




# ***MAGNA GRAIN DRYER OPERATING INSTRUCTION***

**MODELS – AUTOMATIC**



Updated June 2013

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# **1 INTRODUCTION TO THE MANUAL**

## **1.1 FOREWORD**

This manual is provided to give you the necessary operating and maintenance instructions to obtain the best performance and working life from your dryer.

Please read this manual thoroughly. Understand what each control is for and how to use it.

Observe all safety precaution decals on the machine and noted throughout the manual for safe operation.



DO NOT CARRY OUT MAINTENANCE WORK AND/OR REPAIRS UNTIL THE MAIN ELECTRIC POWER SWITCH IS TURNED TO OFF.



DO NOT UNDER ANY CIRCUMSTANCES ENTER THE DRYER THROUGH THE INSPECTION HATCH UNTIL THE MAIN POWER SWITCH TURNED TO OFF. FAILURE TO FOLLOW THIS INSTRUCTION MAY CAUSE SERIOUS INJURY. EXPLANATION – SHOULD THE AGITATOR ARM RECIRCULATE WHILST THE OPERATOR IS ENTERING THE DRYER OR INSIDE THE DRYER

If any assistance or additional information is needed, contact your authorized OPICO dealer.

This manual is divided into the following sections:


- 1) Introduction
- 2) General Information
- 3) Preparing The Dryer For Operation
- 4) Loading And Operation
- 5) Maintenance
- 6) Safety Warnings
- 7) Trouble Shooting
- 8) Storage
- 9) Wiring Diagrams

For safety and to obtain the performance of which these machines are capable we recommend that the operator should read this manual carefully before initial start up at the beginning of each season and when changing to a new crop type.



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#### **ENCLOSED WITH THIS HANDBOOK**

- DECLARATION OF CONFORMITY SUPPLIED BY THE MANUFACTURER
- ELECTRIC WIRING DIAGRAM
- PRODUCT REGISTRATION CARD

### **1.3 DEFINITION OF SYMBOLS**

Symbols are used in this handbook to highlight parts of its content, which are of special importance for safety, use and maintenance

SYMBOL	MEANING	DESCRIPTION
	<b>ATTENTION</b>	Section of text which includes an instruction that that requires attention
	<b>DANGER</b>	This symbol requires you to pay special attention because your safety is involved
	<b>USE</b>	Explanation of the correct use of the dryer
	<b>MAINTENANCE</b>	Maintenance Instructions

### **1.4 SAFE WORKING ENVIRONMENT**



Read and understand the operators manual before operating the unit



Always turn the main power switch to off before adjusting, lubricating, servicing or cleaning



Keep all shields and safety devices in place



Keep children, visitors and untrained personnel away from the machine while in operation




Keep hands, feet and clothing away from moving parts



Keep unit level when operating



DO NOT UNDER ANY CIRCUMSTANCES ENTER THE DRYER THROUGH THE INSPECTION HATCH UNTIL THE MAIN POWER SWITCH IS TURNED OFF. FAILURE TO FOLLOW THIS INSTRUCTION MAY CAUSE SERIOUS INJURY. EXPLANATION – SHOULD THE AGITATOR ARM RECIRCULATE WHILST THE OPERATOR IS ENTERING THE DRYER OR INSIDE THE DRYER

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## 2 GENERAL INFORMATION

### 2.1 OVERVIEW

All instructions relating to position are as viewed from the back of the dryer looking toward the front of the machine. i.e. The diesel burner unit is mounted on the left hand side.

### 2.2 DRYER IDENTIFICATION

The Identification Plate and CE marking of the machine is placed on the left side of the draw-bar.

The identification plate must not be tampered with, covered over or modified in any way.

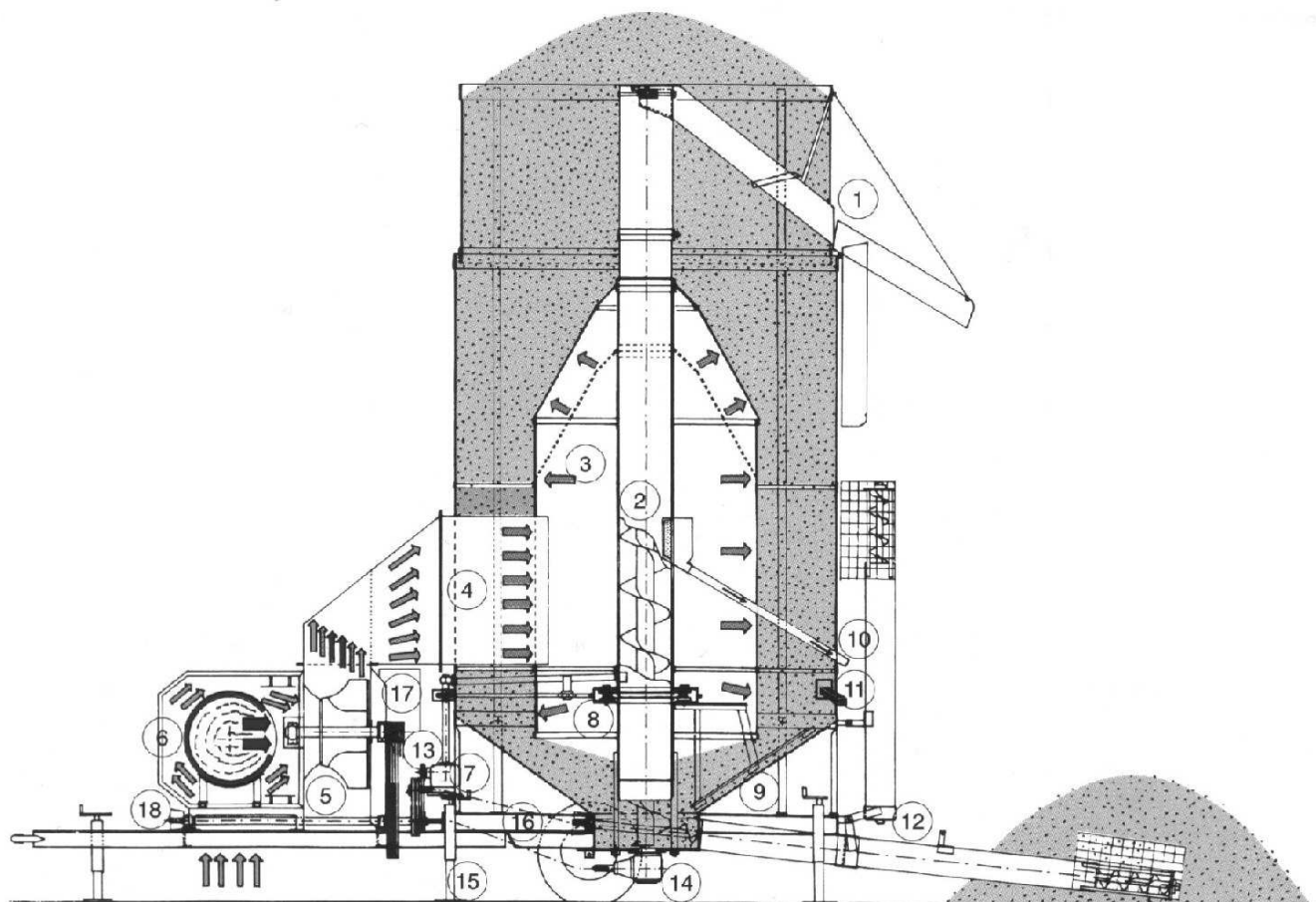
Should the plate become damaged or lost you should request a replacement as soon as reasonable possible.

Picture 2.2 IDENTIFICATION PLATE

		
Viale Tretti Marotti 18 Grisignano di Zocco - Vi - Italy Tel. 0444-414201 Fax 0444-414283		
<b>ESSICCATOIO MOD.</b>	<input type="text"/>	
<b>SERIE</b>	<b>N°</b>	<input type="text"/>
<b>ANNO COSTRUZIONE</b>	<input type="text"/>	



## 2.3 DRYER COMPONENTS



Picture 2.3 DRYER COMPONENTS TABLE

- |                             |                              |
|-----------------------------|------------------------------|
| 1) Discharge Chute          | 10) Grain Cleaner Discharge  |
| 2) Vertical Auger           | 11) Grain Sampler Outlet     |
| 3) Plenum Chamber           | 12) Loading Auger            |
| 4) Air Duct                 | 13) Belt Drive               |
| 5) Fan                      | 14) Centre Auger Drive       |
| 6) Heat Unit                | 15) Adjustable Support Jacks |
| 7) Agitator Gearbox         | 16) Intake drive             |
| 8) Agitator Support Rollers | 17) Control Board            |
| 9) Agitator Arm             |                              |



## **2.4 THEORY OF DRYING**

### **2.4.1 HEATING THE GRAIN**

Combinable crop drying has two basic stages:

1. The diffusing of internal moisture to the surface of the grain, bean or seed.  
Followed by:
2. The removal of the created external moisture by air flow.

The grain temperature largely establishes this rate of diffusion and must be controlled not to exceed a rate that could result in a ruptured seed.

Removal of the exterior moisture is dependant upon air flow and air temperature.

These two stages must be balanced to produce the quality dried crop.

The balance is accomplished quite simply in the Magna Grain Dryer with its uniform circulation, regulated heat and controlled air-flow.

### **2.4.2 COOLING THE GRAIN**



It is very important to cool grain. Grain to be stored should be cooled after drying to within 15 degrees F of atmospheric temperature or 10 degrees F of grain already in the storage bin. Moisture migration from air to grain will occur if the grain is not cooled within these limits.



**2.4.3 RECOMMENDED DRYING TEMPERATURES**

CROP TYPE	MOISTURE CONTENT & POINTS OF INTEREST	PLENUM TEMPERATURE	MAXIMUM FINAL GRAIN TEMPERATURE	FINAL STORAGE LEVEL
<b>BARLEY</b>				
Feed		180 - 220°F	120°F	14%
Malting / Seed	Below 21%	120 - 150°F	105°F	
	Above 22%	110 - 130°F	105°F	

If light samples are experienced Maximum Plenum Temperature should not exceed 140°F

**WARNING**

Great care should be taken with the storage of barley grown for malting or seed between the actual harvesting of the material and the drying of it. Harvested crop must only be stored before drying for the minimum amount of time. It is recommended that the crop is stored so that the maximum depth does not exceed 2 feet.

