

TopDry Series 2000 Autoflow

Operation Manual

PNEG-696

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All information, illustrations, photos and specifications in this manual are based on the latest information available at the time of publication. The right is reserved to make changes at any time without notice.

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Cautionary Symbols Definitions

Cautionary symbols appear in this manual and on product decals. The symbols alert the user of potential safety hazards, prohibited activities and mandatory actions. To help you recognize this information, we use the symbols that are defined below.



This symbol indicates an imminently hazardous situation which, if not avoided, **will result in serious injury or death.**



This symbol indicates a potentially hazardous situation which, if not avoided, **may result in serious injury or death.**



This symbol indicates a potentially hazardous situation which, if not avoided, **may result in minor or moderate injury.**



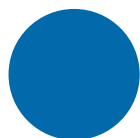
This symbol is used to address practices not related to personal injury.



This symbol indicates a general hazard.



This symbol indicates a prohibited activity.



This symbol indicates a mandatory action.



WARNING! BE ALERT!

Personnel operating or working around equipment 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.

Fan/Heater Installation and Operating Instructions

Thank you for choosing a TopDry Series Autoflow. It is designed to give excellent performance and service for many years.

This manual describes the installation for all standard production TopDry Series 2000 single fan, multi-fan and 2000 Series Heater Control units. Different models are available for liquid propane or natural gas fuel supply, with either 1 phase 230 volt or 3 phase 208, 220, 380, 460 or 575 volt electrical power.

Our foremost concern is your safety and the safety of others associated with this equipment. We want to keep you as a customer. This manual is to help you understand safe operating procedures and some problems that may be encountered by the operator and 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 in the area. Safety precautions may be required from the personnel. Avoid any alterations to the equipment. Such alterations may produce a very dangerous situation where **SERIOUS INJURY** or **DEATH** may occur.

This equipment shall be installed in accordance with the current installation codes and applicable regulations, which should be carefully followed in all cases. Authorities having jurisdiction should be consulted before installations are made.

Safety Precautions

READ THESE INSTRUCTIONS BEFORE OPERATION AND SERVICE SAVE FOR FUTURE REFERENCE

1. Read and understand the operating manual before trying to operate the dryer.
2. Power supply should be **OFF** for service of electrical components. Use **CAUTION** in checking voltage or other procedures requiring power to be **ON**.
3. Check for gas leaks at all gas pipe connections. If any leaks are detected, **DO NOT** operate the dryer. Shut down and repair before further operation.
4. **NEVER** attempt to operate the dryer by jumping or otherwise bypassing any safety devices on the unit.
5. Set pressure regulator to avoid excessive gas pressure applied to burner during ignition and when burner is in operation. **DO NOT** exceed maximum recommended drying temperature.
6. Keep the dryer clean. **DO NOT** allow fine material to accumulate in the plenum or drying chamber.
7. Use **CAUTION** in working around high speed fans, gas burners, augers and auxiliary conveyors which can **START AUTOMATICALLY**.
8. **DO NOT** operate in any area where combustible material will be drawn into the fan.
9. **BEFORE** attempting to remove and re-install any propeller, make certain to read the recommended procedure listed within the servicing section of the manual.
10. Clean grain is easier to dry. Fine material increases resistance to airflow and requires removal of extra moisture.

Use Caution in the Operation of this Equipment

This dryer is designed and manufactured with operator safety in mind. However, the very nature of a grain dryer having a gas burner, high voltage electrical equipment and high speed rotating parts, presents hazards to personnel which cannot be completely safeguarded against without interfering with the efficient operation of the dryer and reasonable access to its components.

Use extreme caution in working around high speed fans, gas-fired heaters, augers and auxiliary conveyors, which may start without warning when the dryer is operating on automatic control.



Keep the dryer clean. Do not allow fine material to accumulate in the plenum chamber or surrounding the outside of the dryer.

Continued safe, dependable operation of automatic equipment depends, to a great degree, upon the owner. For a safe and dependable drying system, follow the recommendations within this manual and make it a practice to regularly inspect the unit for any developing problems or unsafe conditions.

Take special note of the Safety Precautions on Page 5 before attempting to operate the dryer.

The GSI Group recommends you contact your local power company and have a representative survey your dryer installation, so your wiring will be compatible with their system and you will have adequate power supplied to your unit.


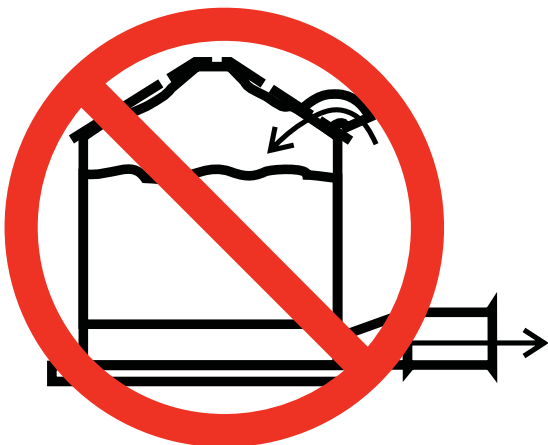
Safety decals should be read and understood by all people in and around the dryer area. If the following safety decals are not displayed on your dryer or if they are damaged, contact The GSI Group for replacement:

GSI Decals

1004 E. Illinois St.
Assumption, IL. 62510
Phone: 1-217-226-4421

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.

 CAUTION	
	
<p>Excessive vacuum (or pressure) may damage roof. Use positive aeration system. Make sure all roof vents are open and unobstructed. Start roof fans when supply fans are started. Do not operate when conditions exist that may cause roof vent icing.</p>	
GSI Group, Inc. 217-226-4421	DC-969

2. Safety Decals

 **DANGER**



**High voltage.
Will cause serious
injury or death.
Lockout power
before servicing.**

DC-1224

DC-1224

 **DANGER**



**Automatic equipment can
start at any time. Do not
enter until fuel is shut off
and electrical power is
locked in off position.
Failure to do so will result
in serious injury or death.**

GSI Group 217-226-4421

DC-973

DC-973



GSI Group 217-226-4421

 **WARNING**

**Stay clear of rotating
blade. Blade could start
automatically. Can cause
serious injury. Disconnect
power before servicing.**

DC-1225

DC-1225



GSI Group 217-226-4421

 **WARNING**

**Flame and pressure beyond
door. Do not operate with
service door removed. Keep
head and hands clear. Can
cause serious injury.**

DC-1227

DC-1227

Power Supply

An adequate power supply and proper wiring are important factors for maximum performance and long life of the dryer. Electrical service must be adequate enough to prevent low voltage damage to motors and control circuits (See electrical load information.)

Transformer and Wiring Voltage Drop

It is necessary to know the distance from the unit to the available transformer and the horsepower of your fan unit. Advise the service representative of your local power supplier that an additional load will be placed on the line. Each fan motor should be wired through a fused or circuit breaker disconnect switch. Check on KVA rating of transformers, considering total horsepower load. The power supply wiring, main switch equipment and transformers must provide adequate motor starting and operating voltage. Voltage drop during motor starting should not exceed 14% of normal voltage and after motor is running at full speed it should be within 8% of normal voltage. Check electrical load information for HP ratings and maximum amp loads to properly size wire and fusing elements. Standard electrical safety practices and codes should be used. (Refer to National Electrical Code Standard Handbook by National Fire Protection Association.)

Machine to Earth Grounding

It is very important that a *Machine To Earth Ground Rod* be installed at the fan. This is true even if there is a ground at the pole 15' away. Place the ground rod that comes standard, within 8' of the dryer and attach it to the dryer control panel with at least a #6 solid, bare, copper ground wire and the clamp provided. The grounding rod located at the power pole will not provide adequate grounding for the dryer. The proper grounding will provide additional safety in case of any short and will ensure long life of all circuit boards and the ignition system. The ground rod must be in accordance with local requirements.

