Part Number		List Price
DO4-0381	Moisture control when purchased with dryer	$3495.00
DO4-0379	Moisture control when purchased seperately	$4387.00

SHRINK WRAP
For Dryer Transport

Column Length	Part Number	Net Price After Cash
8'-10'	CD-0313	$236.00
12'-18'	CD-0409	$368.00
20'-26'	CD-0410	$499.00

DISCHARGE AUGER EXTENSION

10" Diameter Tube	Part Number	List Price
2'	CD-AE02	$452.00
4'	CD-AE04	$609.00
6'	CD-AE06	$746.00
8'	CD-AE08	$903.00
Fill Extention	MF-AE02L	$578.00
Discharge Box Bypass In lieu of Standard	D01-1172	$48.00

Any length needed is available. Call factory for quotation.

TRANSPORT KIT

Item	Model	Part Number	List Price
Transport Kit	8-10 ft. series	TK-01	$1,785.00
	12 ft. series	TK-02	$3,045.00
	14, 16 ft. series	TK-02S	$3,150.00
	18, 20, 22 ft. series	TK-03	$4,515.00
	26 ft. series	TK-04	$6,195.00

CRANE BRACKETS

	Part Number	List Price
Crane bracket kit - top models (used on single module dryers and top modules of stack dryers)	D04-0128	$151.00
Crane bracket kit - bottom module (used on bottom and middle modules of stack dryers)	D04-0157	$55.00

WATCHDOG

Part Number		List Price
DO3-0358	Standard System (World Wide Access)	$1995.00
DO3-0359	Short Haul (No Modem On-site Computer)	$1995.00

Stainless Steel Grain Inverters

	Part Number	List Price
Grain Inverter (per foot of basket)	D01-1490S	$315.00

DRYER STEEL LEG SUPPORTS

When ordering leg stands for dryers, please use these part numbers to specify the desired item needed. These groupings have been developed to make ordering legs for dryers easier.

All leg packages include frame step assembly on front and rear.

Individual Leg Assembly

LEG-016	16" Tall	$43.00
LEG-018	18" Tall	$44.00
LEG-024	24" Tall	$46.00
LEG-030	30" Tall	$50.00
LEG-036	36" Tall	$53.00
LEG-042	42" Tall	$56.00

Leg Packages For An 8' Dryer Module

LEG-016-08	16" Tall	$400.00
LEG-018-08	18" Tall	$410.00
LEG-024-08	24" Tall	$450.00
LEG-030-08	30" Tall	$480.00
LEG-036-08	36" Tall	$510.00
LEG-042-08	42" Tall	$560.00

Leg Packages For 10' & 12' Dryer Modules

LEG-016-10	16" Tall	$480.00
LEG-018-10	18" Tall	$500.00
LEG-024-10	24" Tall	$540.00
LEG-030-10	30" Tall	$580.00
LEG-036-10	36" Tall	$620.00
LEG-042-10	42" Tall	$680.00

Leg Packages For 14' & 16' Dryer Modules

LEG-016-14	16" Tall	$570.00
LEG-018-14	18" Tall	$580.00
LEG-024-14	24" Tall	$630.00
LEG-030-14	30" Tall	$680.00
LEG-036-14	36" Tall	$720.00
LEG-042-14	42" Tall	$790.00

Leg Packages For 18' & 20' Dryer Modules

LEG-016-18	16" Tall	$650.00
LEG-018-18	18" Tall	$670.00
LEG-024-18	24" Tall	$720.00
LEG-030-18	30" Tall	$780.00
LEG-036-18	36" Tall	$830.00
LEG-042-18	42" Tall	$900.00

Leg Packages For A 22' Dryer Module

LEG-016-22	16" Tall	$740.00
LEG-018-22	18" Tall	$760.00
LEG-024-22	24" Tall	$820.00
LEG-030-22	30" Tall	$880.00
LEG-036-22	36" Tall	$940.00
LEG-042-22	42" Tall	$1,020.00

Leg Packages For A 26' Dryer Module

LEG-016-26	16" Tall	$820.00
LEG-018-26	18" Tall	$840.00
LEG-024-26	24" Tall	$910.00
LEG-030-26	30" Tall	$980.00
LEG-036-26	36" Tall	$1,050.00
LEG-042-26	42" Tall	$1,130.00

FRAME STEPS*

To be used to extend ladder on front of non stack dryers for access to fan when dryer is on legs.

2 rung step assembly (extends 6" below frame)	D01-1196	$54.00
3 rung step assembly (extends 18" below frame)	D01-1197	$71.00
4 rung step assembly (extends 30" below frame)	D01-1567	$88.00

* Not needed if you have purchased a leg assembly package above.

* Removal of light foreign materials occurs at the most optimum moment, when grain is in suspension.

* Removing light meterials improves air flow during storage aeration.

* Removing bees' wings (Red Dog) reduces the potential of plugged aeration floors, elevator leg boots, heads, and distributors.

* Low cost, low maintenance, high return.

* The GSI PGC can also be adapted to other areas of the grain system to increase the cleaning potential.

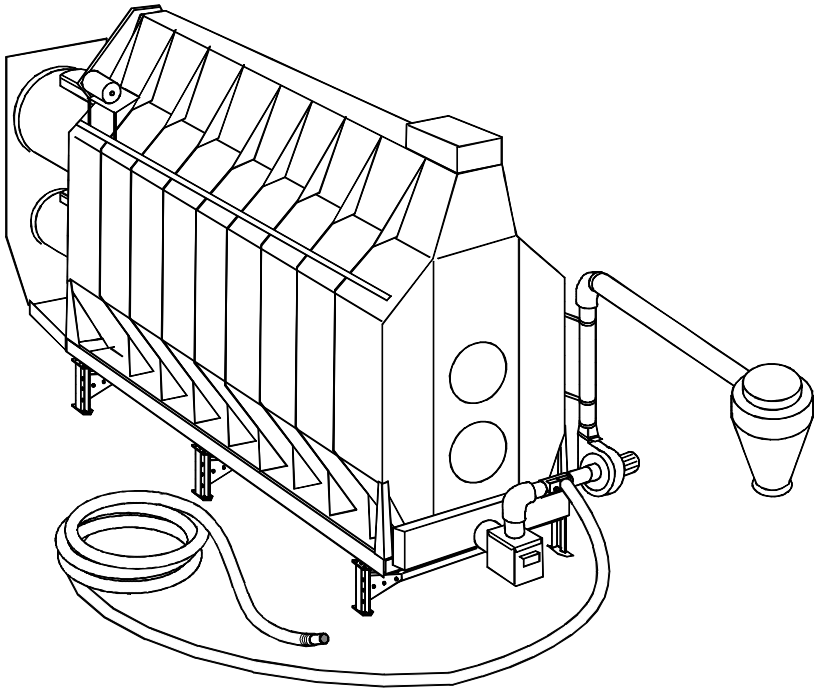
* Less bees' wings (Red Dog) and foreign matter around the drying facility results in a cleaner more desirable working atmosphere.

* Includes a PGC Vacuum System, which is designed to allow easy cleanup of the dryer during and at the end of the drying season. Regular cleaning of the fines or bees' wings allows for more efficient drying, reduces fire hazard, and by removing old fines that hold moisture, promotes longer life of the drying and grain handling equipment.

PGC-01 Grain Cleaner Kit	**List Price:**	**$1,618.00**

The PGC requires a 1.5 Hp motor not included in the above price. The following motors are available if desires.

Part Number	Description	List Price
002-1338-9	1.5 Hp 1 Phase 115/230 TEFC 56	$430.00
002-1339-7	1.5 Hp 3 Phase 230/460 TEFC 26	$430.00



PGC.DS4

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Transport Kit Policy

If the transport kit will be kept longer than the stated terms of the invoice, payment needs to be received. Upon return of the kit, credit will be issued. If payment is not made, a 1% per month finance charge will be the responsibility of the dealer. When returning the kit please include the invoice number the kit was billed on. This will help establish the credit more quickly.

Light kits are available for $200.00 credit upon return only. We would like to encourage our dealers selling several dryers per year to purchase a set of kits.

Cancellations or Changes

$100.00 is charged to an order for any change made during production and $1000.00 charge is issued for a dryer order cancellation during production.

Dryer Trailers

Allowable length 45' 0"

Any combinations to = 45' 0"

Dryer Hauling Lengths

Model Length	Length
8	14' 9"
10	16' 9"
12	18' 9"
14	20' 9"
16	22' 9"
18	24' 9"
20	26' 9"
22	28' 9"
26	32' 9"