CROP TYPE	MOISTURE CONTENT & POINTS OF INTEREST	PLENUM TEMPERATURE	MAXIMUM FINAL GRAIN TEMPERATURE	FINAL STORAGE LEVEL
<b>OILSEED RAPE</b>				
Oil Extraction	Up to 17%	160 - 200°F	120°F	8%
Seed	Reduce plenum temperature by 10°F	120 - 150°F	105°F	8%

**SPECIAL NOTES**

1. Plenum temperatures of up to 200°F have been used without apparent oil/quality loss
2. Excessive heat gives slower drying – cooling prolonged
3. Mature crops dry relatively easily
4. Desiccated early crops may contain 30% volume of immature seeds which are less easily dried
5. With moisture content above 17% - for every 2% increase in moisture content, reduce plenum temperature by 10°F for the initial drying period





CROP TYPE	MOISTURE CONTENT & POINTS OF INTEREST	PLENUM TEMPERATURE	MAXIMUM FINAL GRAIN TEMPERATURE	FINAL STORAGE LEVEL
<b>HERBAGE SEEDS</b> (SAFE DRYING AIR TEMPERATURES FOR 90% GERMINATION)				
(Grass Seed)				
PRG/IRG	Up to 25%	130°F	90°F	13%
	Between 25% – 30%	120°F	90°F	13%
	Between 30% – 35%	110°F	90°F	13%
	Between 35% – 40%	100°F	90°F	13%



## NOTES

- \* Always grown for seed
- \* Grass seed does not flow easily over 22% moisture content
- \* Polish the dryer prior to use with dried barley or other dry grain

**BEANS** – see Peas / Field Beans

CROP TYPE	MOISTURE CONTENT & POINTS OF INTEREST	PLENUM TEMPERATURE	MAXIMUM FINAL GRAIN TEMPERATURE	FINAL STORAGE LEVEL
<b>LINSEED</b>				
Oil extraction and/or seed	Up to 15%	120 - 150°F	120°F	8%
<b>*For every 2% increase in moisture content reduce plenum temperature by 10°F</b>				
		90 - 120°F	105°F	8%

CROP TYPE	MOISTURE CONTENT & POINTS OF INTEREST	PLENUM TEMPERATURE	MAXIMUM FINAL GRAIN TEMPERATURE	FINAL STORAGE LEVEL
<b>OATS</b>				
Feed		150 - 200°F	130°F	14%
Seed		110 - 150°F	105°F	14%



**NOTE** Oats for feed use can stand plenum temperatures up to 220°F.



CROP TYPE	MOISTURE CONTENT & POINTS OF INTEREST	PLENUM TEMPERATURE	MAXIMUM FINAL GRAIN TEMPERATURE	FINAL STORAGE LEVEL
<b>PEAS / FIELD BEANS (PULSES)</b>				
Processing / Protein		110 - 120°F	105°F	14%
<b>NOTE</b> In general protein is not affected by heat but excessive heat will cause splitting damage				
Seed	Below 24%	90 - 110°F	105°F	14%
Seed	Above 24%	70 – 90°F	105°F	14%
Seed	Above 27%	No heat to 50°F	105°F	14%

### DIRECT HARVESTED

1. Can experience handling problems over 25% moisture content
2. Do not use loading auger over 25% moisture content (see below)
3. Special note – clean out the centre auger bin bottom after each load. This crop carries a lot of surface dirt which in the re-circulation process will find its way to the bin bottom well and create an extremely abrasive paste. This will shorten the life of the centre auger dramatically if the recommended cleaning process is not carried out.


### DRYING FROM STORE

1. This crop is susceptible to splitting if excessive heat is used
2. Increase temperature in 5°F stages and check for splits to a maximum of 110°F plenum temperature : No heat - 110°F

CROP TYPE	MOISTURE CONTENT & POINTS OF INTEREST	PLENUM TEMPERATURE	MAXIMUM FINAL GRAIN TEMPERATURE	FINAL STORAGE LEVEL
<b>WHEAT</b>				
Feed		180 - 220°F	140°F	14%
Milling	Below 25%	150 - 180°F	120°F	14%
	Above 25%	140 – 170°F	120°F	14%
Seed		100 - 130°F	105°F	14%

### SPECIAL NOTES

1. High gluten wheats mean slower drying
2. Wet cereals in general i.e. over 27% moisture content – dry carefully do not exceed Grain Final Safe Temperature. If this is apparent, stop the burner, allow dryer to continue circulating grain until cool, then re-light the burner and complete the drying process.
3. Seed wheat over 27% moisture content – use no heat to a maximum of 105°F plenum until moisture content is below 20%, then continue with care using a plenum temperature of 120°F maximum.

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CROP TYPE	MOISTURE CONTENT & POINTS OF INTEREST	PLENUM TEMPERATURE	MAXIMUM FINAL GRAIN TEMPERATURE	FINAL STORAGE LEVEL
<b>LUPINS</b>				
Drying for Seed		no heat to 120°F		

- \* Furry seed – may generate fluff in handling
- \* Very tough skin
- \* Pre-drying treatment – pre-cleaning helpful if not essential

#### **METHOD**

1. Polish dryer with barley prior to handling
2. Be careful if moisture content 23% - 24% - augers may not handle
3. Recommended plenum temperatures no heat - 105°F - 120°F **ABSOLUTE MAXIMUM**



## 2.4.4 TEMPERATURE CONVERSION CHART

EG 120°F = 48.9°C OR 120°C = 248°F

0 ~ 90

C		F
-17.8	0	32.0
-15.0	5	41.0
-12.2	10	50.0
-9.4	15	59.0
-6.7	20	68.0
-3.9	25	77.0
-1.1	30	86.0
1.7	35	95.0
4.4	40	104.0
7.2	45	113.0
10.0	50	122.0
10.6	51	123.8
11.1	52	125.6
11.7	53	127.4
12.2	54	129.2
12.8	55	131.0
13.3	56	132.8
13.9	57	134.6
14.4	58	136.4
15.0	59	138.2
15.6	60	140.0
16.1	61	141.8
16.7	62	143.6
17.2	63	145.4
17.8	64	147.2
18.3	65	149.0
18.9	66	150.8
19.4	67	152.6
20.0	68	154.4
20.6	69	156.2
21.1	70	158.0
21.7	71	159.8
22.2	72	161.6
22.8	73	163.4
23.3	74	165.2
23.9	75	167.0
24.4	76	168.8
25.0	77	170.6
25.6	78	172.4
26.1	79	174.2
26.7	80	176.0
27.2	81	177.8
27.8	82	179.6
28.3	83	181.4
28.9	84	183.2
29.4	85	185.0
30.0	86	186.8
30.6	87	188.6
31.1	88	190.4
31.7	89	192.2
32.2	90	194.0

91 ~ 141

C		F
32.8	91	195.8
33.3	92	197.6
33.9	93	199.4
34.4	94	201.2
35.0	95	203.0
35.6	96	204.8
36.1	97	206.6
36.7	98	208.4
37.2	99	210.2
37.8	100	212.0
38.3	101	213.8
38.9	102	215.6
39.4	103	217.4
40.0	104	219.2
40.6	105	221.0
41.1	106	222.8
41.7	107	224.6
42.2	108	226.4
42.8	109	228.2
43.3	110	230.0
43.9	111	231.8
44.4	112	233.6
45.0	113	235.4
45.6	114	237.2
46.1	115	239.0
46.7	116	240.8
47.2	117	242.6
47.8	118	244.4
48.3	119	246.2
48.9	120	248.0
49.4	121	249.8
50.0	122	251.6
50.6	123	253.4
51.1	124	255.2
51.7	125	257.0
52.2	126	258.8
52.8	127	260.6
53.3	128	262.4
53.9	129	264.2
54.4	130	266.0
55.0	131	267.8
55.6	132	269.6
56.1	133	271.4
56.7	134	273.2
57.2	135	275.0
57.8	136	276.8
58.3	137	278.6
58.9	138	280.4
59.4	139	282.2
60.0	140	284.0
60.6	141	285.8

142 ~ 260

C		F
61.1	142	287.6
61.7	143	289.4
62.2	144	291.2
62.8	145	293.0
63.3	146	294.8
63.9	147	296.6
64.4	148	298.4
65.0	149	300.2
65.6	150	302.0
66.1	151	303.8
66.7	152	305.6
67.2	153	307.4
67.8	154	309.2
68.3	155	311.0
68.9	156	312.8
69.4	157	314.6
70.0	158	316.4
70.6	159	318.2
71.1	160	320.0
71.7	161	321.8
72.2	162	323.6
72.8	163	325.4
73.3	164	327.2
73.9	165	329.0
74.4	166	330.8
75.0	167	332.6
75.6	168	334.4
76.1	169	336.2
76.7	170	338.0
77.2	171	339.8
77.8	172	341.6
78.3	173	343.4
78.9	174	345.2
79.4	175	347.0
82.2	180	356.0
85.0	185	365.0
87.8	190	374.0
90.6	195	383.0
93.3	200	392.0
96.1	205	401.0
98.9	210	410.0
101.7	215	419.0
104.4	220	428.0
107.2	225	437.0
110.0	230	446.0
112.8	235	455.0
115.6	240	464.0
118.3	245	473.0
121.1	250	482.0
123.9	255	491.0
126.7	260	500.0



### **3 PREPARING THE DRYER FOR OPERATION**

#### **3.1 SITING THE DRYER**



Select a site as level as possible 50 feet (15 metres) from inflammable buildings. It is preferable to set the machine with the fan facing toward the prevailing wind.

If the dryer is being set on a level concrete slab simply lower the adjustable jacks, raising the wheels slightly off the ground, bringing the machine to a level position. It is important that the central auger is vertical. Use the spirit levels that are positioned on the dryer transport chassis.

If the dryer has been placed straight on to soil then a board of at least 2" x 8" x 12" should be placed under each leg.

#### **3.2 ELECTRICAL CONNECTIONS**

Standard equipment; 3 phase electric supply, 380-400V, 50Hz, requires the following mains electric supply service.

Model	1200	2000	2910	3810	4810
Supply	80Amp	100Amp	140Amp	160Amp	180Amp

All wiring to the electrical control panel should be done in compliance with wiring codes by a qualified electrician

#### **3.3 DIESEL FUEL SUPPLY**

The diesel tank is located on the left hand side of the dryer. The fuel supply to the burner has a filter on the suction side. There is a second filter inside the fuel pump and each nozzle has a filter on it. All filters should be checked / cleaned or replaced as required, depending on usage and cleanliness of diesel supply, but at least once per year.

The fuel pump is factory set at 12 bar pressure for Diesel fuel.



### 3.4 POSITIONING THE TOP FOLD DOWN AUGER

The type of discharge head will vary depending on the specification ordered, therefore the following descriptions may vary slightly on machines.



THERE IS A CORRECT METHOD THAT MUST BE FOLLOWED:

#### STANDARD MACHINES

**step one:** First examine the illustration below (fig 3A). Climb the external ladder and stand on the plenum. Using the lever marked 1 in fig 3A pull the over-centre mechanism bringing the folding auger toward the centre of the dryer. Lock the lever in position using the wing nut item number 2.



FAILURE TO FOLLOW STEP TWO WILL RESULT IN MATERIAL DAMAGE TO THE SIDE SHEETS OF THE DRYER.