4. Control Panel

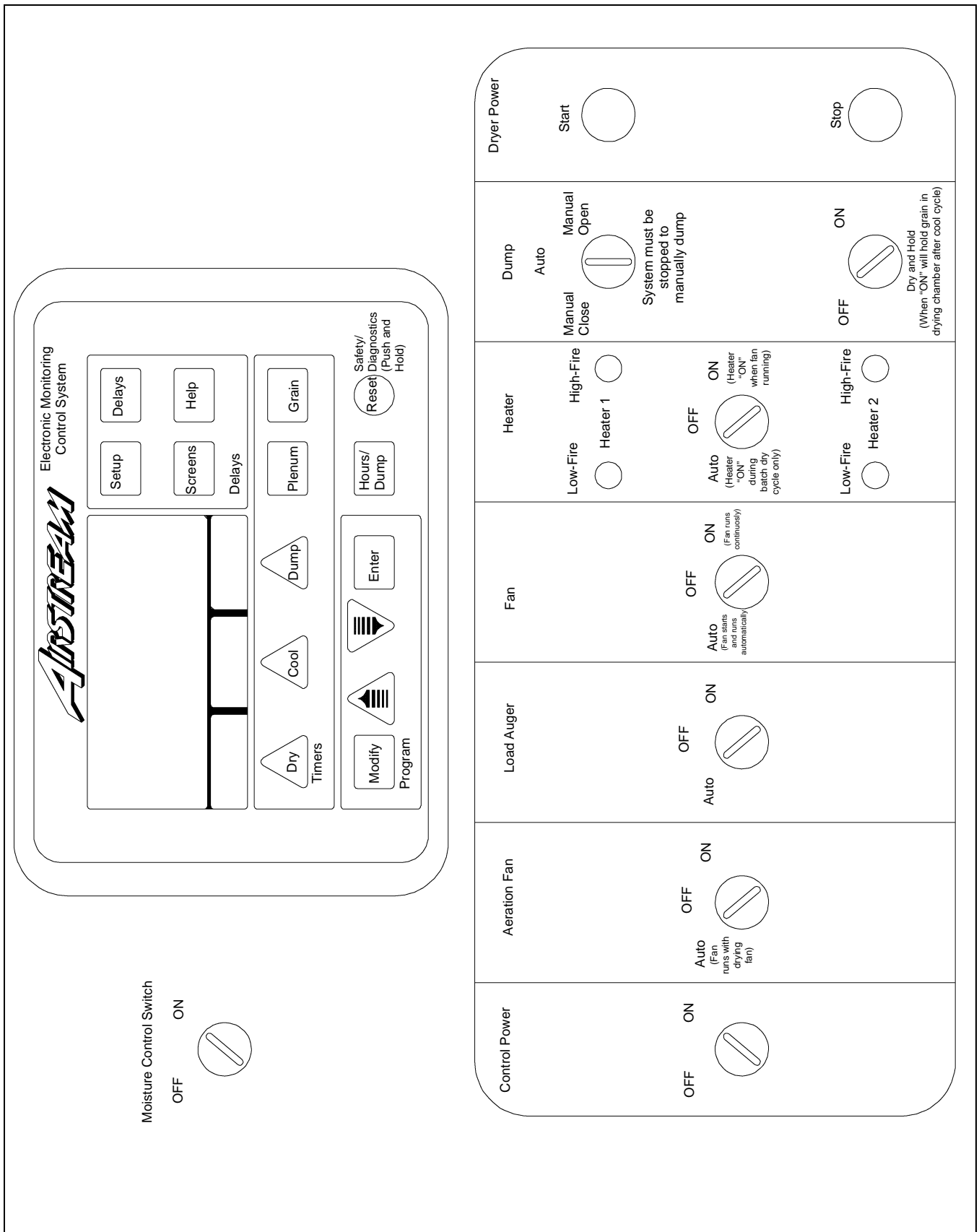


Figure 4A Electronic Monitoring Control System

Dryer Control Panel Featuring the Electronic Monitoring Control System

The control panel provides easy access to gauges and controls and the illuminated switches provide a quick reference for every operating function. The patent pending Electronic Monitoring Control System is a computerized control system that gives instant information regarding dryer operation.

Moisture Control Switch

This switch determines if the grain temperature set point is used in the operation of the dryer. When placed in the “ON” position, the dryer will not enter the dump cycle until the grain temperature has reached the grain temperature set point and the dry timer has reached zero. When placed in the “ON” position, the Moisture Control switch illuminates when the grain temperature is below the grain temperature set point. When placed in the “OFF” position, the dryer ignores the grain temperature and operates strictly OFF of the dry timer. When placed in the “OFF” position, the Moisture Control switch does not illuminate.

Control Power Switch

The power to the Electronic Monitoring Control System is turned ON or OFF with the Control Power switch. The switch illuminates when placed in the “ON” position. If the switch is placed in the “ON” position and the light does not illuminate make sure that the Emergency Stop switches located on the Autoflow control box and Fill System control box are pulled out.

Aeration Fan Switch

This switch controls the operation of the aeration fan located at the bottom of the bin. The switch illuminates when the aeration fan comes ON. When placed in the “AUTO” position the aeration fan starts and stops with the main drying fans. When placed in the “OFF” position, the aeration fan will not run. When placed in the “ON” position, the aeration fan comes ON when the dryer is running.

If the Aeration Fan Bypass is enabled in the Set-up, the aeration fan remains running when the Aeration Fan switch ON, the dryer control panel is placed in the “ON” position. With the Aeration Fan switch placed in the “AUTO” position, the aeration fan will stop any time the dryer stops.

Load Auger Switch

This switch controls the operation of the fill system(s) that load grain into the drying chamber. The switch illuminates when the fill system(s) are running. When placed in the “AUTO” position, the fill system(s) start and stop automatically depending on the level of grain relative to the Drying Chamber High Level Rotary switch. When operating in the Autobatch mode the fill system(s) will shut off 2/3 of the way through the dry cycle even if grain has not reached the Drying Chamber High Level Rotary switch. When placed in the “OFF” position the fill system(s) will not run. When placed in the “ON” position, the fill system(s) work the same as in Auto, except the out of grain timer is ignored.

4. Control Panel

Fan Switch

This switch controls the operation of the main drying fan(s). The switch illuminates when the Air switch located in the sidewall next to the master drying fan senses an increase in static pressure and closes. In the Autobatch mode, the main drying fan(s) shut off automatically in the dump cycle. When placed in the "OFF" position, the main drying fan(s) will not run. When placed in the "ON" position, the main drying fan(s) come ON and stay ON when the dryer is running.

Heater Switch

This switch controls the operation of the burner(s). The switch illuminates when the burner is ON. When the burner is on small lights above and below the Heater switch indicate if the burner(s) are in high-fire or low-fire. In the Autobatch mode, the burner(s) shut off automatically in the cool and dump cycle. When placed in the "OFF" position, the burner(s) will not fire. When placed in the "ON" position, the burner(s) fire anytime the main drying fan(s) are running.

Dump Switch

This switch controls the operation of the linear actuator housed in the actuator control box. The switch illuminates when the linear actuator is moving. When placed in the "MANUAL CLOSE POSITION" the linear actuator in the actuator control box retracts-raising the dump chutes. When placed in the "AUTO" position, the linear actuator extends at the beginning of the dump cycle-lowering the dump chutes and retracts at the end of the dump cycle-raising the dump chutes. When placed in the "MANUAL OPEN" position the linear actuator extends lowering the dump chutes.

Dry and Hold Switch

When placed in the "ON" position, the grain in the drying chamber will not be dumped into the storage chamber at the end of the dry cycle and the dryer will stop and cool for as long as the cool timer is set. If no cooling is desired set to 0. This switch can be used to hold the last batch of grain in the drying chamber and stop the dryer. When placed in the "OFF" position, the dryer will operate normally. The switch illuminates when placed in the "ON" position.

Dryer Power Start Switch

This switch starts and operates the dryer based on switch settings. The switch illuminates when the dryer is running. The Dump switch is disabled after this switch has been pushed.

Dryer Power Stop Switch

This switch stops all dryer functions. If an automatic dryer shut down occurs, first determine and correct the cause of the shut down. Then, press the Dryer Power Stop switch to reset the dryer before starting.

Electronic Monitoring Control System

The Electronic Monitoring Control System controls all timing functions and safety circuit checks. It is designed to simplify dryer operation by providing printed messages and warnings on its liquid crystal display (LCD).