Dryer Freight Charges

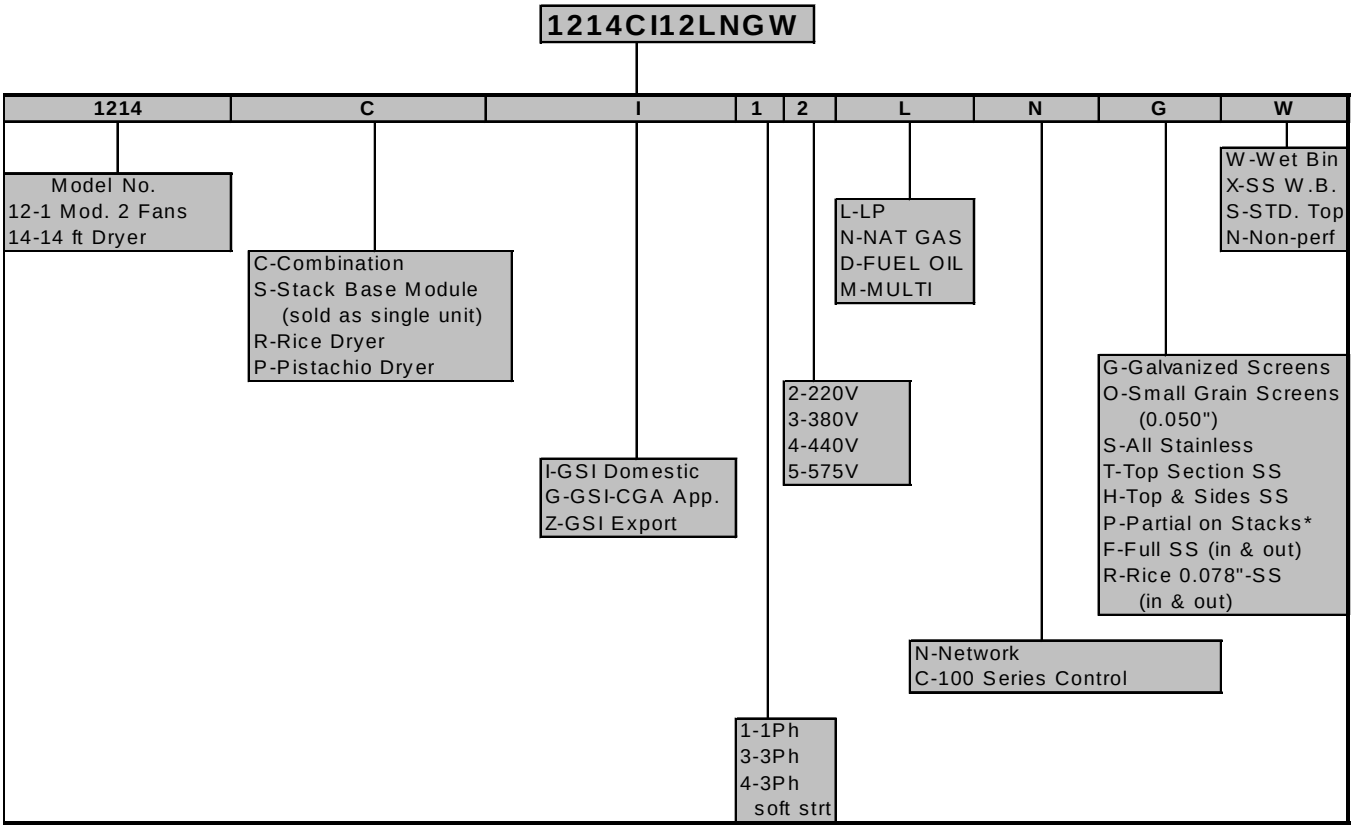
The following freight rates apply to GSI dryer shipments from Newton, Illinois:

Pulled Dryers - For 18' or shorter dryer baskets, the delivery of a single pulled dyer will be $1.55 per mile. For pulled dryers longer than 18' basket, the delivery charge will be $2.10 per mile. (The recommended transport kit will be required on all pulled dryers)

Hauled Dryers - The delivery of any hauled dryer or dryers to a single dealership will be $2.10 per mile per trailer load. (Note: Two dryers with a total basket length of 36' or less can be hauled on the GSI dryer trailer. Three dryers with a total basket length of 30' or less can be hauled on the GSI dryer trailer)

Hauled Dryers, Split Loads Betweeen Different Dealers 150 Mile Radius of Each - The delivery of a dryer(s) combined with another dryer(s) from a different dealer will be $1.25 per mile per dealership. (Note: Two dryers with a total basket length of 36' or less can be hauled on the GSI dryer trailer. Three dryers with a total basket length of 30' or less can be hauled on the GSI dryer trailer)

Model Number Identification Chart



Here is the 2002 Dryer Model Number Identification Chart. Please use the chart to aid you when ordering a portable dryer. Notice that some of the areas have changed. The changes have been made to help insure that the order you place is correct.

Dryer Capacity Conversion Chart for Various Crop Types.

Crop to be Dried (Common Types)	Plenum Temperature Setting Drying Rates Calculated on this Recommended Plenum Temperature Setting	Conversion Formula (bu) Corn Production Rate Conversion to New Crop Production Rate	Conversion to Metric Tons Conversion of Crop Production Rate from bushels/hour to Metric Tons/hour
Canola	160° F	(corn dryer capacity) x 0.60	1 Metric Ton (@ 56 lb / bu) = 39 bu
Corn	210° F	rated capacity given in specs.	1 Metric Ton (@ 56 lb / bu) = 39 bu
Milo / Sorghum	160° F	(corn dryer capacity) x 0.60	1 Metric Ton (@ 56 lb / bu) = 39 bu
Rice	130° F	(dryer column holding capacity) x 2.5 per 2 points of removal	1 Metric Ton (@ 45 lb / bu) = 49 bu
Soybean	150° F	(corn dryer capacity) x .55	1 Metric Ton (@ 60 lb / bu) = 36.75 bu
Sunflower	140° F	(corn dryer capacity) x 1.75	1 Metric Ton (@ 32 lb / bu) = 68.9 bu
Wheat	160° F	(corn dryer capacity) x 0.60	1 Metric Ton (@ 60 lb / bu) = 36.75 bu

Example 1: Wheat Capacity Calculation for 1220 : 590 bu/hr (10 point corn) x 0.60 = 354 bu/hr

Example 2: Wheat Capacity Metric Tons for 1220 : 354 bu/hr ÷ 36.75 bu/MT = 9.6 MT/hr

Note: It is recommended that canola be dried in a batch mode only.

Auxiliary Equipment

A.Capacity

Verify the capacity of the loading and unloading equipment. Compare the auxiliary equipment capacities to the maximum values for the dryer. The auxiliary equipment must be able to handle the input and output requirements of the dryer.

B. Electrical

Verify the type of phase, voltage, amperage, and horsepower of the auxiliary equipment. If the dryer is to control the operation of the auxiliary equipment, values for the electrical requirements of this equipment must be taken into account when ordering the components of the dryer control system.

Horsepower required for 6", 8" & 10" Wet Load Augers

3 phase motors

6"	3 HP/10' of length
8"	4 HP/10' of length
10"	5 HP/10' of length

1 phase motors

6"	2 HP/10' of length
8"	3 HP/10' of length
10"	4 HP/10' of length

Sample Calculations; 25% Shelled Corn Dried to 15% Moisture Content

Use the average drying energy of 1700 Btu / pound of water removed.

Btu required per bushel

To find the Btu required per bushel, multiply the amount of water to be removed for a given point differential by the drying energy used in the dryer for each pound of water removed.

10 point removal

$$\frac{7.42 \text{ lb } H_2O}{\text{bushel}} \times \frac{1{,}700 \text{ Btu}}{\text{lb } H_2O} = \frac{12{,}614 \text{ Btu}}{\text{bushel}}$$

Fuel units required per bushel

To find the fuel units required per bushel, divide the amount of Btu required per bushel at a given point removal by the heating value per unit of the fuel to be used.

10 point removal

$$\frac{12{,}614 \text{ Btu}}{\text{bushel}} \div \frac{91{,}500}{\text{gallon LP}} = \frac{0.138 \text{ gallon LP}}{\text{bushel}}$$

The reciprocal of these values is the number of bushels that can be dried per gallon of LP.

Fuel Consumption (units per hour)

Multiply the number of fuel units required by the bushel capacity of the dryer in question at the moisture removal desired.

A 126 dryer has a capacity of 715 bph for 10 point removal. How many gallons of LP are used?

$$\frac{715 \text{ bushels}}{\text{bushel}} \times \frac{0.138 \text{ gallon LP}}{\text{gallon LP}} = \frac{98.67 \text{ gallon LP}}{\text{bushel}}$$

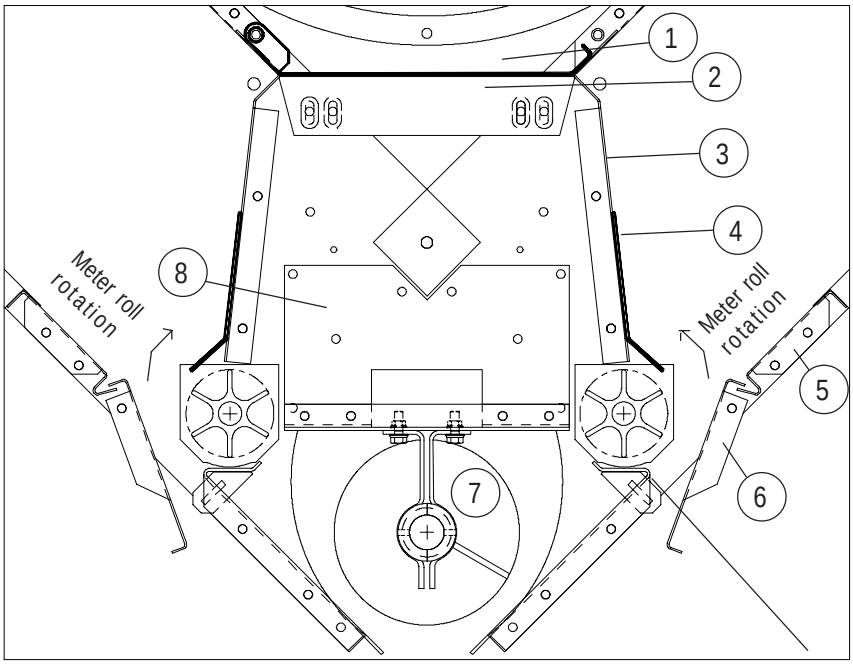
Drying Costs (cost per bushel)

Multiply the cost of fuel per unit by the fuel unit per bushel rate.

Assume LP costs $0.60 per gallon.

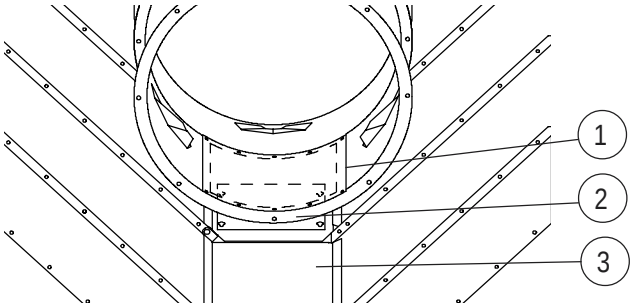
$$\frac{\$0.60}{\text{gallon LP}} \times \frac{0.138 \text{ gallon LP}}{\text{bushel}} = \frac{\$0.083}{\text{bushel}}$$

It will cost $0.083 per bushel to dry in a 126 dryer at the rated capacity of 710 bushels per hour for 10 point removal.