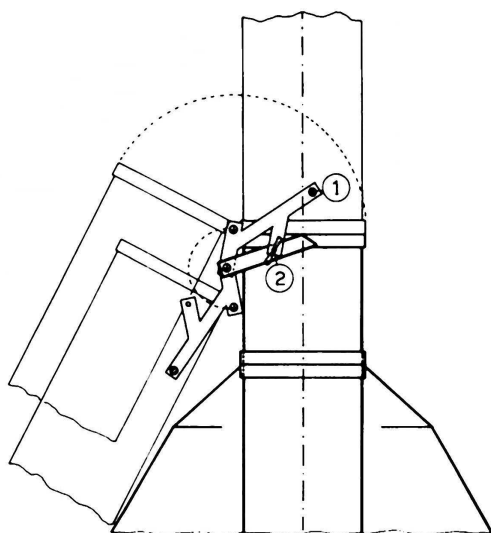


FIG 3A

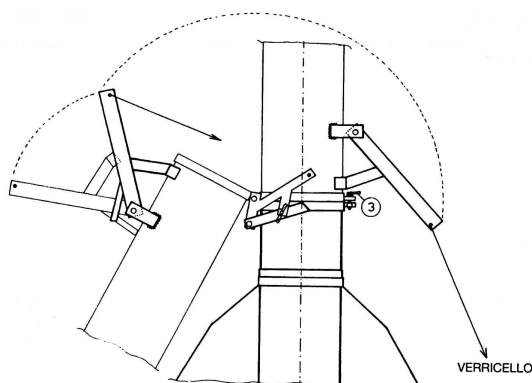


FIG 3B

**step two:** Raise the external extending side sheets to the top of their movement range, fit the 4 safety pins on all four top extension supports and lower the extension top until the pins start to carry the load.

**step three:** Using the vertical auger winch (beside the control cabinet) **raise** the folding auger into its vertical position. Once the auger is correctly positioned climb the ladder and tighten up the wing nut item 3 in fig 3B.



DURING DRYER OPERATION THE VERTICAL AUGER WINCH WIRE TO THE TOP AUGER SHOULD NOT BE UNDER TENSION.



## MACHINE SUPPLIED WITH EXTENDED DISCHARGE OR DUST EXTRACTOR

**step one:** The top section of vertical auger will be supplied loose because of transport height restrictions. The section of auger must first be lifted and connected to the main vertical auger tube using the pivot pin supplied. Then connect the vertical auger winch wire to the top section vertical auger tube. Using the vertical auger winch (mounted at the front of the machine) **raise** the folding auger into its vertical position. Once the auger is correctly positioned climb the ladder and tighten up the wing nut item 3 in fig 3B.



**step two:** Raise the external extending side sheets to the top of their movement range, fit the 4 safety pins on all four top extension supports and lower the extension top until the pins start to carry the load.

## 3.5 PREPARING FOR TRANSPORT



TO PREPARE THE DRYER FOR TRANSPORT FOLLOW ALL THE STEPS ABOVE IN REVERSE ORDER WITH **ONE ADDITIONAL STEP:**

**First Step:** To start the lowering of the top auger extension pull the wire that is positioned at the rear of the dryer and has at its end a triangle steel pull handle. Important you must undo the wing nut item 3 in fig 3b first and loosen the vertical auger winch 3-4 rotations.

## 3.6 POSITIONING THE LOADING AUGER

Using the loading auger winch gently lower the loading auger into the horizontal position. In the process checking that the driving lugs do not directly hit each other. adjust the support feet at the end of the hopper and check the inner/outer auger section fit properly and are sealed to prevent grain loss.





### 3.7 GRAIN CLEANER

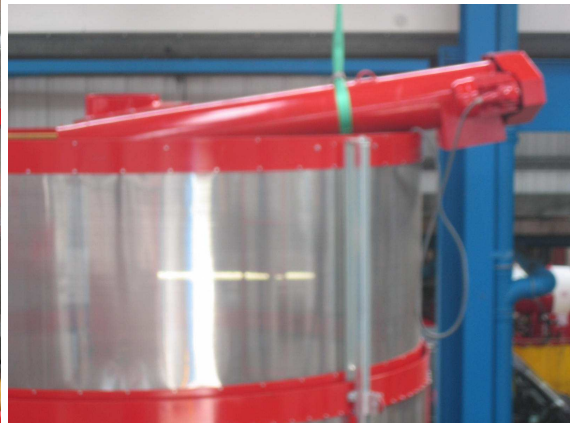
The grain cleaner box is mounted on the vertical auger tube inside the plenum chamber, the box is fitted to the vertical tube with a single bolt fixing around the tube which needs to be removed to allow the box movement away from the tube. The cleaner screen are located in position by one M13 setscrew, by removing this the screen will pull out and can be replaced with the correct screen for the crop being dried.

The cleaner is pipe is pressurised from the main fan pressure via a access hole on the top of the cleaner box, this access hole can be opened/closed to set the pressure required to keep the pipe clear.

Two screens are supplied as std – Oil Seed Rape screen (1.5mm) and Barley/Wheat screen (2.5mm). A blank screen is fitted from factory.

### 3.8 POSITIONING THE DISCHARGE AUGER

The standard discharge auger is mounted over the top of the vertical auger and rests on the flange welded to the vertical tube. The auger is free swinging to discharge left or right. Mount the top rim support cradle on the chosen discharge side and connect the power supply to the discharge motor.





Extended discharge augers and/or dryers fitted with a dust extractor are connected to the vertical auger by means of a connector box which bolts onto the discharge auger and clamps around the vertical auger tube. Extended discharge augers will require additional support at the motor end of the auger from grain store building





## 4 OPERATING INSTRUCTIONS



This picture shows all the components of the control system of the Magna Dryer. All parts are numbered and identified by description. The following pages of the Operation, Maintenance and Service sections refer to the following information contained herein



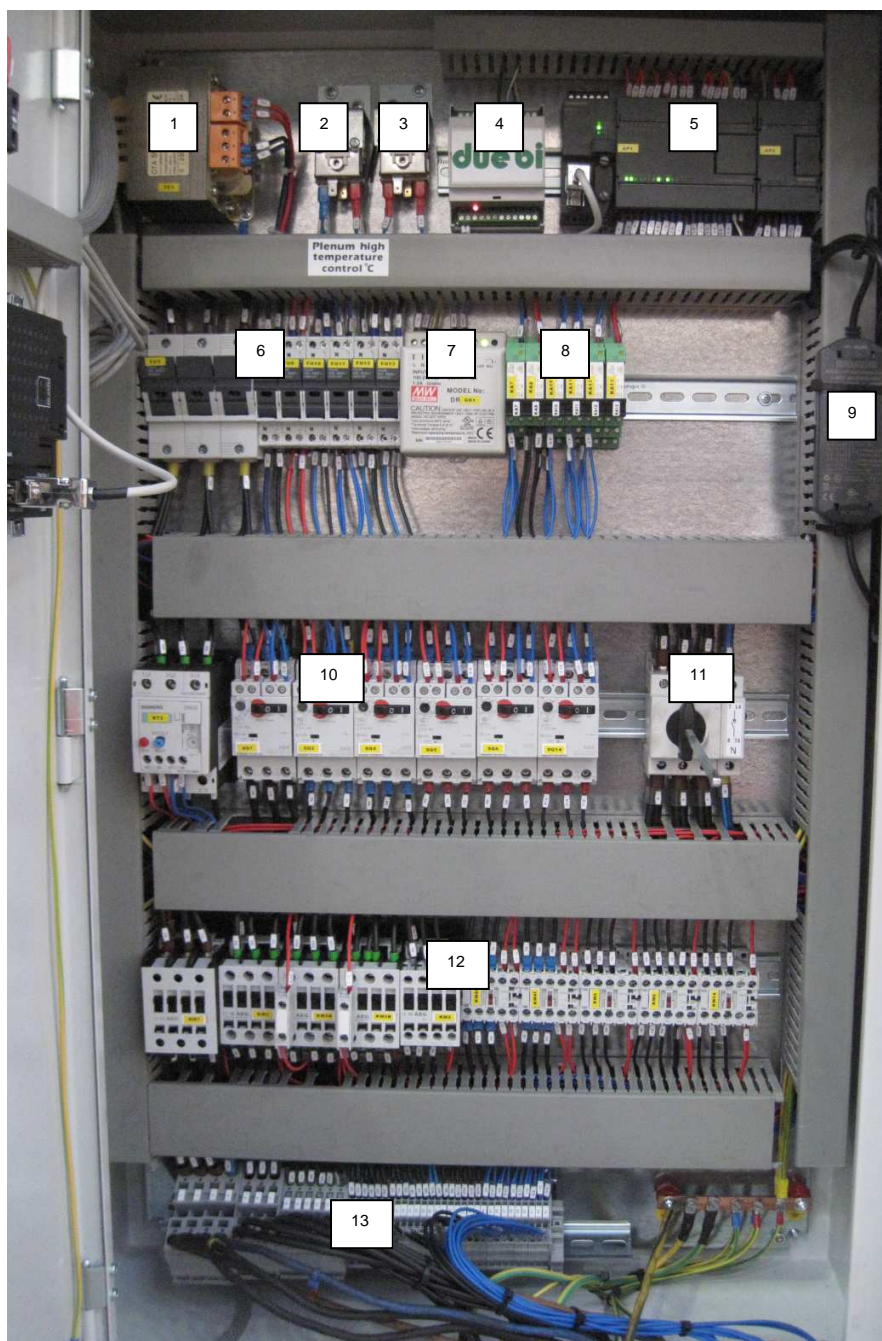
PIC 1. Magna Auto Dryer Touch Screen control board

- |                           |                                      |
|---------------------------|--------------------------------------|
| 1. Main power indicator   | 4. Plenum Air temperature thermostat |
| 2. Phase power indicator  | 5. Grain temperature thermostat      |
| 3. HMI Touch Screen panel | 6. Isolator power switch             |





## 4.1 CONTROL BOARD



PIC 2. Magna Auto Dryer electric control board panel

- 1 – Transformer
- 2 - Safety thermostat – Fan
- 3 - Safety thermostat - Plenum chamber
- 4 – Modem unit (SMS optional equipment)
- 5 - CPU microprocessor
- 6 – Fuse
- 7 – Transformer

- 8 - DCv Relay
- 9 – Modem cable (SMS option)
- 10 - Motor Contactors
- 11 – Mains isolator switch
- 12 - Motor MCB Circuit Breakers
- 13 - Terminal block



## 4.2 CPU MICRO-PROCESSOR

The CPU microprocessor is located inside the control board panel (PIC 2. item 5), this controls all the functions of the dryer communicated from the touch screen (PIC 1. item 3)

**Manual control** – There are times when it may be useful to operate the motors of the dryer manually. This option is provided to test individual motors and drivelines or operate the dryer manually. The motors will operate when the individual motor start button is pressed once, some motors need to operate in pairs. The start button will be replaced with a stop button on the screen, which when pressed will stop the motor.

Motor operation;  
Central auger  
Central auger & Agitator  
Central auger & Loading auger  
Central auger & Unloading auger  
Fan  
Fan & Burner

Note; the Agitator motor will not operate when the Loading auger is running – this is to ensure the loading sequence is done as quickly as possible.