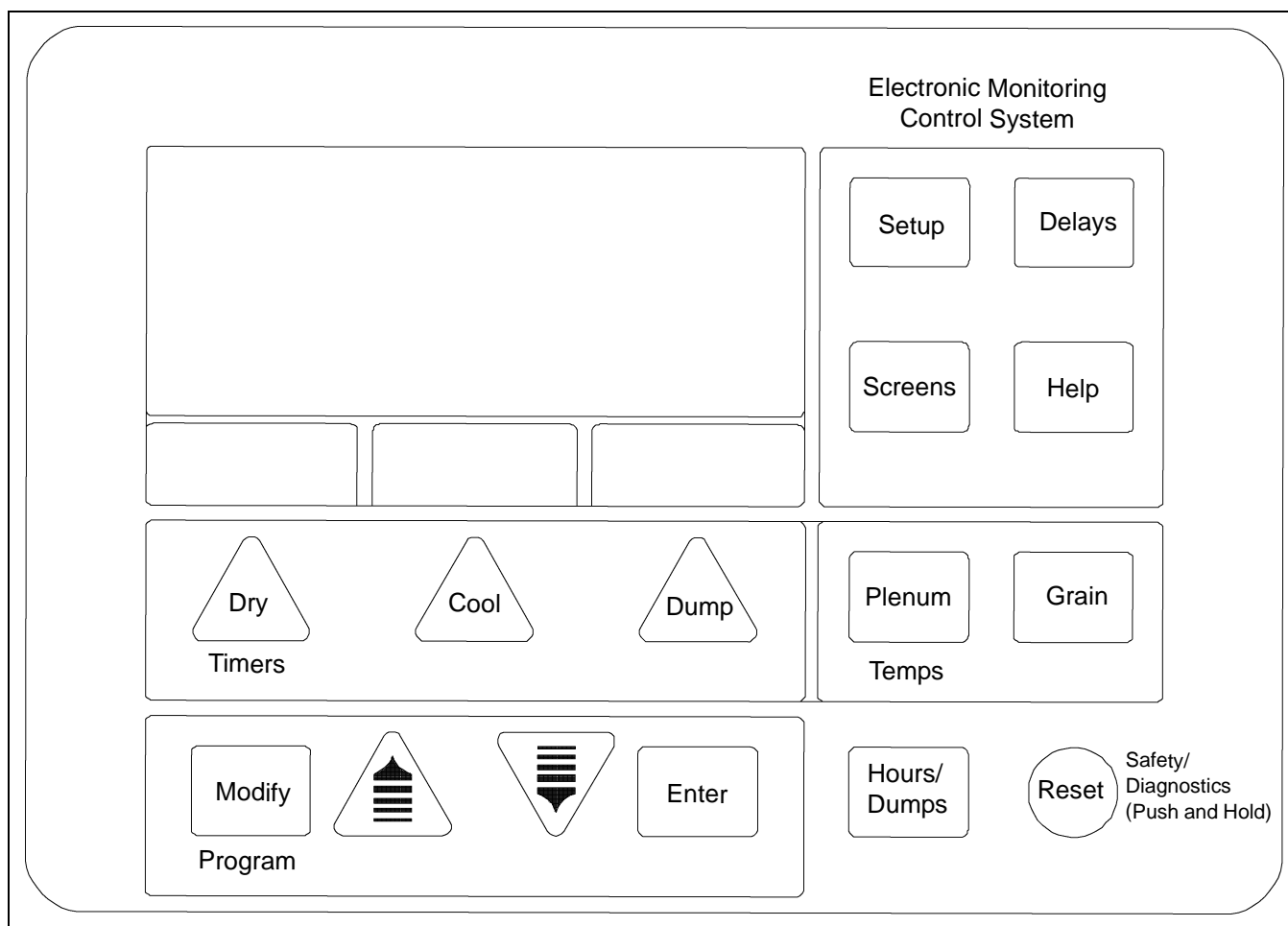


Figure 5A *Electronic Monitoring Control System*

Turning On the Electronic Monitoring Control System

Turn the Control Power switch to the “ON” position. The monitor will display a copyright message, software version number and will enter the main drying screen.

5. Control System

Setting the Dry, Cool and Unload Timers

These switches are used to set the dry, cool and dump cycle times. The current settings on these timers are displayed directly above their timer button. To change the setting of these timers do the following:

1. Press the dry, cool or unload timer button.
2. Press the modify button.
3. Press the increase or decrease button to adjust the settings.
4. Press the enter button.
5. To enter the new value into memory immediately, press the reset button.

During operation the remaining time on each timer is displayed on the screen. If the power goes out or the dryer is stopped these times are saved by the controller. When the dryer is restarted, the timers will continue timing down. The timers will return to their initial settings by pressing the reset button. The cool timer is not used on a Autoflow system except when in cool down mode. The cool timer is used to determine how long the TopDry will cool at shut down. If no cool down is desired set timer to 0. Upon any of the following conditions the system will go into cool down mode.

1. Out of Grain Timer Warning
2. Storage Chamber Full Warning
3. Low Level Switch Exposed Warning
4. Wet Bin Switch Exposed Warning

Setting the Delays

The following Delays are Set by Pressing the Delays Button

Wet Bin Switch Delay - If the Wet Supply Rotary switch is exposed this delay must expire before a warning is given.

Refill Delay - The Refill Delay is used only on batch units. It is the amount of time that the unit has to refill after the dump cycle. If the unit does not refill before the time on the refill delay is at zero the unit will give a "dry chamber empty" error. This delay is not shown in Autoflow mode.

High Level Switch Delay - The value set on the High Level Switch delay is the amount of time that fill system runs after grain reaches the Drying Chamber High Level Rotary switch. The High Level Switch delay should be set long enough so that the Drying Chamber High Level Rotary switch is covered with enough grain that the fill system does not start and stop frequently in the dry cycle due to settling or shrinkage; but, the High Level Switch delay should be set short enough so that grain does not reach the Drying Chamber Overflow Rotary switch.

Fill 1 Delay - This delay is not used in units with only one fill system controlled by the Autoflow. The value set on the fill 1 delay is the amount of time that fill system number one runs after grain reaches the Drying Chamber High Level Rotary switch.

Motor Delay - The motor delay is the delay in seconds between the starting of the master fan unit and the slave fan unit. In systems with 220V 1 PH electrical power, the fan delay should be set at small value - less than 3 seconds. If the motor delay is set too long, the slave fan could rotate fast enough backwards to start in a reverse rotation. Use the increase and decrease buttons to select the motor delay. Press the enter button when the correct motor delay is displayed to continue to the main drying screen. In single fan units, the motor delay is not applicable.

Fans Off Delay - The fans off delay allows the fan and heater unit(s) to be shut down during the dump cycle. This will prevent the drying floor from becoming excessively dirty when there is a large amount of foreign material present in the grain being dried. There are two values that the fans off delay can be set at presently: 1:00 and 0:00. Use the increase and decrease buttons to select the value. When set at 1:00 the fan and heater units will shut off during the dump cycle. When CONTROL SYSTEM set at 0:00 the fan and heater unit(s) will not shut off and the unit will operate normally.

Set-Up: Standard

The following Options are Set by Pressing the Setup Button

Out of Grain Timer - This timer counts down when the fill system(s) start and will shut them off when it has timed out. Default time is 20 minutes.

Clear Total Batches - Press the reset button to clear the total batches. Press the enter button to continue.

Clear Warning History - Press the reset button to clear the warning history. Press the enter button to continue.

Time Until Load OFF - In Autobatch mode is the percentage of time through the dry cycle that the fill systems will be shut off regardless if the dryer is full or not. Press the enter button to return to the main drying screen. This feature is only shown in Autobatch mode.

Set-Up: Extended

The set-up mode is used to program the computer with different variables that influence how the dryer will operate. This mode is accessed by holding in on the modify button when turning on the control panel.

Set Date - Use the increase and decrease buttons to select the correct day of month. Press the enter button when the correct day of month is displayed.

Set Month - Use the increase and decrease buttons to select the correct year. Press the enter button when the correct month is displayed.

Set Year - Use the increase and decrease buttons to select the correct year. Press the enter button when the correct year is displayed.

Set Hour - Use the increase and decrease buttons to select the correct hour. Press the enter button when the correct hour is displayed.

Set Minute - Use the increase and decrease buttons to select the correct minute. Press the enter button when the correct minute is displayed.

Air Switch - Use the increase and decrease buttons to toggle between enabled or disabled. If disabled is selected the dryer does not require proof of airflow before the burner lights. If enabled is selected the dryer requires proof of airflow to light the burner. Each time the dryer control power is shut off the Air switch test defaults to enabled.

Wet Tank Switch - Use the increase and decrease buttons to toggle between enabled and disabled. If the disabled the computer will ignore the status of the Wet Supply Rotary switch. If enabled the dryer will monitor the status of the Wet Supply Rotary switch.

Start Fans with High - Determines whether the drying fan(s) will start with the drying chamber high level. Use the increase and decrease buttons to toggle between enabled or disabled. In most situations the fan(s) should be started with the Drying Chamber High Level Rotary switch. When the Drying Chamber High Level Rotary switch is selected to control the starting of the main drying fan(s) the dry cycle and main drying fan(s) will not start until grain reaches the Drying Chamber High Level Rotary switch.

5. Control System

Aeration Fan Bypass - Allows the aeration fan to remain running after the dryer has shut down. Use the increase and decrease buttons to toggle between enabled and disabled. When the aeration fan bypass is enabled, the aeration fan will remain running after the dryer has stopped if the Aeration switch ON the dryer front panel is placed in the "ON" position. When the aeration fan bypass is disabled, the aeration fan stops with the dryer.