1-Plenum closure door
2-Adjustable sealing/ support angle
3-Meter roll upper shield
4-Meter roll strike off plate
5-Perforated connector sheet*
6-Perforated access door*
7-Bottom auger mounted from above
8-Hanger bearing mounting assembly
(*2 fan modules only)

Cross section of the metering system unload area.



1-Air mixer removable panel
2-Forward plenum closure door with access panel
3-Plenum closure door

Access to unload area through the airmixer.

Standard Features On GSI Dryers

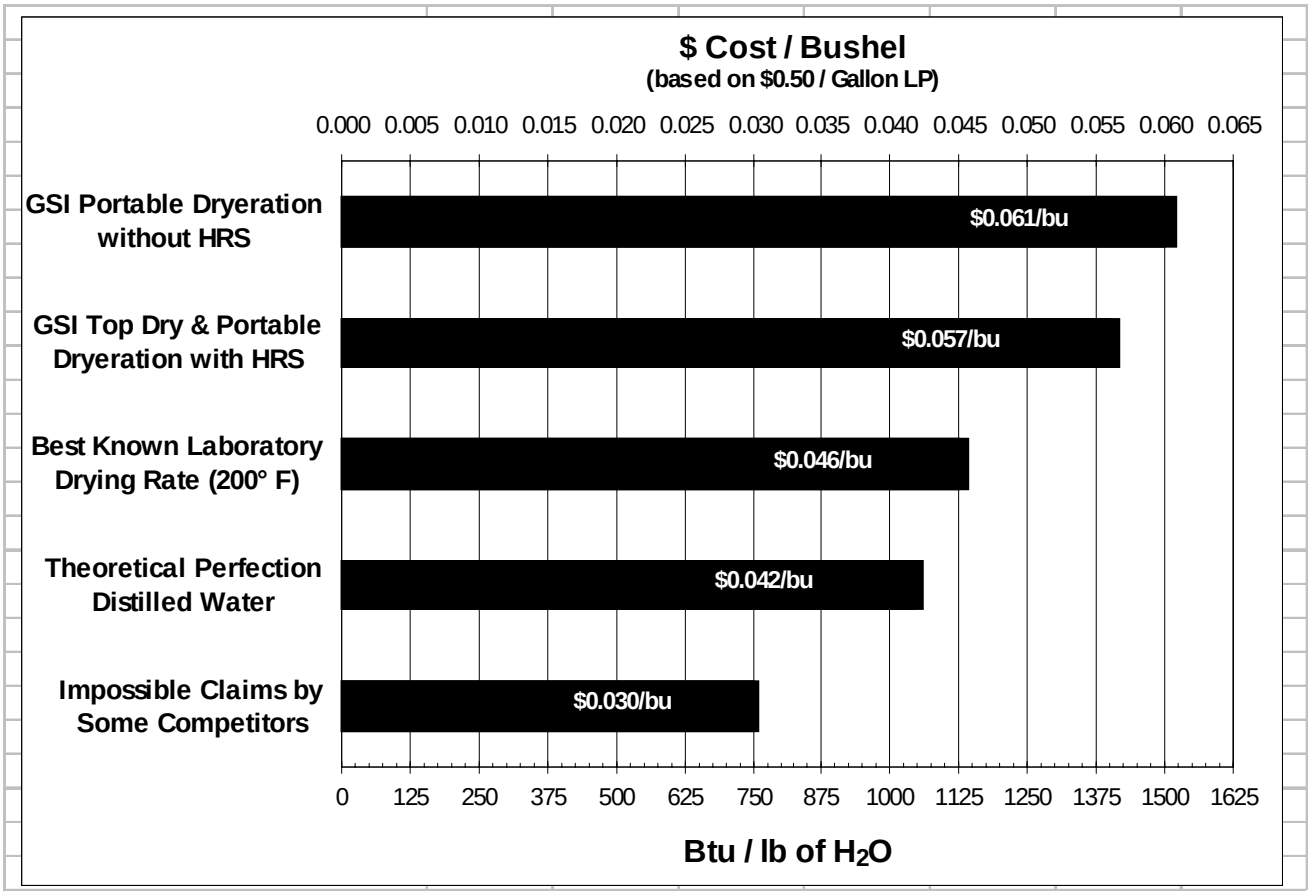
1. **GSI 100 Series Control System on single fans, GSI Network Control System on multi fan dryers** (true automation, dependable, self-diagnosing, accurate and easy to use).
2. Network control uses digital communication to reduce the amount of control circuit wiring on stack units by up up to 90 %.
3. Network control allows user to **monitor** and **adjust** grain and plenum temps from the main control box. Plenum temps can be adjusted from either the main control box or the individual fan/heater units. Already standard on 100 series.
4. Network control allows user to remote mount the main control box as far as 1000' away using a 7 conductor shielded cable.
5. Network control monitor all of the dryers safety circuits seperatly. When an error occurs the operator is informed of the nature of the shutdown, plus the time and date it occured. Up to 256 are permanently saved in the computer memory.
6. Network control monitors all meter roll rotation and uses this to calculate average time the meter rolls spend on each unloading speed. This is an important tool to help optimize capacity and quality of grain.
7. "Watchdog" remote monitoring software available for all Network models (additional equipment required).
8. Grain inverters on stacks option. (Highest grain quality and efficiency possible).
9. All IEC controls in electrical system. (More durable meets more codes).
10. Powder coat in place of painting. (Much longer life).
11. Low profile wet holding bin 14' 6" (lower height, fits more installations)
12. Adjustable metering roll gates, with **grain bypass** (minimizes column plugging, perfect for trashy conditions, quick grain bypass).
13. All fans low speed, low noise, composite blade design (low noise, efficient, more air, less vibration, easier on motors).
14. Galvanized fan housings, control cabinet, & auger housings (much longer life).
15. Full-size, see-through control panel door (convenient & cleaner).
16. Large see-through burner access door (much easier service).
17. Self monitoring start cycle (convenient, more productive).
18. 110 volt control circuit and ignition system (safer, more dependable).
19. Main safety disconnect (easier to wire, no extra cost).
22. Hinged lever operated discharge auger dump doors (convenient, easier to operate).
21. Operational monitor lights (easier operation, remote monitoring).
22. Fully perforated inner screens with standard wet bin (more grain exposed to drying air), wet bin is optional on 8'-14' Series 2000 dryers.
23. 2 speed, 4 point (two in each column) electronic moisture control (precision control, any conditions).
24. **New** DMC sensor ready discharge option. (Ready for optional DMC or GSI moisture control).
25. Double sealed control cabinets.
26. Batch and Multi-Stage controls on all models (operates in any system).
27. Power panel has terminals installed that allows easy hook-up of DMC moisture control and DMC air system.

Note: All information subject to change without notice.

Dryer Column Holding Capacity Comparison

GSI		Farm Fans		SuperB		MC		Sukup	
Model	Column Holding	Model	Column Holding	Model	Column Holding	Model	Column Holding	Model	Column Holding
108	160	CF/AB-150	150	SD185VQ	134	370EMS	157		
110	200	CF/AB-190	190	SD250VQ	210				
112	282	CF/AB-270	270	SE250VQ	187	690EMS	313	T1211A	285
114	329	CF/AB-320	320	SD375VQ	251				
116	376								
118	423	CF/AB-400	420						
120	470	CF/AB-460	460	SD500VQ	335	970C	413	T2011B	475
122	517	CF/AB-510	506	SD750C	402				
126	611	CF/AB-600	598						
1214	329	C2120A	320	SE375V	250	670EMS	313		
1216	376							T1631A	380
1218	423	C2125A	420			675EM	313		
1220	470	C2130A	460	SE500V	313			T2031A	475
1222	517			SE625C	313				
1226	611	C2140A	598	SE750C	375	980EM	620		
1214s	329	CF/SA-320	320						
1218s	423	CF/SA-410	420						
1220s	470	CF&CMS500H	460					T2021A	475
1222s	517	CF/SA-510	506					T2021B	475
1226s	611	CF/SA-600	598					T2421B	570
2314	679	CF750H	735						
2318	873	CF850H	850	SE1000C	500	1075EM	812		
2320	970	CF&CMS1000H	940	SE1200C	595	1080EM	927		
2322	1067								
2326	1261	CF1300M	1254			1180EM	1234		
3414	1022								
3418	1314								
3420	1460	CF&CMS1500H	1380						
3422	1606					2675EM	1541		
3426	1898	CF2000M	1894			3175EM	1848		

Note: All information subject to change without notice.



Approximate Bushels per Gallon of Fuel [(1)]

Based on 10 Point Removal and 100° F Moisture Control Setting

Drying Method	Bushels / Gallon LP	Btu / lb H_2O
Dry & Cool	5 - 6	2466 - 2055
Dry & Cool with Heat Recovery	7 - 8	1761 - 1541
All Heat	7 - 8	1761 - 1541
All Heat with Heat Recovery	8 - 9	1541 - 1370
Top Dry Cooling in Bottom	8 - 9	1541 - 1370

(1) Historical data from past customer reports.

Fuel Formula Constants

Fuel Type	Base Unit	Btu Content
Liquid Propane	gallon	91,500
Natural Gas	cubic foot	1,040
	therm	100,000
#2 Fuel Oil	gallon	136,000
Electricity	kilowatt	3,413

The following information should be used for estimates only.