**Automatic control** – Allows the dryer to operate in the automatic cycle via the CPU micro-processor. When working in automatic mode, the dryer can work for a single batch cycle or continuous batch cycles – **'Single cycle on/off'**

### Continuous Batch Drying

The single cycle selector **'off'** mode allows continuous batches of grain to load, heat, cool, discharge, load heat....., as long as there is wet grain waiting to enter the dryer. If the dryer does not load or discharge within the set time limit, the dryer will shut down and wait for an operator to confirm if a fault has occurred.

During continuous batch drying you can instruct the dryer to complete the batch being processed and shut down until further instruction. To do this move the single batch selector to **'on'** any time after the final batch has started loading but before the discharge cycle has finished.

### Single Batch Drying

The single cycle selector **'on'** mode allows one batch of grain to be loaded, heated, cooled and discharged. After discharge the dryer will shut down until further instructions from the operator.

**Conditioning control** – Allows the dryer to operate in the automatic cycle via the CPU micro-processor. When working in conditioning mode, the dryer can work for a single batch cycle or continuous batch cycles – **'Single cycle on/off'**

### Continuous Batch Drying

The single cycle selector **'off'** mode allows continuous batches of grain to load, heat (if burner set 'on'), cool fan (condition), discharge, load heat....., as long as there is grain waiting to enter the dryer. If the dryer does not load or discharge within the set time limit, the dryer will shut down and wait for an operator to confirm if a fault has occurred.

During continuous batch conditioning you can instruct the dryer to complete the batch being processed and shut down until further instruction. To do this move the single batch selector to **'on'** any time after the final batch has started loading but before the discharge cycle has finished.



### Single Batch Drying

The single cycle selector '**on**' mode allows one batch of grain to be loaded, heated (if burner set '**on**'), cool fan (conditioned) and discharged. After discharge the dryer will shut down until further instructions from the operator.

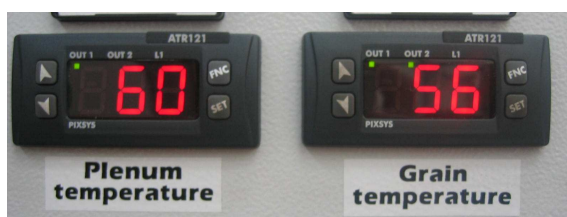
### NOTE, RESETTING PROGRAMS;

To reset the program press the emergency button, then reset this button to continue dryer operation.

## 4.3 THERMIC SAFETY

The thermic safety warning light on the control board indicates if any of the electric motor circuit breakers have tripped. This protects the motor from over loading, ie if an auger was to jam. Check all the circuit breakers and reset any which have tripped – checking the driveline and motor in question.

## 4.4 PLENUM TEMP THERMOSTATS



Recommended operating temperatures – Section 2.4.3

Plenum thermostat is factory set to operate in °F and has one temp setting.

Press '**SET**' (OUT 1 illuminated) – the last plenum temperature setting used will appear on the display, using the '**↑**' key to raise or '**↓**' key to lower the plenum temperature °F. The change will appear on the display, when the desired plenum temperature appears on the display, press '**SET**' to save and exit.

When operating, a light below the symbol 'OUT 1' will indicate where the actual temperature reading is in relation to the preset temperature. ie If the grain temp setting is 112°F and the grain probe is currently reading 102°F no light will illuminate, when the plenum temperature reaches the set temperature 112°F a green light will illuminate below 'OUT 1'.

## 4.5 GRAIN TEMP THERMOSTATS

Recommended operating temperatures – Section 2.4.3

Grain thermostat is factory set to operate in °F and has two temp settings.

**Hot grain temperature °F (Burner off);** Press '**SET**' once (OUT 1 illuminated) – the last grain hot temperature setting used will appear on the display, using the '**↑**' key to raise or '**↓**' key to lower the hot grain temperature °F. The change will appear on the display, when the desired grain temperature appears on the display, press '**SET**' to save and move onto Cool grain temperature, or press '**SET**' a second time to exit.



**Cool grain temperature °F (Discharge start);** Press 'SET' twice (OUT 2 illuminated) – the last cool grain temperature setting used will appear on the display, using the '↑' key to raise or '↓' key to lower the cool temperature. The change will appear on the display, when the desired grain temp for discharge appears on the display, press 'SET' to save and exit.

Two methods of cooling are possible;

1. Cool grain before unloading.

Under normal operation the cooling temperature is set below the grain hot temperature and above the ambient temperature, for example "OUT1 - 115" & "OUT2 - 85". This will allow the grain to be cooled by 30 degrees before unloading. The operator may adjust this setting to attain any level of cooling between the ambient air temperature and hot grain temperature.

2. Unload the grain hot

To unload the grain immediately after it reaches the hot grain temperature, set the cooling temperature equal to the grain hot temperature. This allows the operator to unload hot grain and cool the grain in an aeration bin.

#### 4.6 PLENUM SAFETY CONTROL

The plenum safety control (PIC 2. items 2 & 3) safeguards against excessive plenum temperatures, two temperature thermostats are used – one positioned in the plenum chamber and one positioned in the fan. During initial start-up of the dryer the microprocessor checks both safety thermostats to make certain the plenum temperature falls within the safe operating range. If so, operation continues and the dryer begins the cycle. Should the thermostat open at any time during operation, power to the microprocessor will be interrupted, halting operation of the dryer.

The safety thermostats operate in °C and should be set approx 30°C above the running Plenum Air Temperature setting (Note; Plenum temperature is °F, temp conversion chart in section 2). This is generally left at the factory setting and does not need constant adjustment.

#### 4.7 SILO SENSORS

The bottom & middle silo sensors are proximity sensors, they can be adjusted for sensitivity and is factory set to cover most crop types, over time this may need adjusting to register crops. The top silo sensor is a micro switch sensor, there is a secondary safety sensor mounted beside it, this is to ensure the dryer does not over-fill if the first sensor was to fail.

During loading, when grain covers the middle sensor the fan will start, purge air for 20 seconds then ignition will attempt to start the burner, the heating cycle operates and the loading auger will continue to fill the silo until the top sensor is reached, at this point the loading cycle will stop.

The fill silo over-ride button can be used during empty auto test or during operation to signal dryer is full and move controls onto full heating. This may assist if there is insufficient crop to completely fill the dryer.



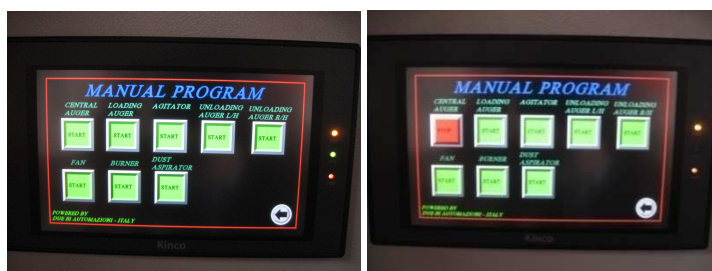


## 4.8 STARTING INSTRUCTIONS



Turn main power isolator to 'ON' position, the touch screen will power up and display a introduction. Touch the middle of the screen and the program options will appear. Select a program , MANUAL by pressing the program option button, then press the red arrow to enter that program.

### MANUAL PROGRAM



To start a motor, press the green start button and the motor will operate, the button will then change to a red stop button. To stop a motor press the red stop button.

Motor operation sequences, press;

LOADING:	Central auger & Loading auger (Note – Agitator will not operate)
HEATING:	Central auger & Agitator & Fan & Burner
COOLING:	Central auger & Agitator & Fan
UNLOAD:	Central auger & Agitator & Unloading auger

When all motors are stopped, you can return to the program menu by pressing the back arrow on the lower r/h corner of the screen.



## AUTO DRYING PROGRAM



Select 'AUTO PROGRAM' on the control panel

For Continuous Batch Drying turn 'SINGLE CYCLE to OFF', for Single Batch Drying turn 'SINGLE CYCLE to ON'



In continuous batch mode, it is possible to select an actual number of batches to be completed. To choose an actual batch quantity, press the batches 'TO DO' button (green area), this will open a number pad, select the required number and press ENT to enter (0 will allow the program to continuously until no crop is left to fill within time limit)

To choose an actual batch quantity, press the batches 'TO DO' button (green area), this will open a number pad, select the required number and press ENT to enter



To access page 2 of Auto Drying settings, press the r/h arrow in the bottom r/h corner of the screen. On page 2 you can alter the factory set times for 'Loading' (40min) and 'Unloading' (30min) To alter these time setting, press the time button (green area), this will open a number pad, select the required time and press ENT. On this page it is also possible to change the direction of discharge auger (machines fitted with Twin Discharge) the selector button will move from l/h to r/h when pressed once. **NOTE; Only adjust this when the discharge auger is turned off on page 1 of the Auto Program.**

To access page 3 of the Auto Drying settings, press the r/h arrow in the bottom r/h corner of the screen. On page 3 you can select the 'Auto refill' option – this allows the loading auger to operate during the heat cycle to top up a batch with wet grain. The Auto Refill on/off selector should be pressed to set this to on or off.

The 'total time' is a period when you would like the dryer to consider loading wet grain when the dryer is heating (we suggest this is limited to the first 30min of a heating cycle)



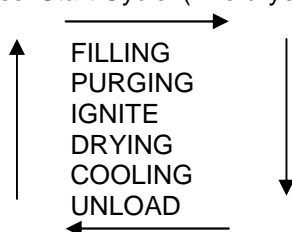
The 'time interval' is the time period when the computer will look at the top sensor and determine if any grain is required (due to grain shrinkage) – If the top sensor is still covered not Loading will occur, if the top sensor is uncovered then wet grain will Load (we suggest this time interval is set a 5min intervals to ensure wet crop is well blended with the grain being dried). The 'Refill Events To Do' is the number of times the computer will look for the top sensor (we suggest this is set to 5)

To return to page 1 of the Auto Drying settings, press the r/h arrow in the bottom r/h corner of the screen.

To start a Auto cycle;

Set both temperature thermostats to the desired temperatures.

Press 'Start Cycle' (The dryer cycles in the following order)



The dryer will begin to fill, 'Central auger' & 'Loading auger' motors will operate. The 'Fan' & 'Burner' will operate when the middle sensor is covered with grain, as ignition attempts begin, the solenoid controlled fuel valves open and the ignition electrode plug begins to spark. When the flame is established the burner photocell will detect this and end the ignition.

A micro switch sensor is mounted at the top of the dryer to determine when the grain has reached this level, a maximum time limit is set on page 2 (factory setting 30 minutes) is allowed to reach this point. If the bin is not full by the end of this period, the dryer will shut down. This prevents the machine from attempting to fill for more than a short period should the wet grain supply become exhausted or a problem with the loading auger arise.

When the grain is detected at the top of the dryer, the loading cycle ends and the 'Agitator' motor will start, the drying cycle will run. The burner will operate at maximum output to bring the plenum temperature up to the operating level as quickly as possible. When the preset plenum temperature is reached, the dryer will begin to cycle between high and low burn to maintain this temperature. If at any time you wish to alter the drying parameters, the thermostats can be adjusted at any time during the operation.

When the grain has reached the pre-set grain hot temperature, the burner will be extinguished and the dryer will automatically switch to the COOLING or UNLOADING cycle depending on the Grain thermostat cool temperature set point.