Number of Fill Systems - Use the increase and decrease buttons to toggle between one or two fill systems. Press the enter button when the number of fill systems displayed on the screen equals the number of fill systems that the computer will be controlling. If one fill system is selected only one fill system will be controlled by the computer. The High Level SW delay will be used to delay the shut off of the fill system after the drying chamber is full. The Fill 1 delay will have no effect on the operation of the fill system. If two fill systems are selected two (2) fill systems will be controlled by the computer. Both the High Level SW delay and the Fill 1 delay are used by the computer to delay the shut off of the fill systems after the drying chamber is full.

Select Dryer Type - Use the increase and decrease buttons to select one of the four (4) model types that fits your system. The four (4) models are as follows:

1. AF2 - Autoflow with two (2) main drying fans
2. AF1 - Autoflow with one main drying fan
3. AB2 - Autobatch with two (2) main drying fans
4. AB1 - Autobatch with one main drying fan

Most systems will be either an Autoflow with one fan or an Autoflow with two (2) fans. Press the enter button when the correct model number is displayed.

Select Temp Scale - Use the increase and decrease buttons to toggle between Fahrenheit or Celsius. Press the enter button when the correct scale is displayed.

Burner Cycle - ON/OFF or High-Low cycle.

Burner Differential - Use the increase and the decrease buttons to change the burner differential. The burner differential is the span in degrees between high-fire and low-fire when the high/low option has been selected. When the temperature in the dryer reaches the plenum temperature set point plus the differential the burner will cycle from high-fire to low-fire. When the temperature in the dryer falls to the plenum temperature set point minus the differential the burner will cycle from low-fire to high-fire.

Example: Plenum temperature set point = 180°, temperature differential set to 3°. The burner will cycle from high-fire to low-fire at 183° and will cycle from low-fire to high-fire at 177°. When burners are set to,

Diesel - Select for diesel burners only.

Plenum High-Limit - Setable high-limit that will shut the dryer down when met. Default is 20° above set plenum set point.

Grain Temp High-Limit - Setable high-limit that will shut the dryer down when met. Default is 30° above set plenum set point.

Plenum and Grain Temperature Settings, Screens Button Options

Plenum

The temperature that the burner cycles from high-fire to low-fire is set here. Use the increase and decrease to change the value. Press enter when done.

Grain

The grain temperature set-point is set here. Use the increase and decrease buttons to change the grain temperature set point. Press the enter button when done.

Screens

By pressing the screens button you can toggle between two (2) screens. Screen #1 displays the current plenum and grain temperatures and their set points in parenthesis. Screen #2 displays the status of the Drying Chamber Rotary switches and the total number of batches. In all screens the dry time and dump time are displayed at the bottom of the screen.

6. Fill System Control Box

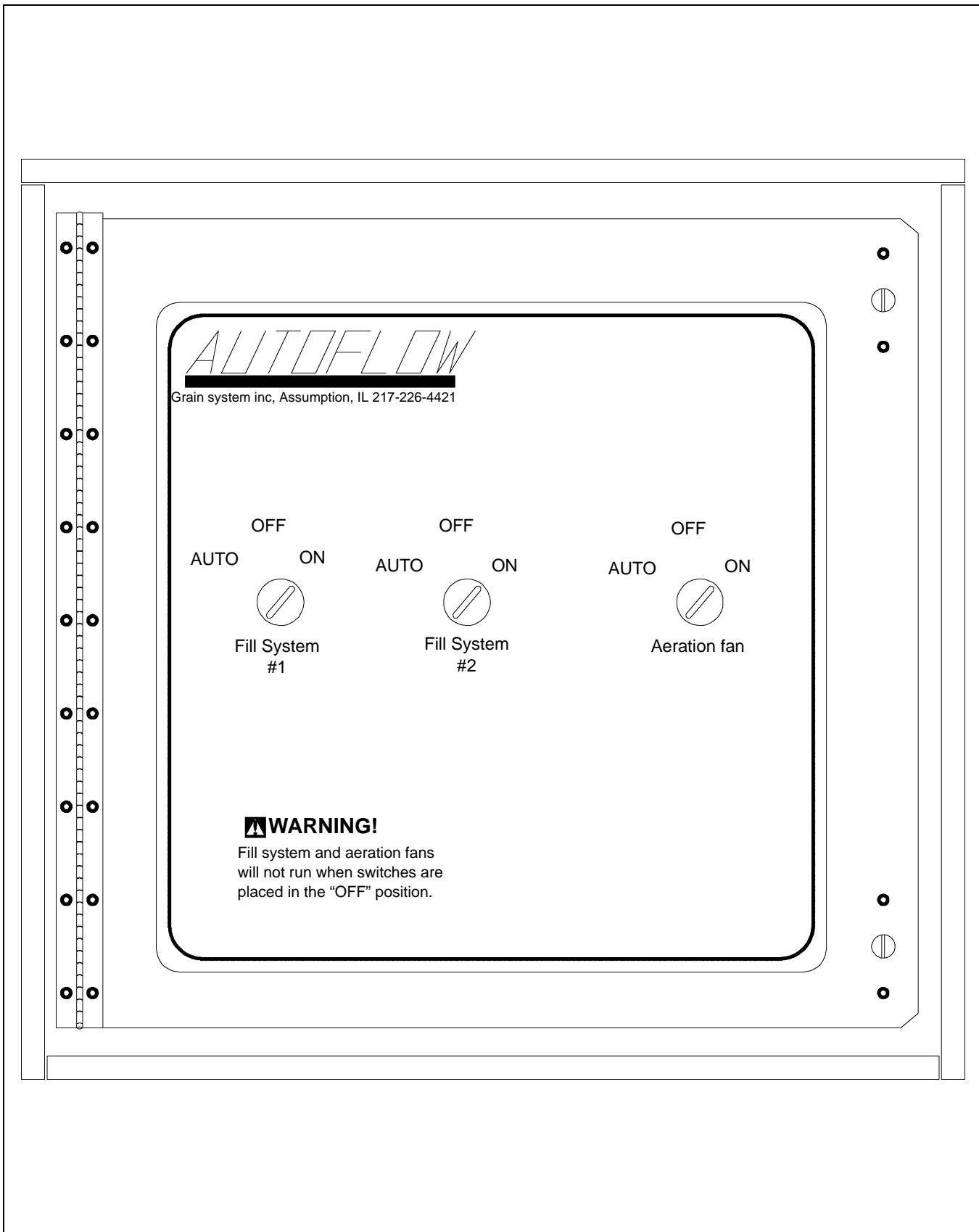


Figure 6A

Fill System Control Box

The fill system control box houses the motor starters for fill system #1, fill system #2 and the aeration fan. Switches are located on the front of the fill system control box and an Emergency Stop switch is located on the side of the control box.

Fill System #1

This switch is used to start and stop fill system #1 manually. The switch should be left in the “AUTO” position for normal dryer operation. If the switch is placed in the “OFF” position fill system #1 will not start and will stop if running. If the dryer control power is ON, fill system #1 can be activated by placing the switch in the “ON” position. When placed in the “ON” position, fill system #1 will operate continuously.

Fill System #2

This switch is used to start and stop fill system #2 manually. The switch should be left in the “AUTO” position for normal dryer operation. If the switch is placed in the “OFF” position fill system #2 will not start and will stop if running. If the dryer control power is ON, fill system #2 can be activated by placing the switch in the “ON” position. When placed in the “ON” position, fill system #2 will operate continuously.

Aeration Fan

This switch is used to start and stop the aeration fan manually. The switch should be left in the “AUTO” position for normal dryer operation. If the switch is placed in the “OFF” position the aeration fan will not start and will stop if running. If the dryer control power is ON, the aeration fan can be activated by placing the switch in the “ON” position. When placed in the “ON” position, the aeration fan will operate continuously.

Emergency Stop Switch

This switch will stop the dryer when pushed and should be used in case of emergency.

7. Error Messages

When the dryer shuts down the user can quickly determine what caused the shut down by viewing the display on the dryer control panel. The Electronic Monitoring Control System displays the error message and sounds a warning signal to alert the user. The displayed error conditions and their electrical cause are as follows:

Burner 1 Loss Flame

The flame sensor in burner number one has failed to detect flame. Either the burner failed to light or the flame sensor needs to be adjusted. The flame sensor is the sensor attached to the burner and has a single lead. If the burner is lighting but the unit is still shutting down due to loss of flame the flame sensor needs to be adjusted. The flame sensor can be adjusted by bending it so it is immersed in flame. If the burner is not lighting make sure that the dryer is getting fuel, all solenoids are opening and the ignitor is sparking.