Drying Energy Constants

Corn

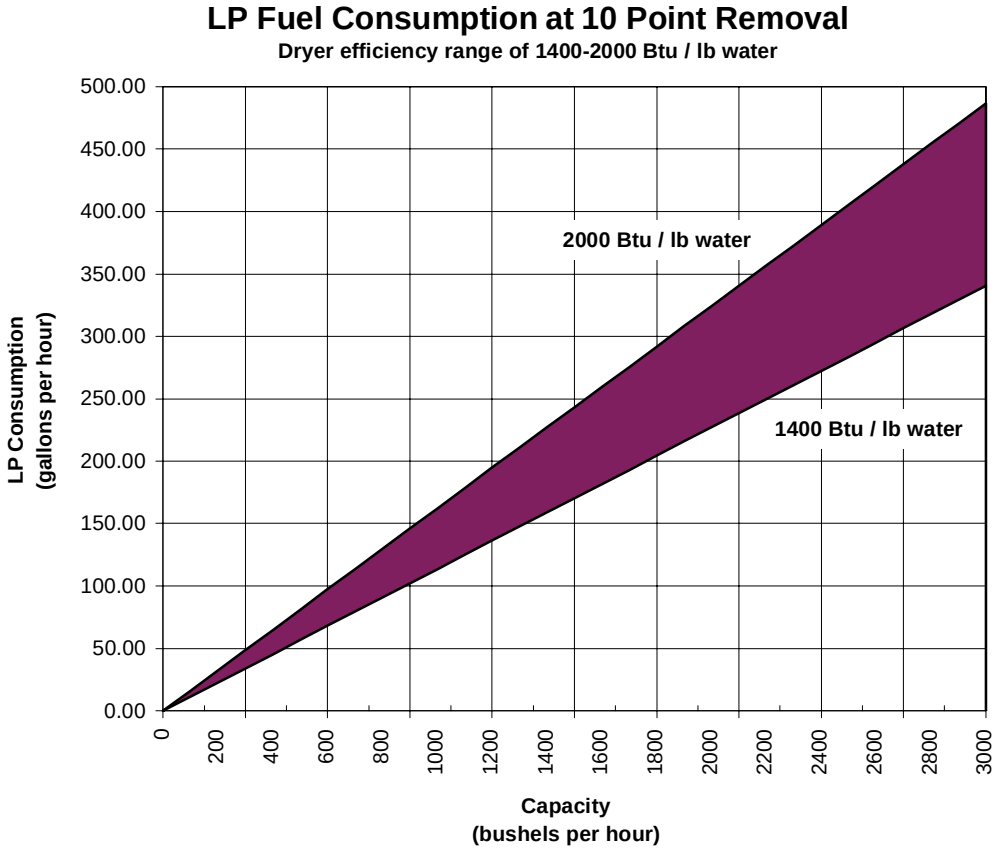
7.42 pounds (lb) of water (H O) are removed per bushel at 10 point removal.

3.48 pounds (lb) of water (H^2O) are removed per bushel at 5 point removal.

1044 Btu are required to evaporate one pound of free water at 100% efficiency.

Approximately 1400 to 2000 Btu are required to remove 1 pound of water from 25% moisture corn when drying it down to 15% moisture content. Requirements will vary with the type of dryer, method of operation, grain density, grain quality, and outside conditions.

The shaded area in following graph represents the range of values for fuel consumption that can occur for each capacity and between the drying energies of 1400 and 2000 Btu / lb of water removed.



Grain temperature is proportional to what the final moisture will be after the grain is cooled in the bin. Though no two farms or bins will be the same there are some starting points. Moisture testers will read from 17% to 19% after temperature correction.

Commercial Corn 15%125-130 degrees

White Corn 15%120-125 degrees

Waxy Corn 110-120 degrees

Each 5-7 degrees 1 point of moisture

Waxy may lose no points of moisture in bin

Temperatures above these numbers indicate hard drying conditions.

Dryeration Process

After starting with MOISTURE CONTROL settings from the manual, adjust accordingly to get 130 degree corn coming out the back of the discharge on the dryer. On rare occasions hard drying, or immature corn may require higher temperatures. Always use a moisture tester to confirm the temperature reading. Use a large sample (2.5 GAL) and an accurate thermometer(A.W. SPERRY model DT-5A digital preferred) to determine actual temperature. Smaller containers bleed off temperature before the thermometer reaches true temperature.

Bins should have a full aeration floor, 1/3 to 1/2 CFM of air when the bin is full, and a grain spreader. Normally let 2 to 3 feet of warm grain enter the bin before turning on fans to give heat a head start. Small dryers or very large bins may take too long. Do not start fans longer than 2 - 4 hours after starting the dryer. On bins with high airflow (above 1/2 CFM) you may have to cycle fans two hours on, two hours off throughout the day to maintain a thick enough hot grain layer to get proper moisture loss in the bin. Large dryers (1,000 bu/hr and bigger) may require at least 1/2 CFM, and immediate starting of fans. Follow these procedures each time you start putting grain in the bin. Continue aeration until the grain is completely cooled.

Fill each bin completely, do not alternate bins as this will layer the moistures throughout the bin. The first morning after starting your dryer, take a cooled sample from the bin and test it. The grain will be within .2% to .5% of it's final moisture at this time. You should also re-check this moisture again 24 and 48 hours later. Always use this method to decide what the moisture control setpoint should be.

If the sample of grain is too wet, turn the moisture conrol setpoint up (Higher Temp). If the test is too dry, turn the moisture control setpoint down (Lower Temp). Remember that 5-7 degrees on the moisture control will equal about one point of moisture. For example, if you want 15% and your test sample is 14%, turn the moisture control setpoint down 5 degrees.

Also keep in mind that at the bottom of the bin you have a rather high airflow, and as the bin fills, you will tend to take out more moisture. This is somewhat offset by the grain at the bottom getting more hours of aeration. If you are like most first timers you will over dry some grain, then make changes to get the desired moisture content.

It is very important to write down every setting for a year to year comparison, and to establish a preset dryer starting point.

Installation Notes

When estimating labor to be used to install the dryer, consider the items listed in the Customer Responsibilties II section of this book. It is also important to remember these notes.

- A tractor, forklift, heavy duty truck, or crane should be present to help unload the delivery truck on the day of delivery.
- All parts should be identified to verify all are present, and installation crews should familiarize themselves with the parts to ease the assembly process.
- A three person crew can install a single module dryer in a one day time period.
- A three person crew will need a few days of preparation time before lifting the dryer modules into place.

This allows for time to install stiffeners, platforms, ladders, wet bin, etc. A crane should not be scheduled to stack the dryer on the same day as delivery.

- Single module heat reclaimers will take a few working days to install with an experienced two person crew. Some extra time may be required.
- Stack heat reclaimers will take a minimum of 5 working days to install completely. Most of this installation should be done before stacking the dryer modules as it is much easier to work from the ground rather than from scaffolds or ladders.
- Noise suppressers can be installed in a one day time period.

Time For Stacking a Multi-Module Dryer

Use for estimating time needed for on site labor

Assume 15 minutes per stiffener section and base support.
Assume 10 minutes per support leg.

Assume 2 hours for platform assembly.

*2000 Series Dryers have 4 sections of stiffener per each stiffener.
*3000 Series Dryers have 6 sections of stiffener per each stiffener.

**Minimum 2 hours for setting each module.

Dryer Model Series	**Number of Stiffeners*	*Number of Support Bases*	*Number of Support Legs*	*Stiffener Assembly Time (Man-hours)*	*Platform Assembly Time (Man-hours)*	*Wet Bin Assembly Time (Man-hours)*	*Total Time (Man hours)*	***Minimum Crane Time (hours)*
2312	6	6	2	**24.00**	**6.00**	**3.00**	**33.00**	**6.00**
2314	6	6	4	**27.00**	**6.00**	**3.75**	**36.75**	**6.00**
2318	8	8	4	**33.00**	**6.00**	**4.50**	**43.50**	**6.00**
2320	10	10	2	**39.00**	**6.00**	**5.25**	**50.25**	**6.00**
2322	10	10	4	**42.00**	**6.00**	**6.00**	**54.00**	**6.00**
2326	12	12	2	**48.00**	**6.00**	**7.50**	**61.50**	**6.00**
3412	6	6	2	**33.00**	**12.00**	**3.00**	**48.00**	**8.00**
3414	6	6	4	**36.00**	**12.00**	**3.75**	**51.75**	**8.00**
3418	8	8	4	**45.00**	**12.00**	**4.50**	**61.50**	**8.00**
3420	10	10	2	**54.00**	**12.00**	**5.25**	**71.25**	**8.00**
3422	10	10	4	**57.00**	**12.00**	**6.00**	**75.00**	**8.00**
3426	12	12	2	**66.00**	**12.00**	**7.50**	**85.50**	**8.00**

* **Minimum time estimates only. Each installation will vary.