If the dryer was set to cool, the fan will continue to operate, moving ambient air through the hot grain to lower the grain temperature. When the grain cools to the preset grain cool temperature, the dryer will begin to UNLOAD. An electronic grain level sensor is located in the bottom of the dryer. When the grain level drops below this sensor the UNLOAD AUGER will run for 30 seconds then stop. The time allowed for unloading is set by the operator (factory set at 30 minutes). If the grain level has not reached the bottom grain level sensor within this period, the dryer will shut down.

If the dryer was set to unload when the grain hot temperature is reached, the dryer will immediately go to the unloading cycle as described above.



When the dryer is completely unloaded, the cycle will start again and the dryer will begin to fill after 5 seconds.

The dryer will continue to operate in this fashion until the wet grain supply has become exhausted or an error condition has been detected. Regardless of the cause, all motors will stop, the following error conditions are possible;

#### ERROR CONDITION

SILO EMPTY	Bin did not fill – wet supply exhausted or fill failure
AGITATOR	Agitator motion stopped – agitator failure
CENTRAL AUGER	Auger motion stopped – auger failure
THERMIC SAFETY	Motor circuit breaker tripped – driveline fault or overloaded
BURNER FAULT	
EMERGENCY STOP	

#### CONDITIONING PROGRAM



Select 'CONDITIONING PROGRAM' on the control panel

For Continuous Batch Drying turn 'SINGLE CYCLE to OFF', for Single Batch Drying turn 'SINGLE CYCLE to ON'



In continuous batch mode, it is possible to select an actual number of batches to be completed. To choose an actual batch quantity, press the batches 'TO DO' button (green area), this will open a number pad, select the required number and press ENT to enter (0 will allow the program to continuously until no crop is left to fill within time limit)

To choose an actual batch quantity, press the batches 'TO DO' button (green area), this will open a number pad, select the required number and press ENT to enter



To access page 2 of Conditioning Drying settings, press the r/h arrow in the bottom r/h corner of the screen. On page 2 you can alter the factory set times for 'Loading' (40min) and 'Unloading' (30min) To alter these time setting, press the time button (green area), this will open a number pad, select the required time and press ENT. On this page it is also possible to change the direction of discharge auger (machines fitted with Twin Discharge) the selector button will move from l/h to r/h when pressed once. **NOTE; Only adjust this when the discharge auger is turned off on page 1 of the Conditioning Program.**

Select a Fan Run Time required to condition crop - press the 'SET FAN RUN TIME' button (green area), this will open a number pad, select the required number and press ENT to enter. This time will start counting when the top silo sensor is activated.

If you need the burner to operate during conditioning, press the Burner on/off selector to the on position. Select a Burner Run Time required to condition crop - press the 'SET BURNER RUN TIME' button (green area), this will open a number pad, select the required number and press ENT to enter. This time will start counting when the fan starts with the middle silo sensor.

To access page 3 of the Conditioning Drying settings, press the r/h arrow in the bottom r/h corner of the screen. On page 3 you can select the 'Auto refill' option – this allows the loading auger to operate during the heat cycle to top up a batch with wet grain. The Auto Refill on/off selector should be pressed to set this to on or off.

The 'total time' is a period when you would like the dryer to consider loading wet grain when the dryer is heating (we suggest this is limited to the first 30min of a heating cycle) The 'time interval' is the time period when the computer will look at the top sensor and determine if any grain is required (due to grain shrinkage) – If the top sensor is still covered not Loading will occur, if the top sensor is uncovered then wet grain will Load (we suggest this time interval is set a 5min intervals to ensure wet crop is well blended with the grain being dried). The 'Refill Events To Do' is the number of times the computer will look for the top sensor (we suggest this is set to 5)

To return to page 1 of the Conditioning Drying settings, press the r/h arrow in the bottom r/h corner of the screen.

To start a Conditioning cycle;

Set the Plenum temperature thermostat to control the burner temperature, the Grain hot temperature to the desired temperatures.





Press 'Start Cycle' (The dryer cycles in the following order)



The dryer will begin to fill, 'Central auger' & 'Loading auger' motors will operate. The 'Fan' & 'Burner' (where selected) will operate when the middle sensor is covered with grain, as ignition attempts begin, the solenoid controlled fuel valves open and the ignition electrode plug begins to spark. When the flame is established the burner photocell will detect this and end the ignition.

A micro switch sensor is mounted at the top of the dryer to determine when the grain has reached this level, a maximum time limit is set on page 2 (factory setting 30 minutes) is allowed to reach this point. If the bin is not full by the end of this period, the dryer will shut down. This prevents the machine from attempting to fill for more than a short period should the wet grain supply become exhausted or a problem with the loading auger arise.

When the grain is detected at the top of the dryer, the loading cycle ends and the 'Agitator' motor will start, the conditioning cycle will run. The burner (where selected) will operate at maximum output to bring the plenum temperature up to the operating level as quickly as possible. When the preset plenum temperature is reached, the dryer will begin to cycle between high and low burn to maintain this temperature. If at any time you wish to alter the drying parameters, the thermostats can be adjusted at any time during the operation.

If the burner was selected 'ON' when the burner run time has completed, the burner will be extinguished and the dryer will automatically switch to the COOLING/CONDITIONING cycle.

The fan will continue to operate, moving ambient air through the grain to lower the grain temperature. When the grain cools to the preset grain cool temperature, the dryer will begin to UNLOAD. An electronic grain level sensor is located in the bottom of the dryer. When the grain level drops below this sensor the UNLOAD AUGER will run for 30 seconds then stop. The time allowed for unloading is set by the operator (factory set at 30 minutes). If the grain level has not reached the bottom grain level sensor within this period, the dryer will shut down.

If the dryer was set to unload when the conditioning cycle is completed, the dryer will immediately go to the unloading cycle as described above.

When the dryer is completely unloaded, the cycle will start again and the dryer will begin to fill after 5 seconds.

The dryer will continue to operate in this fashion until the wet grain supply has become exhausted or an error condition has been detected. Regardless of the cause, all motors will stop, the following error conditions are possible;

**ERROR CONDITION**

SILO EMPTY	Bin did not fill – wet supply exhausted or fill failure
AGITATOR	Agitator motion stopped – agitator failure
CENTRAL AUGER	Auger motion stopped – auger failure
THERMIC SAFETY	Motor circuit breaker tripped – driveline fault or overloaded
BURNER FAULT	
EMERGENCY STOP	



To stop the dryer at any time during the cycle press the stop cycle button or press the emergency stop button.

**4.9 HOW TO GET THE BEST PERFORMANCE OUT OF YOUR DRYER****ON THE FIRST DRYING OF EACH DIFFERENT CROP TYPE ON YOUR FARM PROCEED AS FOLLOWS:**

Set the finished grain temperature to 120 degrees F, this is well above the setting that you will finally use once you have calibrated the first batch.

Check the finished grain temperature gauge reading from time to time. When the grain temperature has achieved 95 degrees F take your first sample to check for actual grain moisture.

Depending upon altitude, outside air temperature and if it is a dry or wet day you will record approximately between 16% and 18% moisture.

Continue to run the dryer and take a further sample of grain at 100 degrees F. Continue in this fashion until the grain is half a percent above finished moisture content required. So if you are looking for 14% moisture content and you achieve 14½% at 108 degrees F press the button marked 'SET' (PIC 1. item 5) press the down arrow to bring the temperature from 120 degrees down to 108 degrees. The burner will cut off and the cooling cycle will begin.

When all the grain is cooled take a further sample before emptying the dryer to check the finished moisture content.

If the finished moisture content is below 14% then you can fine-tune the finished grain temperature by decreasing the value locked into the finished grain temperature gauge by 1 degree.

After two or three loads you will achieve the right balance for the particular crop type. At this point write down the plenum temperature you have used and the finishing grain temperature for that particular crop type as a future record.





The major variable to consider is not moisture content, outside air temperature etc., but rather the plenum temperature used. There is a balance between extra heat and therefore extra fuel usage against time of drying.

The recommendations given in our Crop Drying Recommendations are a good starting point. (Section 2.4.3)

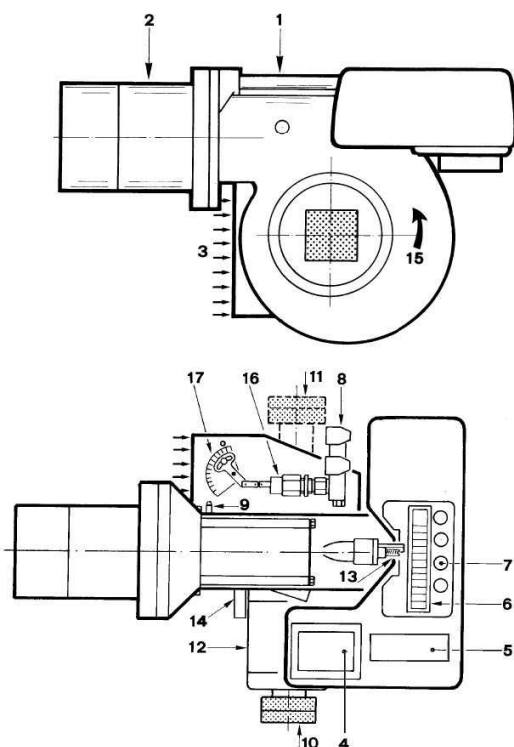
**NOTE:** WHEN DRYING ANY CROPS FOR SEED OR MALTING YOU MUST NOT USE PLENUM AIR TEMPERATURES HIGHER THAN OUR RECOMMENDATION.

#### 4.10 BURNER - RIELLO

For full details on the Riello burner please refer to the separate Riello burner manual. There are occasions when drying temperatures required will vary significantly from the norm. For example when drying seed crops you may need to use smaller nozzles to achieve the correct plenum temperatures.

In Oil Seed Rape because of crop density overall air flow can be reduced, heat retention is increased and again it may be necessary to use smaller nozzles.

##### BURNER DESCRIPTION



- 1 Guides for opening the burner and inspecting the combustion head
- 2 Combustion head
- 3 Fan air inlet
- 4 Ignition transformer
- 5 10 pole socket
- 6 Terminal strip
- 7 Fairleads for wiring carried out by the installer
- 8 Valve assembly
- 9 Fan pressure test point
- 10 Pump PRESS GW-1G-2G-3G
- 11 Pump PRESS 4G
- 12 Electrical motor
- 13 Screw for combustion head adjustment
- 14 Photocell for flame presence control
- 15 Fan rotation direction
- 16 Variable stroke hydraulic cylinder. Opens the fan gate valve to the value necessary at the 2<sup>nd</sup> stage of operation.
- 17 Indexed selector.

This selector adjusts the opening of the fan gate to the value necessary at the 1<sup>st</sup> stage of functioning.



## CHOICE OF NOZZLES FOR 1<sup>ST</sup> AND 2<sup>ND</sup> STAGE

Both nozzles must be chosen from among those listed in Table (H). The first nozzle determines the delivery of the burner in the 1<sup>st</sup> stage. The second nozzle works together with the 1<sup>st</sup> nozzle to determine the delivery of the burner in the 2<sup>nd</sup> stage.