Burner 2 Loss Flame

The flame sensor in burner number two (2) has failed to detect flame. Either the burner failed to light or the flame sensor needs to be adjusted. The flame sensor is the sensor attached to the burner and has a single lead. If the burner is lighting but the unit is still shutting down due to loss of flame the flame sensor needs to be adjusted. The flame sensor can be adjusted by bending it so it is immersed in flame. If the burner is not lighting make sure that the dryer is getting fuel, all solenoids are opening and the ignitor is sparking.

Fan 1 Vapor High-Limit

The LP gas vapor temperature sensor located on the gas pipe train downstream from the vaporizer coil on fan and heater number one has opened indicating that the vaporizer coil is running too hot and must be adjusted. This sensor is set at 200° Fahrenheit and automatically resets itself when cool. The vaporizer is adjusted by loosening the bolt and moving the vaporizer coil away from the flame.

Fan 2 Vapor High-Limit

The LP gas vapor temperature sensor located on the gas pipe train downstream from the vaporizer coil on fan and heater number two (2) has opened indicating that the vaporizer coil is running too hot and must be adjusted. This sensor is set at 200° Fahrenheit and automatically resets itself when cool. The vaporizer is adjusted by loosening the bolt and moving the vaporizer coil away from the flame.

Fan 1 Housing High-Limit

The temperature high-limit located on the housing on fan and heater number one opened, indicating that the housing towards the bin has overheated. This high-limit sensor is set at 200° Fahrenheit and must be manually reset.

Fan 2 Housing High-Limit

The temperature high-limit located on the housing on fan and heater number two (2) opened, indicating that the housing towards the bin has overheated. This high-limit sensor is set at 200° Fahrenheit and must be manually reset.

Plenum High-Limit

An over temperature condition has occurred inside the dryer plenum. The plenum high-limit is set automatically on the high-low thermostat when the cycle set point is adjusted and resets automatically when cooled. The low-fire gas pressure needs to be lowered or the cycle set point on the high-low thermostat needs to be increased if the error is displayed frequently.

Fan 1 Motor Overload

The thermal overload in the control box on fan number one has tripped, indicating an overcurrent condition. The overload must be reset manually.

Fan 2 Motor Overload

The thermal overload in the control box on fan number two (2) has tripped, indicating an overcurrent condition. The overload must be reset manually.

Fan 1 Loss of Airflow

The contacts on the Air switch, located in the master fan opened due to the fan not turning or the Air switch may need to be adjusted.

Fan 2 Loss of Airflow

The contacts on the Air switch, located in the slave fan opened due to the fan not turning or the Air switch may need to be adjusted.

Drying Chamber Overflow

The grain level in the drying chamber has reached the Drying Chamber Overflow Rotary switch. Grain will have to be dumped from the drying chamber to the storage chamber before the unit can be restarted. This error indicates that either the Drying Chamber High Level Rotary switch is faulty or the time on the High Level switch delay needs to be lowered.

Bin Grain High-Limit Full

The grain level in the storage chamber has reached the Storage Chamber High Level Rotary switch located 3' below the fan and heater(s). Grain will have to be removed from the storage chamber before the unit can be restarted.

Bin High-Limit Switch Bad

The Storage Chamber High Level switch has failed. Both the normally open and the normally closed sides of the switch are in the same state.

Out of Grain

The out of grain timer has ran for longer than it was set. Either you are out of grain or the fill system is filling to slow.

7. Error Messages

Fill 1 Motor Overload

The thermal overload in the fill system control box for fill system number one has tripped, indicating an overcurrent condition. The overload must be reset manually.

Fill 2 Motor Overload

The thermal overload in the fill system control box for fill system number two (2) has tripped, indicating an overcurrent condition. The overload must be reset manually.

Aeration Overload

The thermal overload in the fill system control box for the aeration fan has tripped, indicating an overcurrent condition. The overload must be reset manually.

Grain High-Limit

The grain temperature in the drying chamber is too high. The grain temperature reached a point where it was 5° less than the plenum cycle set point.

Before the dryer is filled, thoroughly inspect the unit and check the operation of the dryer as follows. When entering the bin take great caution. Never enter a bin where grain is present.

Set Control Switches

1. Moisture Control Switch - "ON"
2. Aeration Fan Switch - "OFF"
3. Load Auger Switch - "OFF"
4. Fan Switch - "OFF"
5. Heater Switch - "OFF"
6. Dump Switch - "AUTO"
7. Dry and Hold Switch - "OFF"
8. All Emergency Stop switches must be pulled out. These are located on Fan Heater, Main Control Panel, Fill System Box and Actuator Box.

Control Power Switch

Turn the Control Power switch ON. The switch will illuminate. If a fault is found an error message will be displayed on the screen. If all are found safe, the main drying screen will be displayed.

Drying Chamber

Enter the drying chamber and inspect each dump hopper for obstructions that may inhibit the flow of grain into the dump chutes. Make sure that the gap between the discharge flow plates and the floor sheets is a minimum of 1-1/2". All discharge flow plates should be adjusted evenly around the bin. Inspect each discharge flow plate and make sure that the bottom brackets on each flow plate have not collapsed due to pressure from walking around the drying chamber. Inspect the leveling bands. Make sure that all leveling bands are installed properly and in are good shape.

Rotary Switches

View the Drying Chamber Rotary switches from the peak hole on top of the dryer. Make sure that all three (3) Rotary switches are spinning freely. Double check the seal on each Rotary switch top. The number one cause of switch failure is water. Make sure when the electrician replaced the top on the Rotary switch that no creases formed in the gasket. Inspect both the Storage and Wet Supply Rotary switches for operation and proper seal.

Dump Chutes

Enter the storage chamber. Make sure that all dump chutes are adjusted evenly. When one chute is level make sure that all chutes are level. This is very critical to the correct operation of the dryer. The center plate that all the dump chute chains attach to should be no greater that 12" from the pulley when the chutes are level. If the center plate is further than 12" from the pulley when the chutes are closed the chains must be lengthened.

8. Pre-Season Checks

Linear Actuator

Turn the Dump switch on the Autoflow control box to the "MANUAL OPEN" position. Use a tape measure to measure the stroke on the linear actuator. The stroke should be between 16" and 18". If the stroke on the actuator is not 16" to 18" the actuator should be adjusted. Make sure that all pulleys and cables are move freely when the actuator is moving. With the actuator extended enter the storage chamber. View each dump chute individually. Make sure that each dump chute opened completely when the actuator extended. If a dump chute does not open completely the double nuts on the bolt that the chutes hinge on need to be loosened. The dump chutes should hinge smoothly. After the chutes have been inspected turn the Dump switch on the Autoflow control box to the "AUTO" position and press the Stop switch. The chutes should raise.

Power Start Button

Before the dryer start button is pushed make sure there is grain in the wet supply tank. If there is no grain in the wet supply tank, the dryer will not start. Push the dryer start button. The screen should no longer be flashing "Stopped".

Fuel Check

If using LP gas, make sure the tank has plenty of fuel. If using natural gas, make sure an adequate supply is available. If using LP gas, slowly open the main fuel supply valve at the tank. If using natural gas, turn ON the valve along the supply line. Then open the ball valve on the fan heater unit(s). Inspect all gas lines and connections for possible leaks. Any gas leaks need to be fixed immediately.

Fan

Make sure that all Toggle switches on the fan and heater units are ON. Bump the Fan switch on the Autoflow control box and observe the fan rotation. The fan should run counterclockwise. Sometimes on 3 phase models the motor will run backwards. This can easily be reversed by first turning OFF the power at the main disconnect, then interchanging any two (2) of the three (3) power supply wires coming into the motor starter in the fan control box. Reverse the two (2) outside wires, L1 and L3 and leave the middle one in the same position.

Aeration Fan

Bump the aeration Fan switch on the Autoflow control box and observe the aeration fan rotation. The aeration fan should run counterclockwise. Sometimes on three (3) phase models the motor will run backwards. This can easily be reversed by first turning OFF the power at the main disconnect, then interchanging any two (2) of the three (3) power supply wires coming into the motor starter in the fill system control box. Reverse the two (2) outside wires, L1 and L3 and leave the middle one in the same position.

Fill System

Prepare the wet storage tank to deliver grain to the dryer. Make sure all personnel are away from any machinery that is controlled by the Autoflow. Place the Load Auger switch in the "AUTO" position. The fill system(s) should begin to load grain from the wet supply tank to the dryer. When the display on the Autoflow control box reads "GRAIN LOW LEVEL YES" close the valve that supplies the fill system(s) with wet grain from the wet supply tank. After the fill system(s) have cleaned out place the Load Auger switch in the "OFF" position.