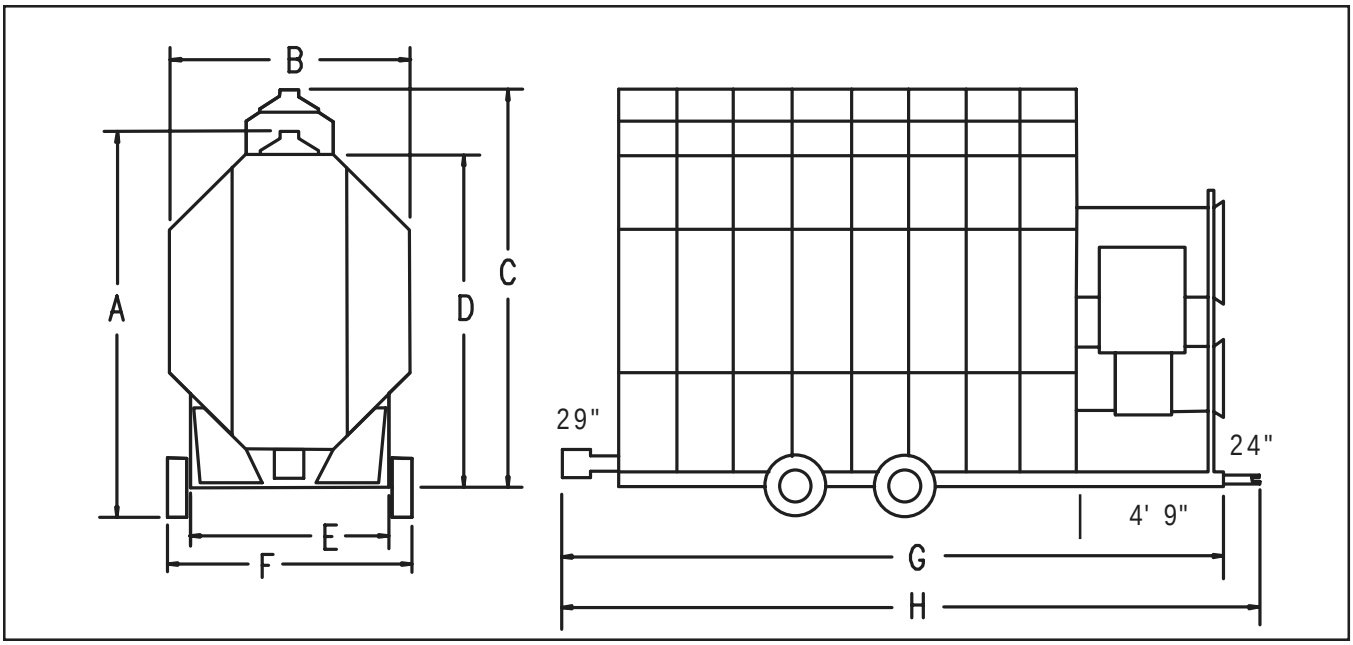


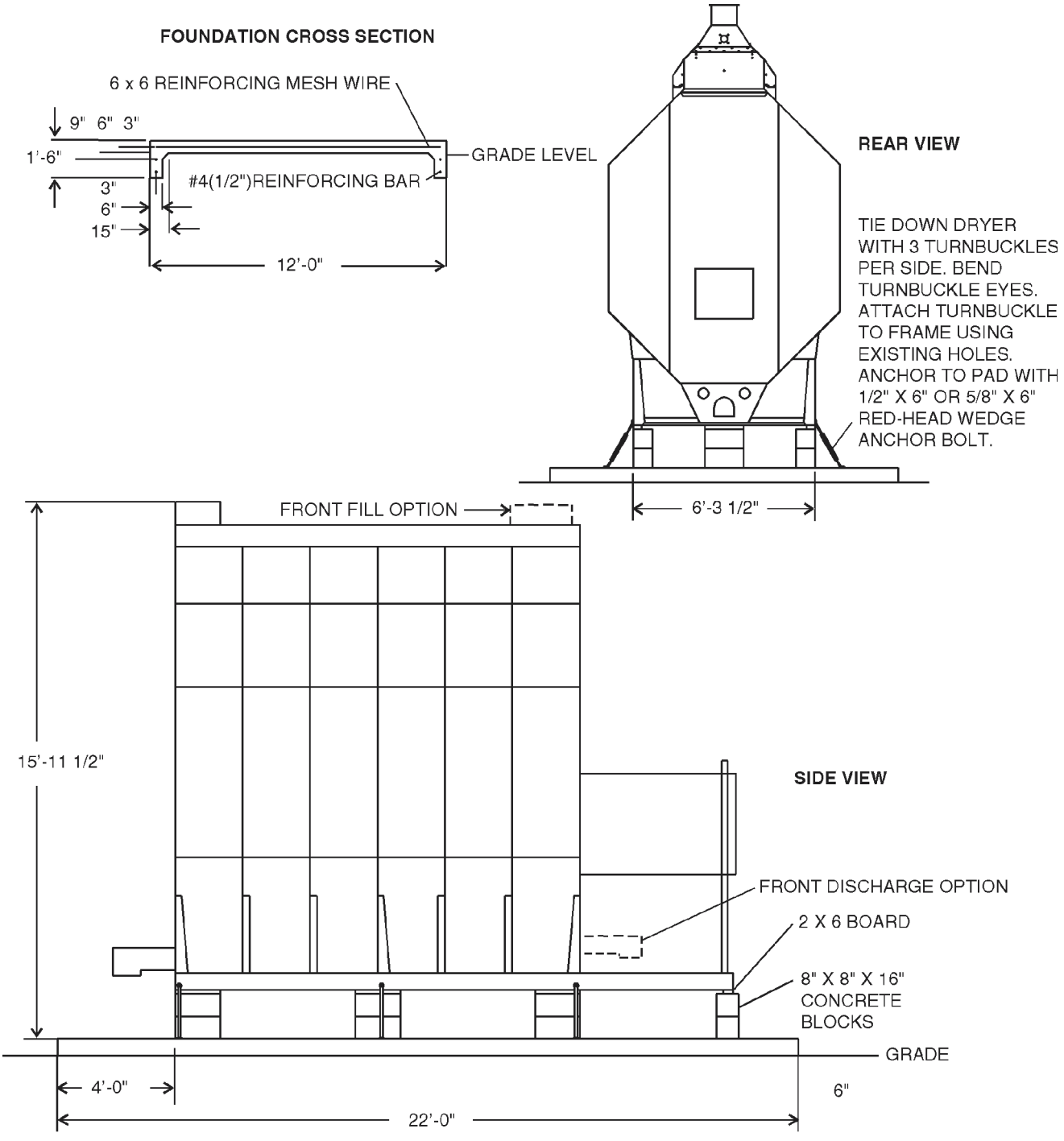
Figure 11: Diagram of dryer dimensions.

Single Module Transport and Installation Dimensions

Values are valid for transportation of stack modules.

Dryer Basket	A Transport Height	B Installed Width	C Installed Height		D Height w/o Wet Bin	E Frame Width	F Transport Width	G Installed Length	H Transport Length
			Wet Bin	Standard Top					
108	11' 11"	8'	13'	11' 6"	10' 3"	6' 5"	8'	115' 2"	117' 2"
110	11' 11"	8'	13'	11' 6"	10' 3"	6' 5"	8'	117' 2"	119' 2"
112	13' 5"	8'	14' 6"	13'	11' 9"	6' 5"	8'	119' 2"	121' 2"
114	13' 5"	8'	14' 6"	13'	11' 9"	6' 5"	8'	121' 2"	123' 2"
116	13' 5"	8'	14' 6"	13'	11' 9"	6' 5"	8'	123' 2"	125' 2"
118	13' 5"	8'	14' 6"	13'	11' 9"	6' 5"	8'	125' 2"	127' 2"
120	13' 5"	8'	14' 6"	13'	11' 9"	6' 5"	8'	127' 2"	129' 2"
122	13' 5"	8'	14' 6"	13'	11' 9"	6' 5"	8'	129' 2"	131' 2"
126	13' 5"	8'	14' 6"	13'	11' 9"	6' 5"	8'	133' 2"	135' 2"
1214S	13' 5"	8' 8"	14' 6"	13'	11' 9"	6' 5"	8'	121' 2"	123' 2"
1218S	13' 5"	8' 8"	14' 6"	13'	11' 9"	6' 5"	8'	125' 2"	127' 2"
1220S	13' 5"	8' 8"	14' 6"	13'	11' 9"	6' 5"	8'	127' 2"	129' 2"
1222S	13' 5"	8' 8"	14' 6"	13'	11' 9"	6' 5"	8'	129' 2"	131' 2"
1226S	13' 5"	8' 8"	14' 6"	13'	11' 9"	6' 5"	8'	133' 2"	135' 2"