Use nozzles with atomization angles of 60° and, if possible, at a pressure of 12 bar.

The two nozzles usually have equal deliveries, but the 1<sup>st</sup> stage nozzle may have the following specifications if required: - a delivery less than 50% of the total delivery whenever the back-pressure peak must be reduced at the moment of firing; - a delivery higher than 50% of the total delivery whenever the combustion during the 1<sup>st</sup> stage must be improved.

Burner	Nozzles	delivery kg/h (1)			kW
		60°-GPH	10 bar	12 bar	
PRESS 1G	2,00	7,7	8,5	9,2	100,8
	2,25	8,6	9,5	10,4	112,7
	2,50	9,6	10,6	11,5	125,7
	3,00	11,5	12,7	13,6	150,6
	3,50	13,5	14,8	16,1	175,5
	4,00	15,4	17,0	18,4	201,6
	4,50	17,3	19,1	20,7	226,5
	5,00	19,2	21,2	23,0	251,4
PRESS 2G	5,50	21,1	23,3	25,3	276,3
	4,00	15,4	17,0	18,4	201,6
	4,50	17,3	19,1	20,7	226,5
	5,00	19,2	21,2	23,0	251,4
	5,50	21,1	23,3	25,3	276,3
	6,00	23,1	25,5	27,7	302,4
PRESS 3G	6,50	25,0	27,6	30,0	327,3
	7,00	26,9	29,7	32,3	352,3
	6,00	23,1	25,5	27,7	302,4
	6,50	25,0	27,6	30,0	327,3
	7,00	26,9	29,7	32,3	352,3
	7,50	28,8	31,8	34,6	377,2
	8,30	31,9	35,2	38,3	417,5
	9,50	36,5	40,3	43,6	478,0
PRESS 4G	10,50	40,4	44,5	48,4	527,8
	12,00	46,1	50,9	55,3	603,7
	9,50	36,5	40,3	43,8	478,0
	10,50	40,4	44,5	48,4	527,8
	12,00	46,1	50,9	55,3	603,7
	13,80	53,1	58,5	63,6	693,8
	15,30	58,2	64,9	70,5	769,7
	17,50	67,3	74,2	80,7	880,0

Tab. H

### Example with the Press 1G Model:

Boiler output = 270 kW - efficiency 90 %

Output required by the burner =  
 $270 : 0.9 = 300 \text{ kW};$   
 $300 : 2 = 150 \text{ kW per nozzle};$

therefore, two equal, 60°, 12 bar nozzles are required: 1° = 3.00 GPH - 2° = 3.00 GPH,

or the following two different nozzles:  
 1° = 2.50 GPH - 2° = 3.50 GPH,  
 or 1° = 3.50 GPH - 2° = 2.50 GPH.

Model	Burner	1°	2°	Total	Spare
120E	2G	5	7	12	4
1200	2G	6.5	6.5	13	4
2000	3G	8	11	19	6.5
2910	4G	11	16	27	9
3810	4G	16	16	32	9
4810	4G	16	16	32	9

## NOZZLE ASSEMBLY

The nozzle for the 1<sup>st</sup> stage of operation is the one lying beneath the firing electrodes Fig. (14). With the burner open on the slide bars, the two nozzles (1, Fig 13) are removed using a 16 mm wrench. When refitting do not use any sealing products such as gaskets, sealing compound, or tape. The nozzles must be screwed into place tightly but not to the maximum torque value provided by the wrench.

Be careful to avoid damaging the nozzle sealing seat. Make sure that the electrodes are positioned as shown in Figure (14). Lastly, close the burner by screwing in the two screws.

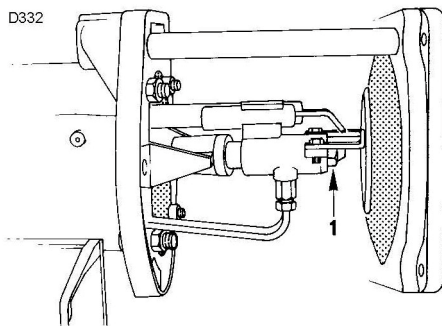


Fig. 13

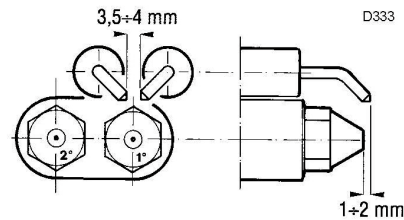


Fig. 14

## CALIBRATIONS BEFORE FIRING

### Combustion head setting

The setting of the combustion head depends exclusively on the delivery of the burner in the 2<sup>nd</sup> stage - in other words, the combined delivery of the two nozzles selected (Tab H). Set the screw 1)(Fig 16) in such way that its rear surface corresponds to the notch number shown in Fig 18.

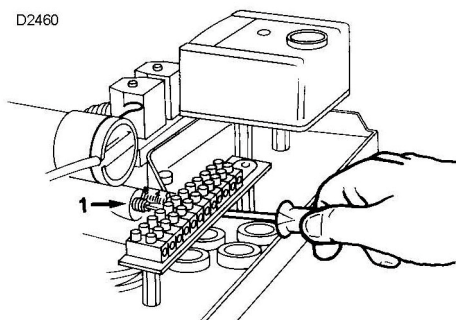


Fig. 16

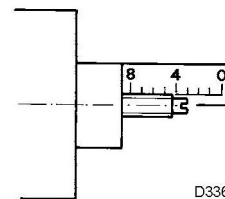


Fig. 17

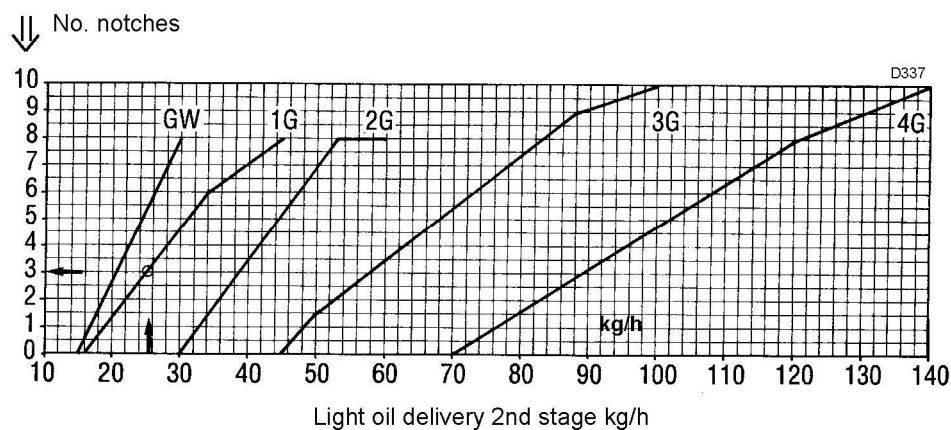


Fig. 18

### Example:

The PRESS 1G Model with two 3.00 GPH nozzles and 12 bar pump pressure.

Find the delivery of the two 3.00 GPH nozzles in Table (H), Page 26:  $12.7 + 12.7 = 25.4$  kg/h.

Diagram (G) indicates that for a delivery of 25.4 kg/h the PRESS 1G Model requires the combustion head to be set to approx. three notches, as shown in Figure (17).



### Fuel pump adjustment

No pre settings are required for the pump, which is set to 12 bar by the manufacturer. This pressure must be checked and adjusted (if required) after the burner has been ignited. The only operation required in this phase is the application of a pressure gauge to check pressure setting (Fig 27.28.29).

**PRESS 1G - 2G:**  
SUNTEC AN77

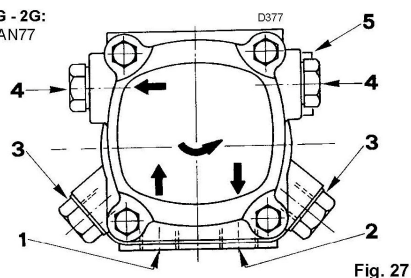


Fig. 27

**PRESS 3G:**  
SUNTEC J6

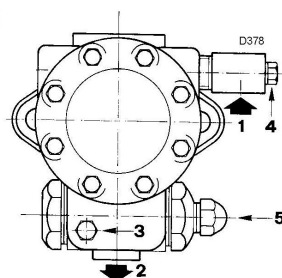


Fig. 28

**PRESS 4G:**  
SUNTEC J7

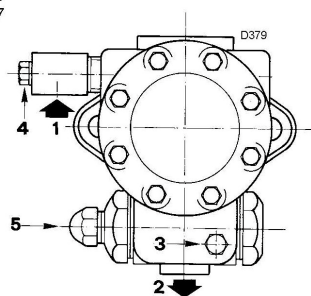


Fig. 29

#### Pump

- 1 Suction line
  - 2 Return line
  - 3 Pressure gauge attachment
  - 4 Suction gauge connection
  - 5 Pressure adjustment screw:
- Right rotation = pressure increases  
Left rotation = pressure decreases

#### AN

- G1/4"
- G1/4"
- G1/8"
- G1/8"

#### J

- G1/2"
- G1/2"
- G1/8"
- G1/2"

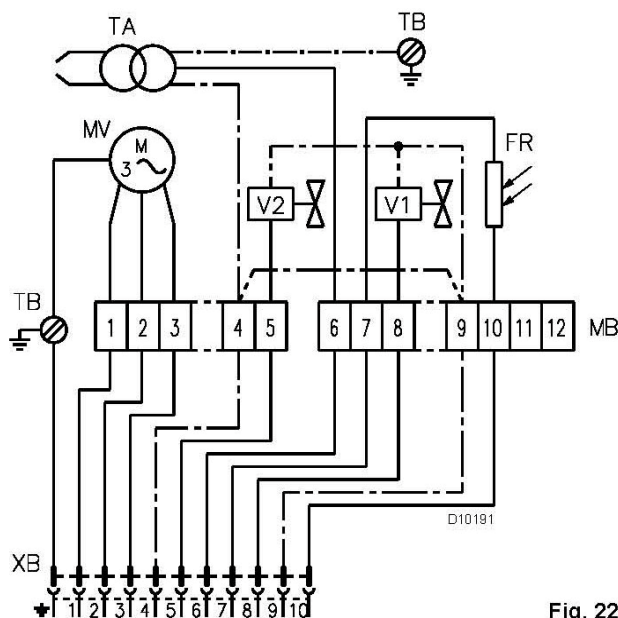
G = cylindrical thread

The connector to be screwed into the cylindrical thread G must be equipped with a sealing washer.

Do not screw a connector with a conical thread (NPTF) into the cylindrical thread G.