Air Switch

Place the fan and heater service switches on the main drying fan(s) in the "OFF" position. Place the Fan switch on the Autoflow control box in the "ON" position. Place the aeration Fan switch on the Autoflow control box in the "ON" position. Go to the master fan and heater unit. Place the fan service switch in the "ON" position. The master fan should start. In two (2) fan units, the slave fan should start after the fan delay. In single fan units, the display on the master fan will read airflow after the master fan reaches half speed. If the display reads airflow before the fan reaches half speed adjust the Air switch by turning it clockwise. If the display does not read airflow adjust the Air switch by turning it counterclockwise. In two (2) fan units, the display on the master fan should read airflow after the slave fan reaches half speed. If the display reads airflow before the fan reaches half speed adjust the Air switch by turning it clockwise. If the display does not read airflow adjust the Air switch by turning it counterclockwise.

Burner Test Fire

Place the Heater switch on the Autoflow control box in the "ON" position. Start the main drying fan(s) if they are not already running. Make sure the fuel supply is ON. The burner should ignite after a short purge delay. Gas pressure should be shown on the gauge. Adjust the high-fire gas pressure by turning the regulator in and out on LP units; or, by opening and closing the main ball valve on natural gas units. The high-fire pressure should be approximately 6-15 lbs. For LP units and 6-10 lbs. For natural gas units. While the heater is in low-fire adjust the low-fire gas pressure by opening or closing the ball valve located on top of the pipe train. The low-fire gas pressure should be approximately 2-6 lbs. For LP units and 1-3 lbs. For natural gas units. If the burner remains in high-fire and does not cycle, increase the gas pressure in order to reach the plenum cycle set point. If the burner remains in low-fire and does not cycle, slightly decrease the gas pressure at the low-fire gas valve. Any time the high-fire gas pressure is adjusted the low-fire gas pressure needs to be checked. The basic rule-of thumb for setting gas pressure is as follows: Make sure that the temperature in the bin is increasing at a rapid rate when in high-fire and the temperature in the bin is falling at a rapid rate while in low-fire.

Dryer Shut Down

To shut down the dryer, first close the fuel supply valve at the tank or the valve along the fuel supply line. If the burner is operating, let the dryer run out of fuel. It should shut down due to loss of flame. Press the dryer stop button to clear the error and turn OFF the main power disconnect at the entrance panel.

Emergency

In case of an emergency push, the Emergency Stop switch located on the side of the Autoflow control box and the fill system control box. This will shut everything that is controlled by the dryer OFF immediately.

TopDry Autoflow Theory of Operation

Control Panel Switch Status

1. Control Power: "ON"
2. Moisture Control Thermostat: "ON"
3. Aeration Fan: "AUTO"
4. Load Auger: "AUTO"
5. Fan: "AUTO"
6. Heater: "AUTO"
7. Dump: "AUTO"
8. Dry and Hold: "OFF"

Emergency Stop Switch Status

1. Autoflow Control Box Emergency Stop: "PULLED OUT"
2. Fill System Control Box Emergency Stop: "PULLED OUT"
3. Actuator Control Box 24V Switch: "ON"

Aeration Fan Bypass: *"Enabled"*

When the TopDry is in a ready state, that is with no grain in the drying chamber and wet grain in the wet storage tank, Fill System #1 and Fill System #2 will start to fill the drying chamber with wet grain when the Start switch is pressed on the Dryer Control Panel. In single fill system units only fill system #1 will start. and the fan delay will start to count down. When the fan delay reaches zero, the slave drying fan will start, The Aeration Fan and the Master Drying Fan will come ON and the Air switch will close and the dry timer will start to count down. In single fan units, the fan delay will not count down and the Air switch will close after the master drying fan starts. After a twenty second purge delay the fan/heater unit(s) will ignite. When the plenum temperature reaches the cycle set point the fan/heater unit(s) will cycle to low-fire. When the plenum temperature falls 10° below the cycle set point the fan/heater unit(s) will cycle back to high-fire. The fan/heater units will continue to cycle throughout the drying process.

When grain reaches the Chamber High Level Rotary switch the fill 2 delay will begin to count down. When the fill 2 delay reaches zero fill system #2 will shut off and the fill 1 delay will begin to count down. When the fill 1 delay reaches zero fill system #1 will shut off.

If the Chamber High Level Rotary switch becomes exposed due to shrinkage of grain in the drying chamber, the fill system(s) will start and refill the drying chamber. When grain reaches the Chamber High Level Rotary switch the fill system(s) will shut off after the delays.

When the dry timer reaches zero and the grain temperature set point is above the current grain temperature the dryer will go into temperature hold. When the grain temperature reaches the grain temperature set point the unit will continue to the dump cycle. In the dump cycle the linear actuator in the actuator control box extends, the dump chutes lower and grain is dumped from the drying chamber into the storage chamber. Immediately after the dump chutes open the dump timer begins to count down. When the dump timer reaches zero, the dump chutes raise and grain stops dumping from the drying chamber into the storage chamber. During the dump cycle 1/3 of the grain is dumped into the storage chamber.

After the dump cycle the unit returns to the beginning of the dry cycle, the fill system(s) refill the drying chamber and the process begins again. If the dry timer reaches zero after the grain temperature reaches the grain temperature set point the unit does not enter temperature hold. It goes right to the dump cycle.

The unit continuous with the same operation until either no grain is present against the Wet Supply Rotary switch or the storage chamber becomes full.

If the wet storage tank becomes empty while the fill systems are running, the fill 1 and fill 2 delays starts to count down. When the fill 1 and fill 2 delays reach zero, the fill system(s) shut off along with the dryer and a wet supply hopper empty “Out of Grain” error is displayed on the Dryer Control Panel screen. When the Start switch is pressed the screen on the dryer control panel will read “Press Enter to Dry Remaining Grain”. If the enter button is pushed, the dryer will restart without running the fill system(s). The dryer will remain running until the completion of the next dump cycle, after which an “Out of Grain” error is displayed on the dryer control panel and the dryer stops.

If the Storage Chamber High-Limit Rotary switch becomes covered with grain during the dump cycle the dryer will continue through the dump cycle and will continue to the next dry cycle. When the dry cycle is complete, the unit will not continue to the dump cycle. A “Bin Grain High-Limit” error will be displayed on the screen and the dryer will stop. The unit will not dump automatically until grain has been removed from the storage chamber.

If the dryer stops for any reason the aeration fan will remain running if the aeration fan bypass is enabled. The aeration fan bypass is set in the set-up mode. If the aeration fan bypass is disabled, the aeration fan stops whenever the dryer stops.

10. Start-Up Procedure

At the beginning of each harvest and before filling the dryer with grain make sure to inspect the dryer for rodent damage and system integrity. Enter the drying chamber and check each dump hopper. Remove any obstructions. Test operate the dryer using the pre-season checklist.

There are two (2) fundamental things to control with the Autoflow TopDry (or any dryer). The drying rate and the grain flow rate. Drying rate is determined by the dryer size and shape, the grain to be dried, the airflow rate and the drying air temperature. We consider the best temperature to be the highest one where the desired grain quality is maintained. Corn used for livestock consumption is dried at a maximum recommended temperature of 200° Fahrenheit. Corn used for different applications and other grains may require lower drying temperatures. By selecting a drying air temperature a drying rate is established. To achieve a desired final grain moisture content, the grain flow rate is adjusted to match the drying rate.

Initial Dryer Start-Up

1. Be sure the Control Power switch is OFF. Turn ON the main power supply disconnect for the Autoflow control box, fan and heaters and all fill systems.
2. Pull out the Emergency Stop switches on the Autoflow control box, fill systems control box and the actuator control box.
3. Set the switches on the Autoflow control box as follows:
 - Moisture Control Switch - "ON"
 - Aeration Fan Switch - "AUTO"
 - Load Auger Switch - "OFF"
 - Fan Switch - "AUTO"
 - Heater Switch - "AUTO"
 - Dump Switch - "AUTO"
 - Dry and Hold Switch - "OFF"
4. Make sure there is wet grain in the wet supply tank.
5. Turn the Control Power switch to the "ON" position.
6. The screen will display a copyright message and software version number.
7. The screen should read "STOPPED". The chamber high level and the chamber low level should both read "NO".
8. Set the dry timer using the following charts for the specific bin size, fan and heater size, drying temperature and grain input moisture content. Start fans with high option must be made active in extended setup. ([See Page 17.](#))
9. Set the dump timer as follows:
 - 24' diameter bin = 28 seconds
 - 30' diameter bin = 34 seconds
 - 36' diameter bin = 31 seconds
10. Set all other delays and timers as prescribed in the Electronic Monitoring Control Section [on Page 15.](#)

11. Press the reset button for timer changes to take effect immediately.
12. Set the grain temperature set point as follows:
 - 180° drying temperature = 100° grain temperature set point
 - 170° drying temperature = 103° grain temperature set point
 - 160° drying temperature = 105° grain temperature set point
 - 150° drying temperature = 108° grain temperature set point
 - *140° drying temperature = 110° grain temperature set point
 - *130° drying temperature = 113° grain temperature set point
 - *120° drying temperature = 115° grain temperature set point

* When drying at a temperature lower than 150° the grain temperature set point on the moisture control thermostat may require a lower setting at night.
13. Press the Start switch ON the dryer control panel.