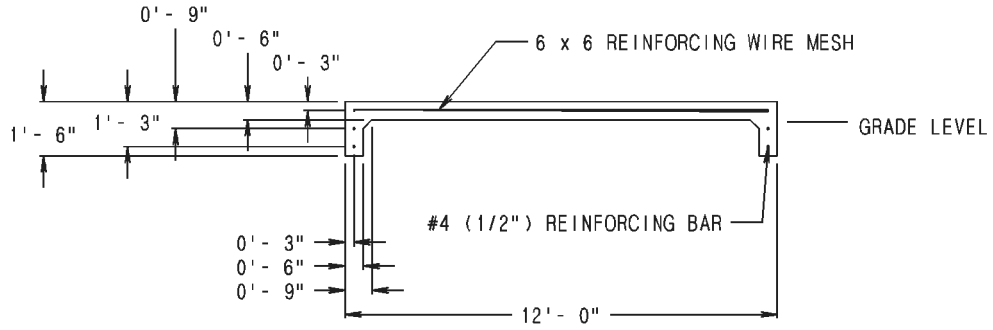
Dimensions For Concrete Block Supports

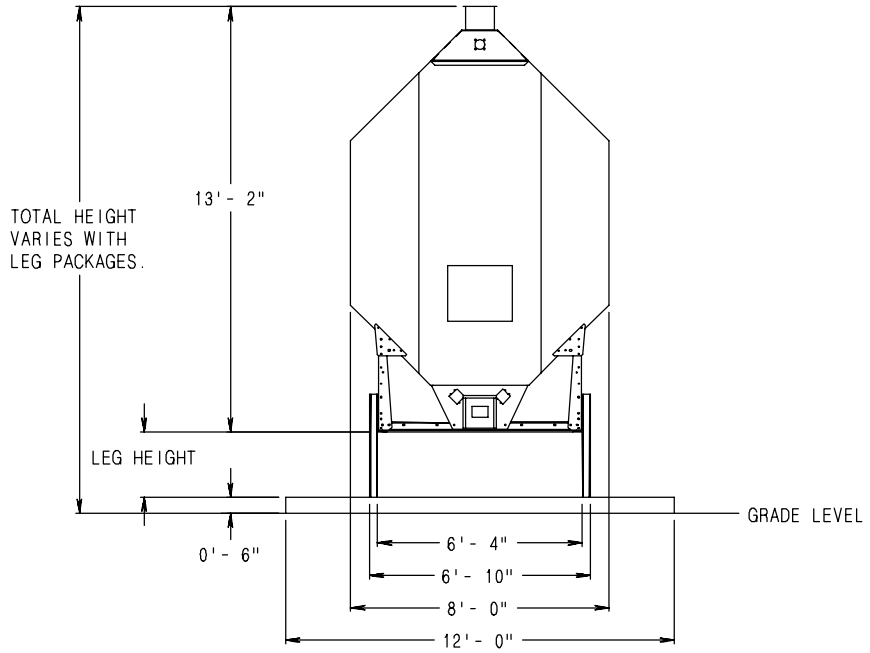


Single Module Specifications

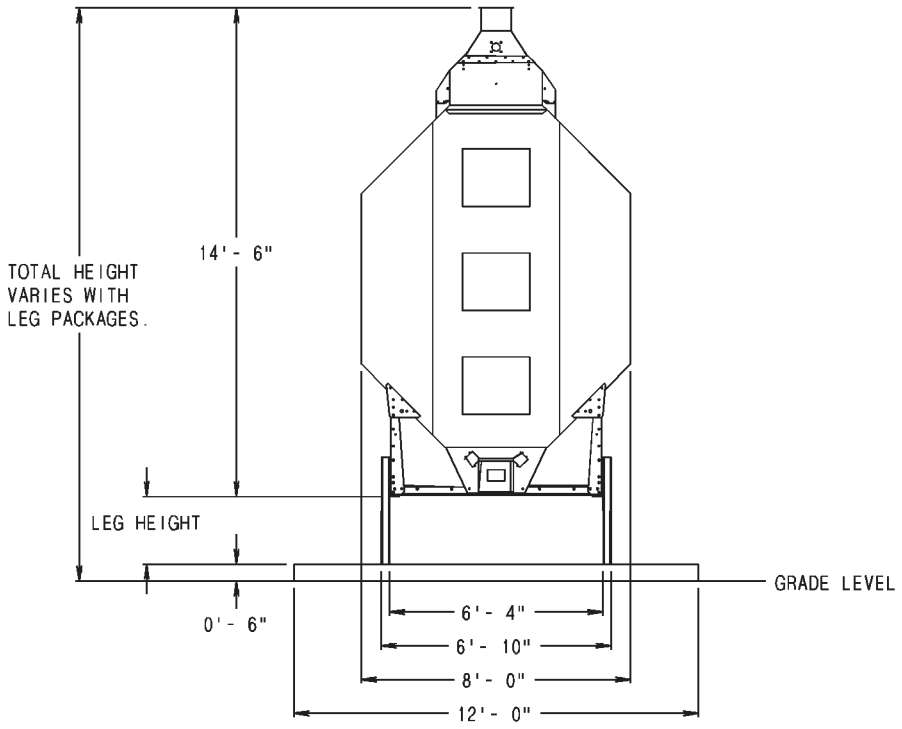
Dryer Basket Length	6	8	10	12	14	16	18	20	22	26
Concrete Pad Size	12 x 16	12 x 18	12 x 20	12 x 22	12 x 24	12 x 26	12 x 28	12 x 30	12 x 32	12 x 36
Yards Concrete	5.3	5.9	6.5	7.1	7.7	8.3	8.9	9.2	10.1	11.3
Reinforcing Rods 20" each	6	6	7	7	7	8	8	8	9	10
Wire Mesh Sq. Ft.	192	216	240	264	288	312	336	360	384	432
Steel Legs(minimum)	8	8	10	10	12	12	14	14	16	18
Anchors	4	4	4	6	6	6	8	8	8	10
Blocks	10	14	14	18	18	18	22	22	26	30
Foot of 2 x 6	10	14	14	18	18	18	22	22	26	30
Turnbuckles	4	4	4	6	6	6	8	8	8	10
Estimated Manhours	8	10	12	14	18	18	20	22	24	28

Quantities are approximate and requirements may vary due to site elevations.
Setup times do not include preparing site and pouring concrete pad.





REAR VIEW

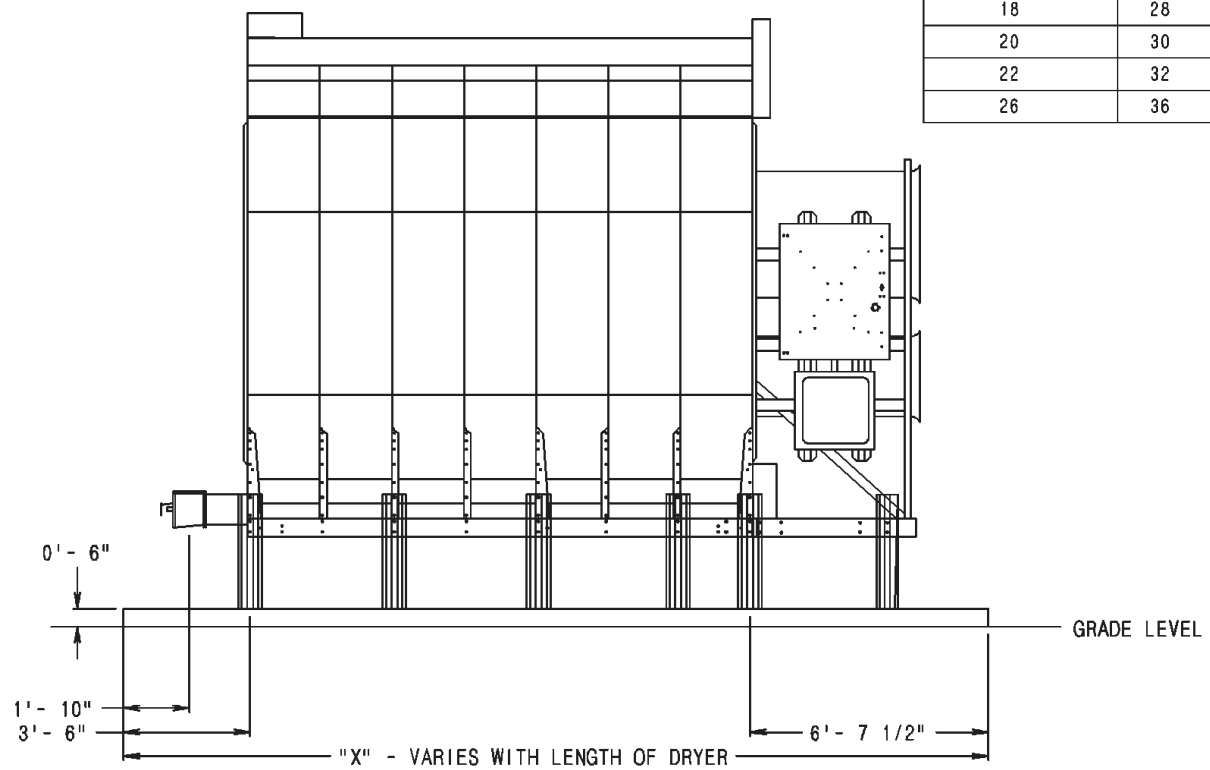


REAR VIEW

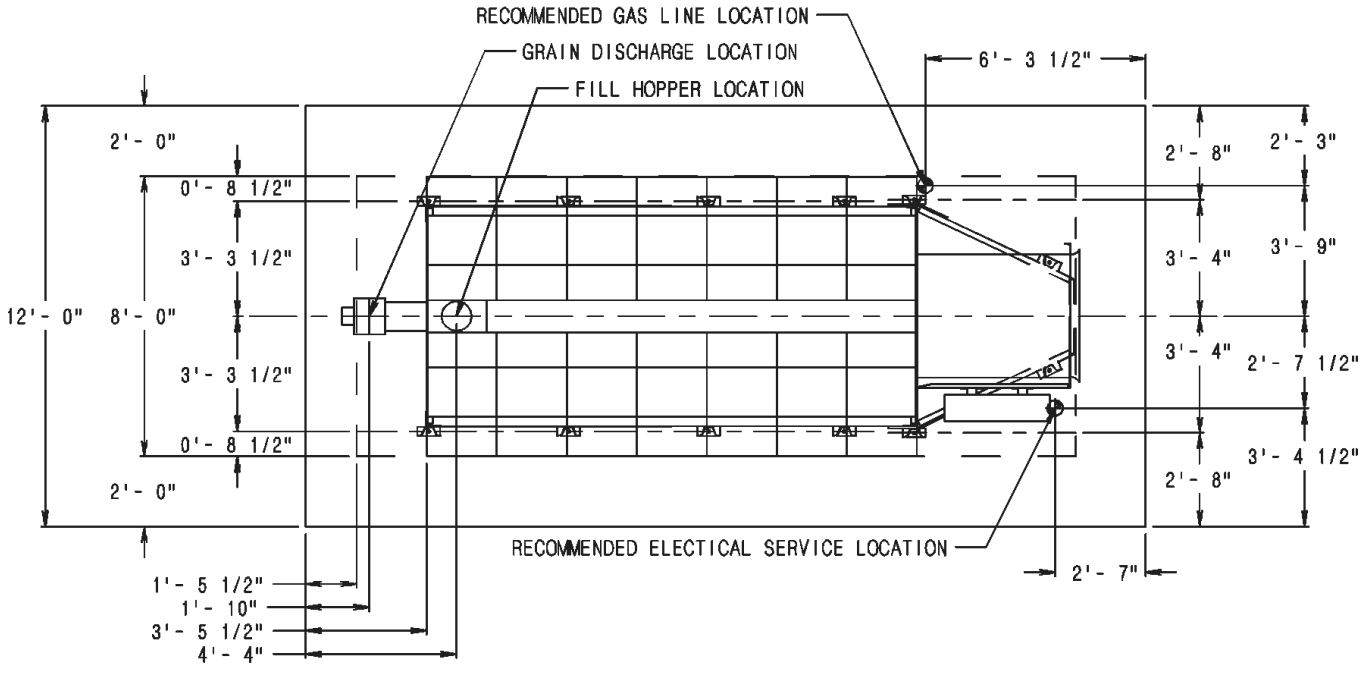
NOTE: INSTALLATION OF THE LEG STANDS SHOULD START AT THE BACK COLUMN LEG OF THE DRYER AND CONTINUE ON EVERY OTHER COLUMN LEG TOWARDS THE FRONT.