## BURNER ELECTRICAL CONNECTION



### Key to Layout (Fig. 22)

MB- Burner terminal strip  
TB- Burner ground (earth) connection  
MV- Fan motor  
TA- Ignition transformer  
V1- 1st stage solenoid valve  
V2- 2nd stage solenoid valve  
FR- Photocell  
XB- 10 pole socket

Fig. 22

## BURNER AIR SETTING

### GPH nozzle 1st stage -N° Set-point

PRESS 1G		PRESS 2G		PRESS 3G		PRESS 4G	
GPH	No.	GPH	No.	GPH	No.	GPH	No.
2,00	1	4,00	1	6,00	1,5	9,5	1,5
2,25	1	4,50	1	6,50	2	10,50	2
2,50	1,5	5,00	1,5	7,00	2	12,00	2
3,00	2	5,50	2	7,50	2,5	13,80	2,5
3,50	2,5	6,00	2	8,30	2,5	15,30	2,5
4,00	2,5	6,50	2,5	9,50	3	17,30	3
4,50	2,5	7,00	3	10,50	3,5		
5,00	3			12,00	4		
5,50	3						

Tab. I

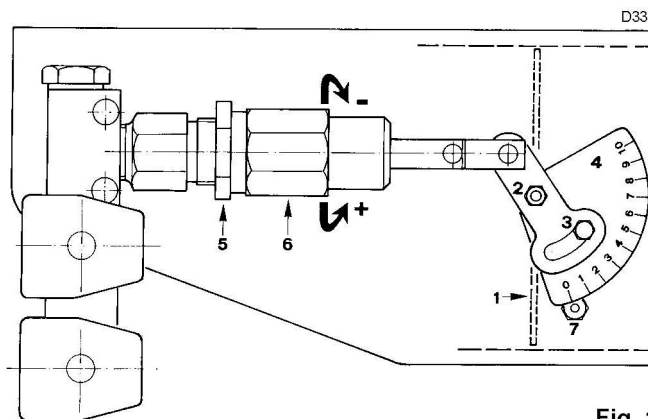



Fig. 19

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### **Fan gate adjustment**

1st stage:

The air gate valve 1)(Fig 19) is set using the indexed selector 4)(Fig 19)

Loosen the screw 3)(Fig 19) and the nut 2)(Fig 19) and shift the indexed selector 4) so that the index finger 7)(Fig 19) corresponds to the required notch setting indicated in Table (I) according to the 1st stage nozzle's delivery.

#### **Example**

The PRESS 1G Model burner - 3.00 GPH nozzle.

The indexed selector must be set to notch 2.

2nd stage:

The air gate valve 1)(Fig 19) must be set using the cylinder 6)(Fig 19). This setting must be adapted case by case to the burner's delivery and combustion chamber pressure. The first time the burner is fired, the hydraulic cylinder setting should be left as originally set by the manufacturer: at approximately half of its full stroke.

In summary, the operations and settings that must be performed prior to firing the burner for the first time are as follows:

- choice of the two nozzles;
- setting of the combustion head;
- setting of the fan's air gate valve for the 1<sup>st</sup> stage.

The following require no adjustment operations and may remain as they are provided:

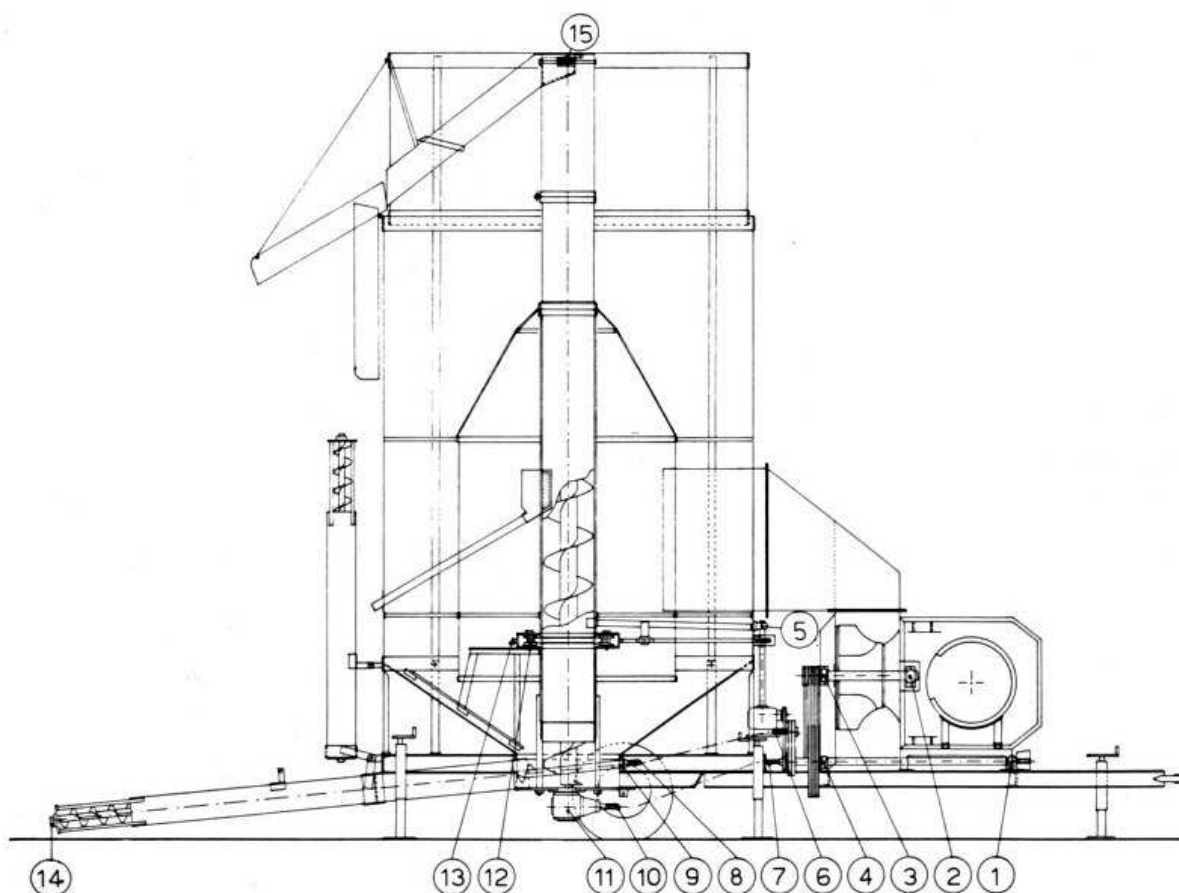
- pump pressure;
- setting of the fan's air gate valve for the 2<sup>nd</sup> stage.













## 5 MAINTENANCE

Please take care not to over grease. Many of the bearings and rollers on this dryer require greasing only once per season. More harm will be done by over enthusiastic application than benefit.














Picture 5.1 **POINTS TO LUBRICATE**

-  2, 3 - FAN SHAFT BEARINGS (GREASE LIGHTLY AT 100HRS AND/OR AT THE END OF EACH SEASON)
-  5,9,14 – LOADING AUGER & AGITATOR SUPPORT BEARINGS (GREASE LIGHTLY AT 100HRS AND/OR AT THE END OF EACH SEASON)
-  12 - AGITATOR SUPPORT ROLLERS (GREASE LIGHTLY EVERY 100HRS)
-  13 - CHAIN (DRY FILM SPRAY LUBRICATE AT THE END OF EACH SEASON )
-  11,15 - VERTICAL AUGER SUPPORT BEARING TOP & BOTTOM (GREASE LIGHTLY EVERY 5 DAYS.) VERTICAL AUGER GEARBOX (WHERE FITTED) CHECK OIL LEVEL EVERY 250HRS
-  6 – AGITATOR GEARBOX (CHECK FOR OIL LEAKS, UNIT SEALED FOR LIFE USES SYNTHETIC GREASE)
-  7 – SUPPORT JACK STANDS (GREASE ONCE EVERY SEASON)
-  WINCHES (DRY FILM SPRAY LUBRICANT ONCE EACH SEASON)










## 5.2 GENERAL OPERATING MAINTENANCE

-  KEEP THE WORKING AREA CLEAR OF CHAFF AND OTHER COMBUSTIBLE MATERIAL
-  CLEAN THE INSIDE PLENUM CHAMBER
-  CHECK AGITATOR CHAIN AND CHAIN TENSIONER
-  COVER AND PROTECT ALL THE ELECTRIC COMPONENTS FROM HUMIDITY
-  CHECK THE AGITATOR ROLLER BEARINGS, REPLACE AS NECESSARY
-  CHECK THE VERTICAL AUGER AND THE VERTICAL TUBE FOR WEAR
-  CHECK ALL DRIVE BELT TENSIONS
-  CHECK THE CONDITION OF THE FURNACE'S REFRACTORY MATERIAL
-  CHECK THE CONDITION OF THE STEEL BASE OF THE FURNACE
-  CHECK THE CONDITION OF THE PROTECTION GUARD OF THE FAN SUPPORT BEARING, PLACED AT THE EXIT OF THE FURNACE FIRE MOUTH BETWEEN FURNACE AND FAN
-  CHECK THE CONDITION OF CABLES AND WINCHES

## 5.3 ELECTRIC COMPONENT MAINTENANCE

-  CHECK THE CONDITION OF MOTORS AND CABLES REGULARLY
-  CLEAN MOTOR HOUSINGS AND FANS USING COMPRESSED AIR TO PREVENT OVERHEATING
-  ELECTRIC MOTORS, CONTROL PANEL AND ALL WIRING SHOULD BE INSPECTED BY A QUALIFIED ELECTRICIAN PERIODICALLY
-  ENSURE THE CONTROL ENCLOSURE IS KEPT CLEAN

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## 6 **SAFETY WARNINGS**

In addition to the design and configuration of equipment, hazard control and accident prevention are dependent upon the awareness, concern, prudence and proper training of personnel in the operation, transport, maintenance and storage of equipment. Lack of attention to safety can result in accident, personal injury, a reduction of efficiency and worst of all – loss of life.

Watch for safety hazards and correct deficiencies promptly.

Use the following safety precautions as a general guide to safe operations when using the machine.

Additional safety precautions are used throughout this manual for specific operating and maintenance procedures. Read this manual and review the safety precautions often until you know the limitations.

### 6.1 **SAFETY PRINCIPLE**

The following are general rules for the users of the machine:



**BEFORE USING THE MACHINE CAREFULLY READ ALL PARTS OF THIS MANUAL. REFRAIN FROM USING THE DRYER UNTIL THE ENTIRE MANUAL (AND ALL ITS ATTACHMENTS) ARE UNDERSTOOD.**



## 6.2 WARNINGS AND DANGERS



DO NOT ALLOW ANYONE TO OPERATE THE MACHINE WHO IS NOT IN GOOD PHYSICAL AND MENTAL HEALTH.



KEEP CHILDREN, VISITORS AND ALL UNTRAINED PERSONNEL AWAY FROM THE MACHINE WHILE IN OPERATION.



DO NOT USE THE DRYER WITHOUT ALL THE SAFETY GUARDS IN THE CORRECT POSITION.



DO NOT CARRY OUT MAINTENANCE WORK AND/OR REPAIRS UNTIL THE MAIN ELECTRIC POWER SWITCH TURNED TO OFF.