Be sure all personnel are clear of fill systems. Place the Load Auger switch on the dryer control panel to the "AUTO" position.

14. The fill system(s) should start immediately.
15. When the grain reaches the Drying Chamber High Level Rotary switch the fan and heater(s) should start.
16. When the grain reaches the Drying Chamber High Level Rotary switch the fill system(s) should stop.
17. When the dry timer reaches zero, the display should read "TEMP HOLD"
18. When the grain temperature reaches the grain temperature set point, the dryer should continue to the dump cycle.
19. The dump chutes should lower, grain should dump from the drying chamber into the storage chamber and the fill system(s) should start.
20. After the dump cycle, the dryer should continue to the beginning of the next dry cycle.
21. After the fourth dump stop the dryer.
22. Test the moisture of the dried grain.
23. If the moisture of the grain is too high increase the grain temperature set point 5° for each additional point of moisture to be removed.
24. If the moisture of the grain is too low decrease the grain temperature set point 5° for each additional point of moisture to be added.
25. After the moisture control thermostat is adjusted decrease the time on the dry timer by one-half. The dry timer should not be set lower than the amount of time it takes the dryer to refill after the dump cycle.
26. Re-start the dryer. The time on the dry timer should expire before the grain reaches the temperature set point.
27. Any time a change is made to the grain temperature set point the dryer must dump four (4) times before the full effect of the change will be made on the moisture of the grain.

10. Start-Up Procedure

Normal Start-Up

When the dryer is started with grain in the drying chamber that has already been partially dried, the dryer can be started without making any adjustments to time or temperature; however, the moisture of the grain should be checked after the fourth dump.

Last Fill

1. Stop the dryer when all the wet grain has been loaded into the drying chamber and turn OFF the Moisture Control switch.
2. Set the time on the dry timer for twice the recommended amount using the following charts for the specific bin size, fan and heater size, drying temperature and grain input moisture content.
3. Push the reset button.
4. Turn the Dry and Hold switch to the "ON" position.
5. Turn the Load Auger switch to the "OFF" position.
6. Press the Start switch.
7. When the dryer shuts down install the fan inlet cover(s).
8. Let the aeration fan cool in the top and store or manually dump into the storage chamber.

**TopDry Autoflow Series
Drying Rates for Shelled Corn**

Autoflow Series			21' Dia.	1 Fan	24' Dia.	1 Fan	30' Dia.	1 Fan	
Fan and Heater Unit(s)	Plenum Temperature F°	Moisture Content Wet Basis	Bu/Hr	Minutes Between Dumps	Bu/Hr	Minutes Between Dumps	Bu/Hr	Minutes Between Dumps	
15 HP 36" Fan	160	20%	499	17.4	528	21.6	557	31.9	
		25%	316	27.6	334	34.1	353	50.4	
		30%	197	44.2	209	54.6	220	80.8	
	3.5 Million BTU	180	20%	639	13.6	*675	*16.8	*713	*24.9
			25%	404	21.5	*428	*26.6	*451	*39.4
			30%	253	34.5	*267	*42.6	*282	*63.1
	200	20%	*748	*11.6	*791	*14.4	*835	*21.3	
		25%	*474	*18.4	*501	*22.7	*529	*33.6	
		30%	*296	*29.5	*313	*36.4	*330	*53.9	
15 HP 40" Fan	160	20%	584	14.9	648	17.5	711	25.0	
		25%	370	23.5	411	27.7	450	39.5	
		30%	231	37.7	256	44.4	281	63.3	
	6.25 Million BTU	180	20%	748	11.6	*830	*13.7	*909	*19.5
			25%	473	18.4	*525	*21.6	*576	*30.9
			30%	296	29.5	*328	*34.7	*360	*49.5
	200	20%	*875	*9.9	*971	*11.7	*1065	*16.7	
		25%	*554	*15.7	*615	*18.5	*674	*26.4	
		30%	*346	*25.2	*384	*29.6	*421	*42.2	
30 HP 42" Fan	160	20%			740	15.4	806	22.0	
		25%			469	24.3	511	34.8	
		30%			293	38.9	319	55.8	
	10.25 Million BTU	180	20%			947	12.0	1032	17.2
			25%			600	19.0	653	27.2
			30%			375	30.4	408	43.6
	200	20%			1109	10.2	1208	14.7	
		25%			702	16.2	765	23.2	
		30%			439	25.9	478	37.2	
40 HP 42" Fan	160	20%					920	19.3	
		25%					583	30.5	
		30%					364	48.9	
	10.25 Million BTU	180	20%					1178	15.1
			25%					746	23.8
			30%					466	38.2
	200	20%						1379	12.9
		25%						873	20.3
		30%						545	32.6

*Insufficient burner BTUs for 45° ambient temperature.

Est. at ambient temperature 45°F, rel.humidity 65% Use only as a guide, conditions will vary capacities.
1/4 CFM cooling.

11. Drying Rates

TopDry Autoflow Series Drying Rates for Shelled Corn

Autoflow Series			30' Dia.	2 Fan	36' Dia.	1 Fan	36' Dia.	2 Fan
Fan and Heater Unit(s)	Plenum Temperature F°	Moisture Content Wet Basis	Bu/Hr	Minutes Between Dumps	Bu/Hr	Minutes Between Dumps	Bu/Hr	Minutes Between Dumps
15 HP 36" Fan 3.5 Million BTU	160	20%	939	18.9			993	25.8
		25%	595	29.9			629	40.7
		30%	371	47.9			393	65.2
	180	20%	1202	14.8			1271	20.1
		25%	761	23.4			805	31.8
		30%	475	37.4			503	51.0
	200	20%	*1407	*12.6			*1488	*17.2
		25%	*891	*19.9			*943	*27.2
		30%	*557	*32.0			*589	*43.5
15 HP 40" Fan 6.25 Million BTU	160	20%	1154	15.4			1269	20.2
		25%	731	24.3			803	31.9
		30%	457	39.0			502	51.1
	180	20%	1477	12.0			1623	15.8
		25%	936	19.0			1028	24.9
		30%	584	30.4			642	39.9
	200	20%	*1730	*10.2			*1901	*13.4
		25%	*1096	*16.2			*1204	*21.3
		30%	*684	*26.0			*752	*34.1
30 HP 42" Fan 10.25 Million BTU	160	20%			819	31.3	1452	17.6
		25%			519	49.4	920	27.8
		30%			324	79.1	574	44.6
	180	20%			1048	24.4	1858	13.8
		25%			664	38.6	1177	21.7
		30%			415	61.8	735	34.8
	200	20%			1227	20.8	2176	11.7
		25%			777	32.9	1378	18.6
		30%			486	52.8	861	29.8
40 HP 42" Fan 10.25 Million BTU	160	20%			950	26.9		
		25%			602	42.6		
		30%			376	68.2		
	180	20%			1216	21.0		
		25%			770	33.3		
		30%			481	53.3		
	200	20%			1424	18.0		
		25%			902	28.4		
		30%			563	45.5		

*Insufficient burner BTUs for 45° ambient temperature.

Est. at ambient temp 45°F, rel.humidity 65% Use only as a guide, conditions will vary capacities.
1/4 CFM cooling.