SOME DRYERS WILL HAVE TWO LEG STANDS NEAR THE FRONT OF THE BASKET AS SHOWN IN THE DRAWING.

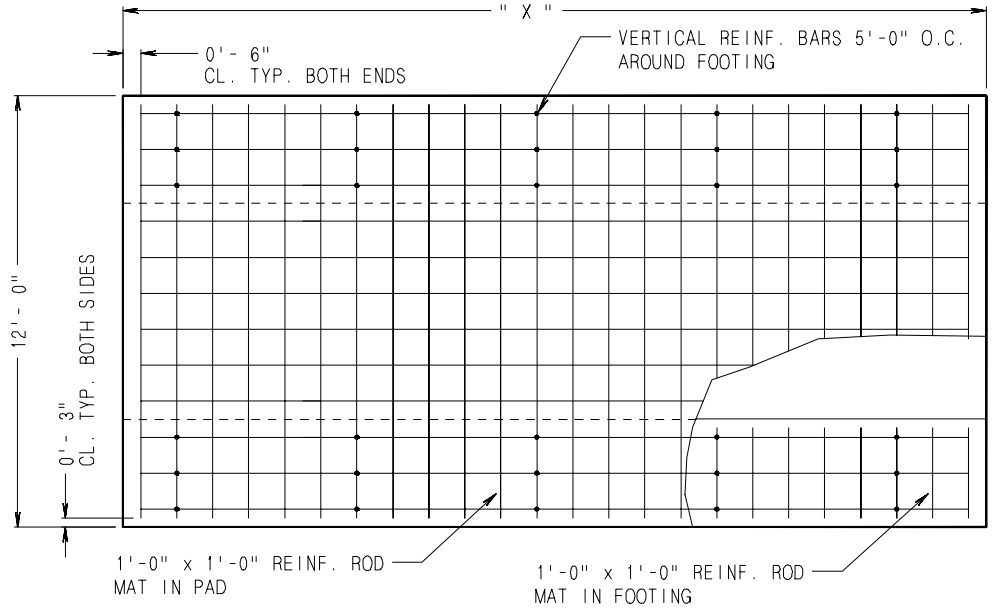
BASKET LENGTH	X (FEET)
08	18
10	20
12	22
14	24
16	26
18	28
20	30
22	32
26	36



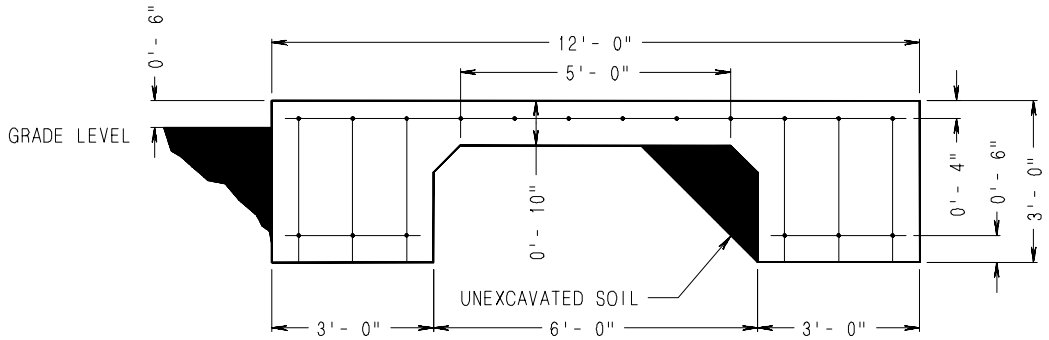
SIDE VIEW



TOP VIEW



FOUNDATION PLAN VIEW



FOUNDATION CROSS SECTION

Stack Dryer Foundation

Basket Length	12	14	18	20	22	26
Concrete Pad Size (12' x "X") [1]	12 x 22	12 x 24	12 x 28	12 x 30	12 x 32	12 x 36
Concrete (cubic yards)	19.00	20.75	24.25	26.00	27.50	31.00
# 4 Rebar (feet) [2]	840	900	1060	1140	1220	1400
Anchors [3]	14	16	20	22	24	28

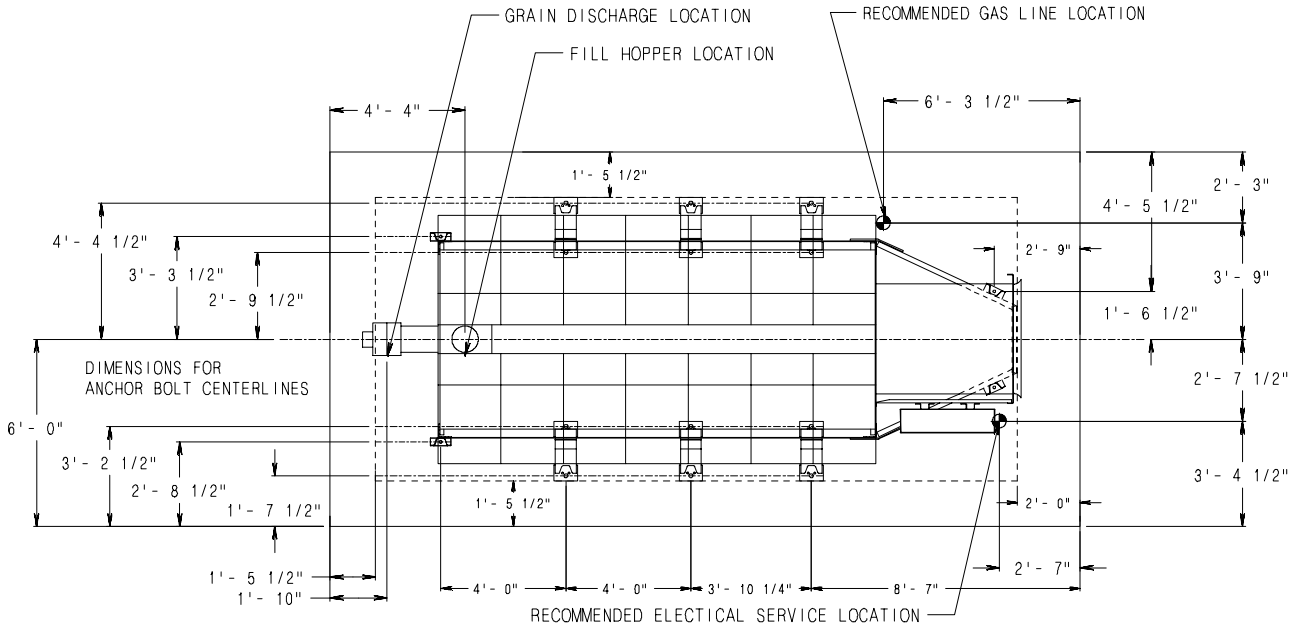
[1] 10" depth with 36" wide x 36" deep footings along each side

[2] #4 reinforcing rods on 1" - 0" centers. Both directions in slab and bottom of footing.

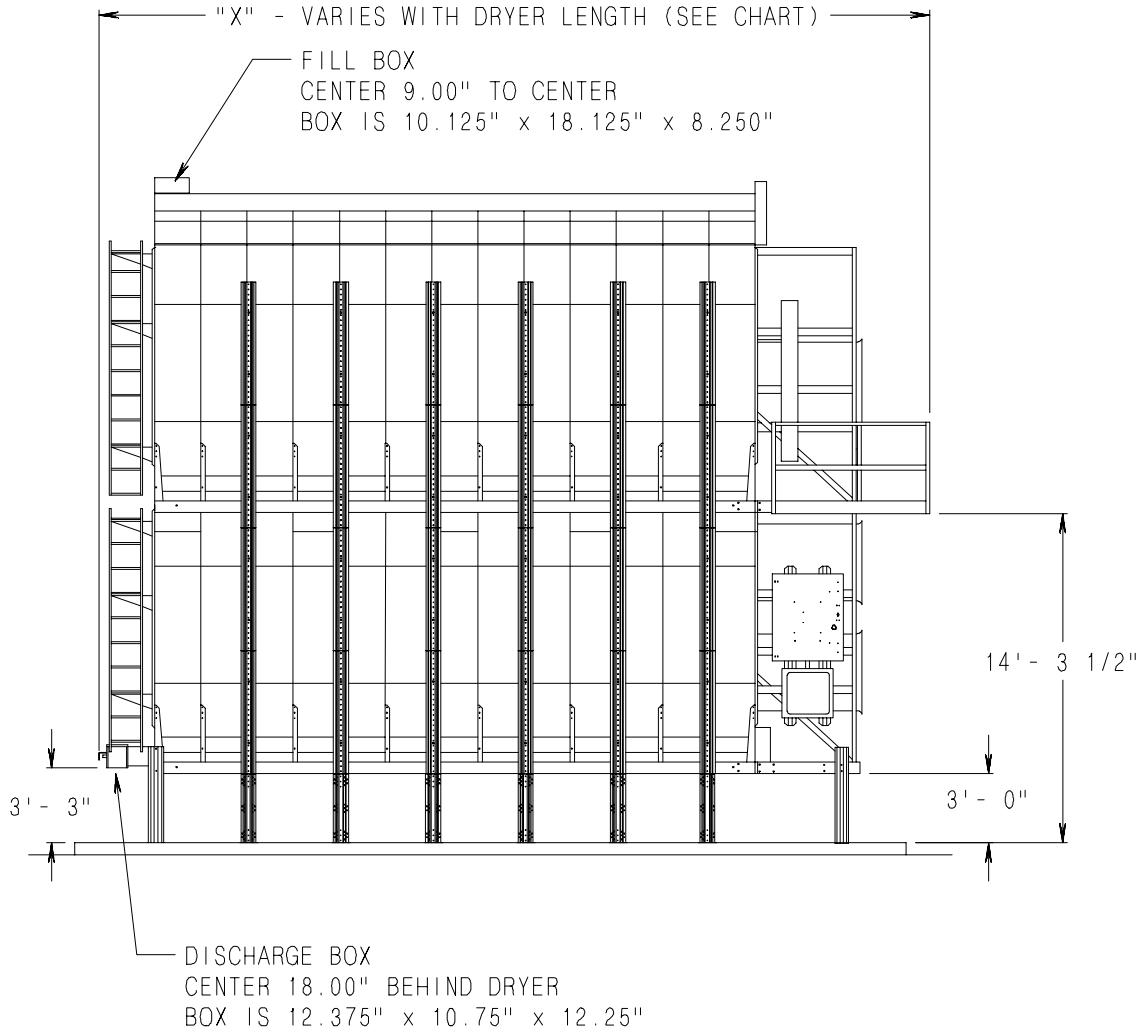
[3] Use 3/4" x 9 5/8" minimum anchors with epoxy. GSI part numbers: anchor (GTC-0003) epoxy (GTC-0004)

Minimum soil bearing capacity = 2000 PSF

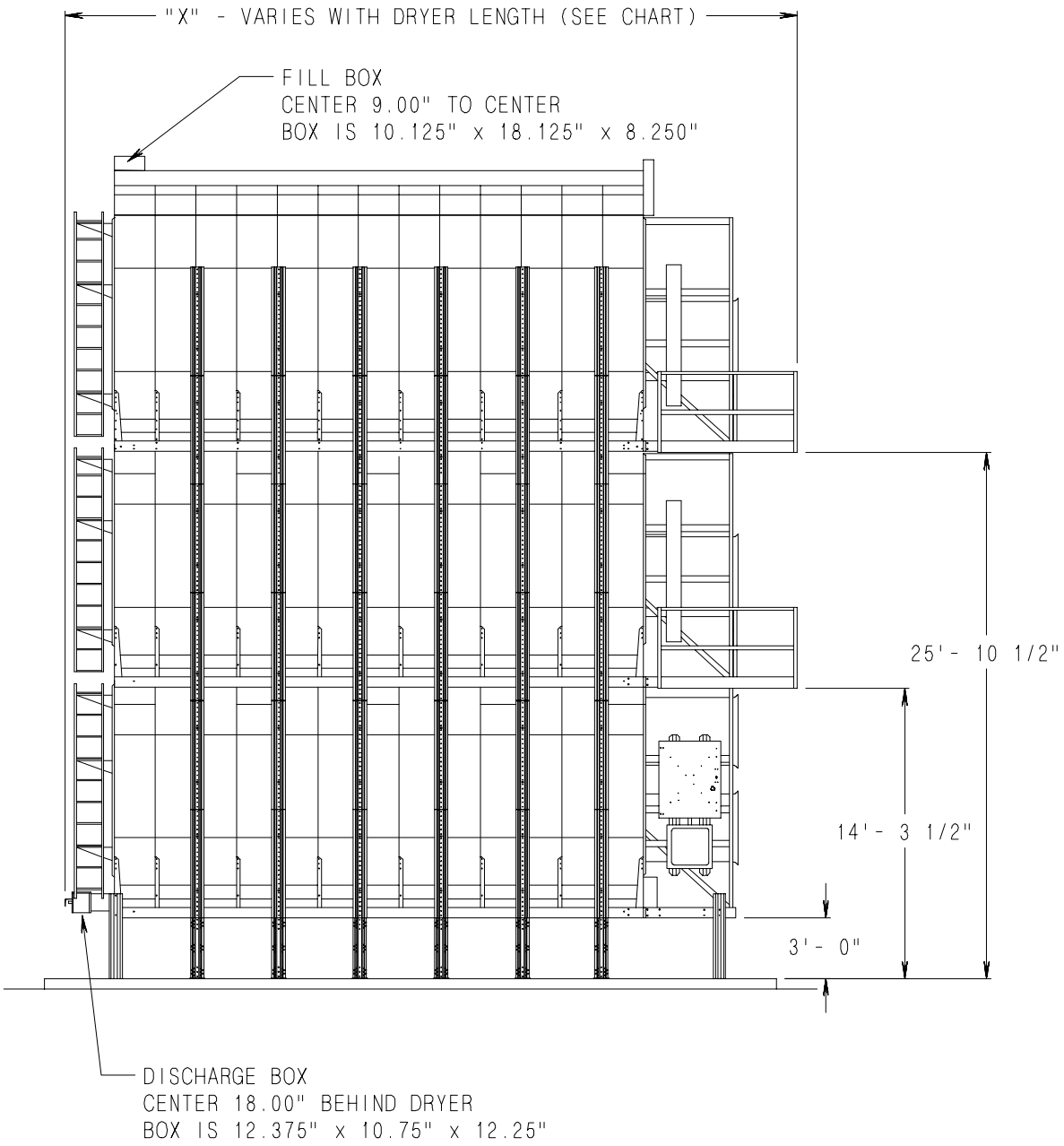
Concrete Specifications
Compressive Strength @ 28 days -- 4000 psi
Minimum Cement Content -- 6 sacks/yard
Maximum Slump -- 4" +/- 1"



EXAMPLE OF STACK DRYER FOOTPRINT



SIDE VIEW - 2 MODULE STACK DRYER

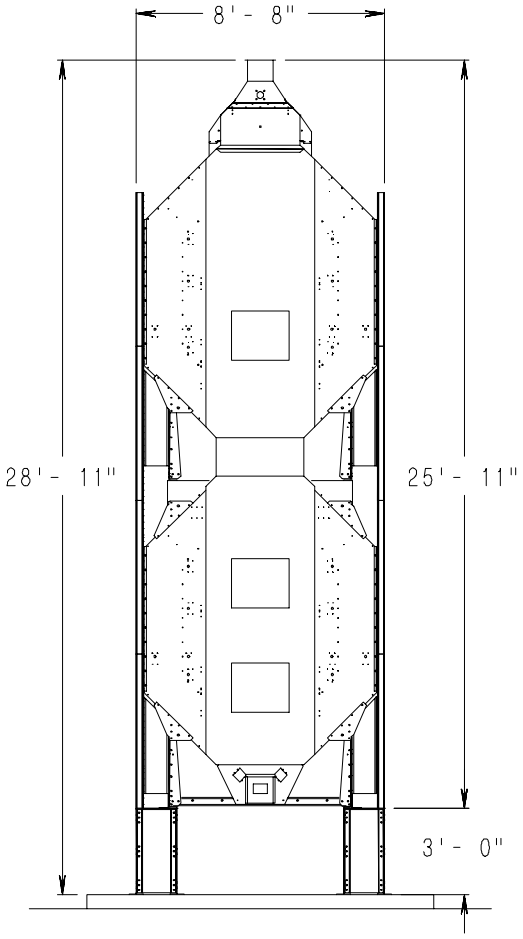


SIDE VIEW - 3 MODULE STACK DRYER

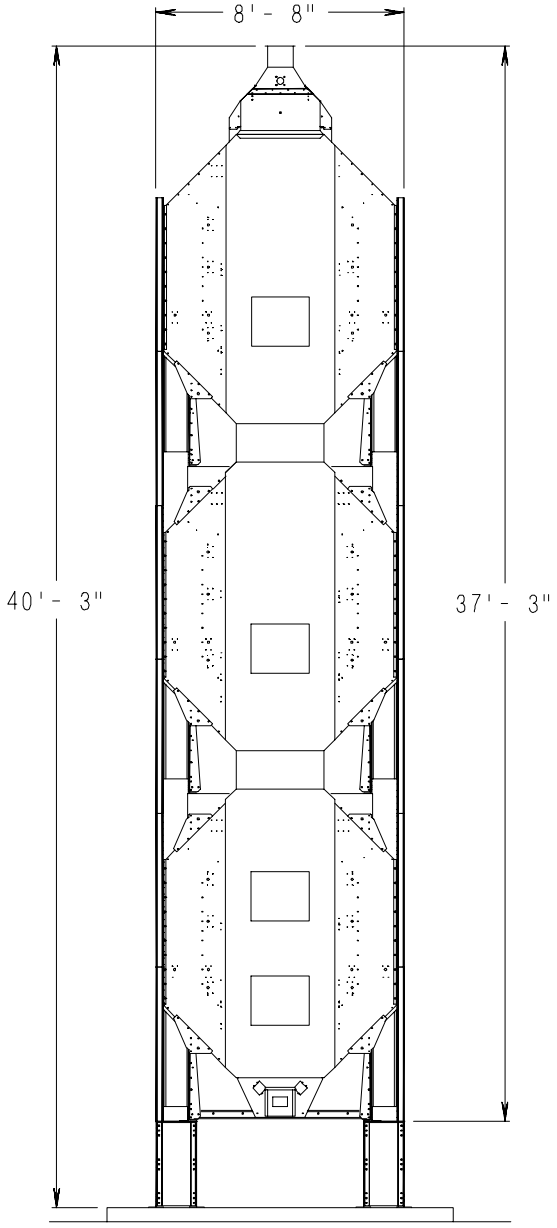
Dryer Installed Length

1, 2, and 3 Module Stacks

Basket Length	Installed Length ("x")
12 ft.	21 ft. 6 in.
14 ft.	23 ft. 10 in.
18 ft.	27 ft. 10 in.
20 ft.	29 ft. 10 in.
22 ft.	31 ft. 10 in.
26 ft.	35 ft. 10 in.



END VIEW - 2 MODULE STACK DRYER



END VIEW - 3 MODULE STACK DRYER

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