12. Autoflow Series Drying Rates

Shelled Corn (Metric Measurements)

Autoflow Series			6.40 m Dia.		7.32 m Dia.		9.14 m Dia.	
Fan and Heater Unit(s)	Plenum Temperature C°	Moisture Content Wet Basis	MT/Hr	Minutes Between Dumps	MT/Hr	Minutes Between Dumps	MT/Hr	Minutes Between Dumps
11.19 kW 91.44 cm	71	20%	12.7	17.4	13.4	21.6	14.1	31.9
		25%	8.0	27.6	8.5	34.1	9.0	50.4
		30%	5.0	44.2	5.3	54.6	5.6	80.8
	82	20%	16.2	13.6	17.1	*16.8	18.1	*24.9
		25%	10.3	21.5	10.9	*26.6	11.5	*39.4
		30%	6.4	34.5	6.8	*42.6	7.2	*63.1
	93	20%	19.0	*11.6	20.1	*14.4	21.2	*21.3
		25%	12.0	*18.4	12.7	*22.7	13.4	*33.6
		30%	7.5	*29.5	8.0	*36.4	8.4	*53.9
11.19 kW 101.60 cm	71	20%	14.8	14.9	16.5	17.5	18.1	25.0
		25%	9.4	23.5	10.4	27.7	11.4	39.5
		30%	5.9	37.7	6.5	44.4	7.1	63.3
	82	20%	19.0	11.6	*21.1	*13.7	*23.1	*19.5
		25%	12.0	18.4	*13.3	*21.6	*14.6	*30.9
		30%	7.5	29.5	*8.3	*34.7	*9.1	*49.5
	93	20%	*22.2	*9.9	*24.7	*11.7	*27.1	*16.7
		25%	*14.1	*15.7	*15.6	*18.5	*17.1	*26.4
		30%	*8.8	*25.2	*9.8	*29.6	*10.7	*42.2
22.37 kW 106.68 cm	71	20%			18.8	15.4	20.5	22.0
		25%			11.9	24.3	13.0	34.8
		30%			7.4	38.9	8.1	55.8
	82	20%			21.1	12.0	26.2	17.2
		25%			15.2	19.0	16.6	27.2
		30%			9.5	30.4	10.4	43.6
	93	20%			28.2	10.2	30.7	14.7
		25%			17.8	16.2	19.4	23.2
		30%			11.2	25.9	12.1	37.2
29.83 kW 106.68 cm	71	20%					23.4	19.3
		25%					14.8	30.5
		30%					9.2	48.9
	82	20%					29.9	15.1
		25%					18.9	23.8
		30%					11.8	38.2
	93	20%					35.0	12.9
		25%					22.2	20.3
		30%					13.8	32.6

Insufficient burner BTUs for 7°C ambient temperature Ratings exclude loading time.

Est. at ambient temperature 7°C, rel.humidity 65%. Use only as a guide, conditions will vary capacities.

1/4 CFM/BU cooling rate.

12. Autoflow Series Drying Rates

Shelled Corn (Metric Measurements)

Autoflow Series			9.14 m Dia. 2 Fan		10.97 m Dia. 1 Fan		10.97 m Dia. 2 Fan	
Fan and Heater Unit(s)	Plenum Temperature C°	Moisture Content Wet Basis	MT / hr	Minutes Between Dumps	MT / hr	Minutes Between Dumps	MT / hr	Minutes Between Dumps
11.19 kW 91.44 cm 1.125 Million kCal	71	20%	23.9	18.9			25.2	25.8
		25%	15.1	29.9			16.0	40.7
		30%	9.4	47.9			10.0	65.2
	82	20%	30.5	14.8			32.3	20.1
		25%	19.3	23.4			20.4	31.8
		30%	12.1	37.4			12.8	51.0
	93	20%	35.7	*12.6			37.8	*17.2
		25%	22.6	*19.9			24.0	*27.2
		30%	14.1	*32.0			15.0	*43.5
11.19 kW 101.60 cm 1.5 Million kCal	71	20%	29.3	15.4			32.2	20.2
		25%	18.6	24.3			20.4	31.9
		30%	11.6	39.0			12.8	51.1
	82	20%	37.5	12.0			41.2	15.8
		25%	23.8	19.0			26.1	24.9
		30%	17.8	30.4			16.3	39.9
	93	20%	*43.9	*10.2			*48.3	*13.4
		25%	*27.8	*16.2			*30.6	*21.3
		30%	*17.4	*26			*19.1	*34.1
22.37 kW 106.68 cm 2.5 Million kCal	71	20%			20.8	31.3	36.9	17.6
		25%			13.2	49.4	23.4	27.8
		30%			8.2	79.1	14.6	44.6
	82	20%			26.6	24.4	47.2	13.8
		25%			16.9	38.6	29.9	21.7
		30%			10.5	61.8	18.7	34.8
	93	20%			31.2	20.8	55.3	11.7
		25%			19.7	32.9	35.0	18.6
		30%			12.3	52.8	21.9	29.8
29.83 kW 106.68 cm 2.5 Million kCal	71	20%			24.1	26.9		
		25%			15.3	42.6		
		30%			9.6	68.2		
	82	20%			30.9	21.0		
		25%			19.6	33.3		
		30%			12.2	53.3		
	93	20%			36.2	18.0		
		25%			22.9	28.4		
		30%			14.3	45.5		

Insufficient burner BTUs for 7°C ambient temperature Ratings exclude loading time.

Est. at ambient temperature 7°C, rel.humidity 65%. Use only as a guide, conditions will vary capacities.

1/4 CFM/BU cooling rate.

Limited Warranty — N.A. Grain Products

The GSI Group, LLC. (“GSI”) warrants products which it manufactures, to be free of defects in materials and workmanship under normal usage and conditions for a period of 12 months from the date of shipment (or, if shipped by vessel, 14 months from the date of arrival at the port of discharge). If, in GSI’s sole judgment, a product is found to have a defect in materials and/or workmanship, GSI will, at its own option and expense, repair or replace the product or refund the purchase price. This Limited Warranty is subject to extension and other terms as set forth below.

Warranty Enhancements: The warranty period for the following products is enhanced as shown below and is in lieu of (and not in addition to) the above stated warranty period. (Warranty Period is from date of shipment.)

	Product	Warranty Period
Storage	Grain Bin Structural Design • Sidewall, roof, doors, platforms and walkarounds • Flooring (when installed using GSI specified floor support system for that floor) • Hopper tanks (BFT, GHT, NCHT, and FCHT)	5 Years
Conditioning	Dryer Structural Design – (Tower, Portable and TopDry) • Includes (frame, portable dryer screens, ladders, access doors and platforms)	5 Years
	All other Dryer parts including: • Electrical (controls, sensors, switches and internal wiring)	2 Years
	All Non-PTO Driven Centrifugal and Axial Fans	3 Years
	Bullseye Controllers	2 Years
Material Handling	Bucket Elevators Structural Design	5 Years
	Towers Structural Design	5 Years
	Catwalks Structural Design	5 Years
	Accessories (stairs, ladders and platforms) Structural Design	5 Years

Conditions and Limitations:

THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE LIMITED WARRANTY DESCRIPTION SET FORTH HEREIN; SPECIFICALLY, GSI DISCLAIMS ANY AND ALL OTHER WARRANTIES OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING, WITHOUT LIMITATION, WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR USE IN CONNECTION WITH: (I) ANY PRODUCT MANUFACTURED OR SOLD BY GSI, OR (II) ANY ADVICE, INSTRUCTION, RECOMMENDATION OR SUGGESTION PROVIDED BY AN AGENT, REPRESENTATIVE OR EMPLOYEE OF GSI REGARDING OR RELATED TO THE CONFIGURATION, INSTALLATION, LAYOUT, SUITABILITY FOR A PARTICULAR PURPOSE, OR DESIGN OF SUCH PRODUCTS.

The sole and exclusive remedy for any claimant is set forth in this Limited Warranty and shall not exceed the amount paid for the product purchased. This Warranty only covers the value of the warranted parts and equipment, and does not cover labor charges for removing or installing defective parts, shipping charges with respect to such parts, any applicable sales or other taxes, or any other charges or expenses not specified in this Warranty. GSI shall not be liable for any other direct, indirect, incidental or consequential damages, including, without limitation, loss of anticipated profits or benefits. Expenses incurred by or on behalf of a claimant without prior written authorization from the GSI warranty department shall not be reimbursed. This warranty is not transferable and applies only to the original end-user. GSI shall have no obligation or responsibility for any representations or warranties made by or on behalf of any dealer, agent or distributor. Prior to installation, the end-user bears all responsibility to comply with federal, state and local codes which apply to the location and installation of the products.

This Limited Warranty extends solely to products sold by GSI and does not cover any parts, components or materials used in conjunction with the product, that are not sold by GSI. GSI assumes no responsibility for claims resulting from construction defects, unauthorized modifications, corrosion or other cosmetic issues caused by storage, application or environmental conditions. Modifications to products not specifically delineated in the manual accompanying the product at initial sale will void all warranties. This Limited Warranty shall not extend to products or parts which have been damaged by negligent use, misuse, alteration, accident or which have been improperly/inadequately maintained.

Notice Procedure:

In order to make a valid warranty claim a written notice of the claim must be submitted, using the RMA form, within 60 days of discovery of a warrantable nonconformance. The RMA form is found on the OneGSI portal.

Service Parts:

GSI warrants, subject to all other conditions described in this Warranty, Service Parts which it manufactures for a period of 12 months from the date of purchase unless specified in Enhancements above.

This equipment shall be installed in accordance with the current installation codes and applicable regulations, which should be carefully followed in all cases. Authorities having jurisdiction should be consulted before installations are made.



**1004 E. Illinois St.
Assumption, IL 62510-0020
Phone: 1-217-226-4421
Fax: 1-217-226-4420
www.gsiag.com**



GSI is a worldwide brand of AGCO Corporation.