DO NOT UNDER ANY CIRCUMSTANCES ENTER THE DRYER THROUGH THE INSPECTION HATCH UNTIL THE MAIN ELECTRIC POWER SWITCH IS TURNED TO OFF. FAILURE TO FOLLOW THIS INSTRUCTION MAY CAUSE SERIOUS INJURY. EXPLANATION – SHOULD THE AGITATOR ARM RECIRCULATE WHILST THE OPERATOR IS ENTERING THE DRYER OR INSIDE THE DRYER



DO NOT ALTER THE DIMENSIONS OR SHAPE OF THE ADJUSTABLE JACK FEET.



DO NOT MOVE THE DRYER WITH TYRES THAT ARE DEFLATED OR NOT SUITABLE FOR SERVICE.



DO NOT MOVE THE MACHINE UNLESS IT IS FULLY IN THE TRANSPORT MODE I.E. WITH THE LOADING AUGER FULLY RAISED FOLD DOWN AUGER FULLY LOWERED AND THE EXTENDING SIDE SHEETS FULLY CLOSED.



DO NOT ALLOW ANY OBSTRUCTION TO THE AIR INLET.



DO NOT THROW ANY TYPE OF OBJECT INTO THE DRYER, THE BURNER UNIT OR THE INLET AIR DUCT.




DO NOT TOUCH THE INSIDE OF THE BURNER BOX ASSEMBLY WHEN IT IS WORKING OR FOR A PERIOD OF AT LEAST ONE HOUR AFTER WORK.



DO NOT CLIMB OR USE THE LADDER WITHOUT FIRST STOPPING THE DRYER AND DISENGAGING THE POWER SUPPLY



DO NOT ALLOW MORE THAN ONE PERSON TO BE ON THE LADDER AT ANY ONE TIME .

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## 6.3 SAFETY GUARDS AND WARNING LOGOS

For safety the dryer is supplied with the necessary safety guards and warning logos.



SHOULD THE SAFETY GUARDS BE REMOVED TO CARRY OUT MAINTENANCE OR CLEANING IT IS THE OPERATORS RESPONSIBILITY TO ENSURE THAT THEY ARE REPLACED IN THEIR ORIGINAL POSITION PRIOR TO OPERATING THE DRYER.

### 6.3.1 EMERGENCY STOP BUTTON

The red emergency button is positioned at the main control panel: if pushed it instantly stops all electrical power to the machine.

NOTE; Motor over loads may need to be reset if emergency stop has been activated.

## 6.4 RESIDUAL RISKS

Some residual risks cannot be avoided in the natural process of grain drying. The following list is indicative not exhaustive



DO NOT PLACE YOUR HANDS OR ANY OTHER PART OF THE BODY THROUGH THE SAFETY MESH POSITIONED OVER THE LOADING AUGER



BE AWARE OF POSSIBLE DANGER WHEN LOWERING THE LOADING AUGER INTO ITS WORKING POSITION



BE AWARE OF POSSIBLE DANGER WHEN POSITIONING THE DRYER USING THE ADJUSTABLE JACKS



BE AWARE OF POSSIBLE DANGER WHEN ATTACHING THE POWER CABLE TO THE SUPPLY SOCKET.

## 6.5 NOISE LEVELS

The level of acoustic pressure of the Magna mobile dryers has been measured with the machine loaded while working in a open field on the 4 compass points at 1,5 meters distance and at 1,6 meters height from ground. The level is between 77dB(A) and 88 dB(A).



## 7 TROUBLE SHOOTING

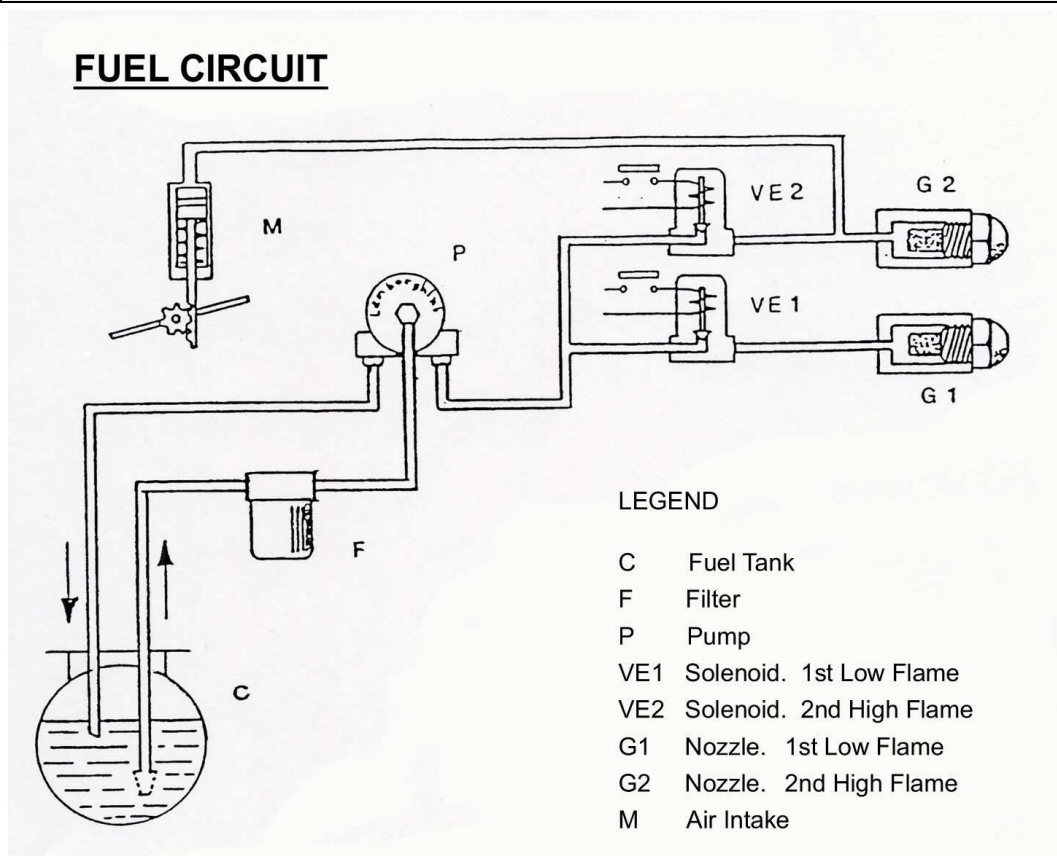
### 7.1 THE BURNER

FAULT	PROBABLE CAUSE	SUGGESTED REMEDY
The burner does not start	<ul style="list-style-type: none"> <li>No electrical power supply</li> <li>A limit or safety control device is open</li> <li>Motor lock-out</li> <li>Pump is jammed</li> <li>Erroneous electrical connections</li> <li>Defective motor command control device</li> <li>Defective electrical motor</li> <li>Photocell short-circuit</li> <li>Light is entering or flame is simulated</li> </ul>	<ul style="list-style-type: none"> <li>Close all switches - Check fuses</li> <li>Adjust or replace</li> <li>Reset thermal cutout</li> <li>Replace</li> <li>Check connections</li> <li>Replace</li> <li>Replace</li> <li>Replace photocell</li> <li>Eliminate light or replace control box</li> </ul>
The burner starts but stops almost immediately	<ul style="list-style-type: none"> <li>Missing phase thermal cutout triggers</li> </ul>	<ul style="list-style-type: none"> <li>Reset thermal cutout when third phase returns</li> </ul>
After pre-purge the burner goes to lock-out and the flame does not appear	<ul style="list-style-type: none"> <li>No fuel in tank; water on tank bottom</li> <li>Inappropriate head and air damper adjustments</li> <li>Light solenoid valve fails to open</li> <li>Nozzle clogged, dirty, or deformed</li> <li>Dirty or poorly adjusted firing electrodes</li> <li>Grounded electrode due to broken insulation</li> <li>High voltage cable defective or grounded</li> <li>High voltage cable deformed by high temperature</li> <li>Ignition transformer defective</li> <li>Erroneous valve or transformer electrical connections</li> <li>Pump unprimed</li> <li>Pump/motor coupling broken</li> <li>Pump suction line connected to return line</li> <li>Valves up-line from pump closed</li> <li>Filters dirty: line - pump - nozzle</li> <li>Incorrect motor rotation direction</li> </ul>	<ul style="list-style-type: none"> <li>Top up fuel level or suck up water</li> <li>Consult manual</li> <li>Check connections; replace coil</li> <li>Replace</li> <li>Adjust or clean</li> <li>Replace</li> <li>Replace</li> <li>Replace or protect</li> <li>Replace</li> <li>Check connections</li> <li>Prime pump and see "Pump unprimed"</li> <li>Replace</li> <li>Correct connection</li> <li>Open</li> <li>Clean</li> <li>Change motor electrical connections</li> </ul>
The burner goes to lock-out right after flame appearance	<ul style="list-style-type: none"> <li>Delayed firing by electrodes or poorly adjusted head</li> <li>Defective photocell</li> <li>Dirty photocell</li> </ul>	<ul style="list-style-type: none"> <li>Adjust</li> <li>Replace</li> <li>Clean</li> </ul>
Firing with pulsations or flame detachment	<ul style="list-style-type: none"> <li>Poorly adjusted head</li> <li>Poorly adjusted firing electrodes</li> <li>Poorly adjusted fan air gate: too much air</li> <li>Nozzle unsuited for burner or boiler</li> <li>Defective nozzle</li> <li>Inappropriate pump pressure</li> </ul>	<ul style="list-style-type: none"> <li>Adjust according to Manual</li> <li>Adjust according to Manual</li> <li>Adjust</li> <li>See Nozzle Table; reduce 1st stage</li> <li>Replace</li> <li>Adjust according to Manual</li> </ul>
The burner does not pass to 2nd stage	<ul style="list-style-type: none"> <li>Control device TR does not close</li> <li>2nd stage sol. valve coil defective</li> <li>Piston jammed in valve unit</li> </ul>	<ul style="list-style-type: none"> <li>Adjust or replace</li> <li>Replace</li> <li>Replace entire unit</li> </ul>
or fuel passes to 2nd stage but air remains in 1st	<ul style="list-style-type: none"> <li>Low pump pressure</li> <li>Defective cylinder</li> </ul>	<ul style="list-style-type: none"> <li>Increase</li> <li>Replace</li> </ul>
Uneven fuel supply	<ul style="list-style-type: none"> <li>Check if cause is in pump or in the fuel power supply system</li> </ul>	<ul style="list-style-type: none"> <li>Feed burner from tank fuel supply system located near burner</li> </ul>
Intermittently rusted pump	<ul style="list-style-type: none"> <li>Water in tank</li> </ul>	<ul style="list-style-type: none"> <li>Suck water from tank bottom with separate pump</li> </ul>
Noisy pump, instable pressure	<ul style="list-style-type: none"> <li>Air has entered the suction line</li> <li>Depression value too high (higher than 35 cm Hg): <ul style="list-style-type: none"> <li>Tank/burner height difference too great</li> <li>Piping diameter too small</li> <li>Suction filters clogged</li> <li>Suction valves closed</li> <li>Paraffin solidified due to low temperature</li> </ul> </li> </ul>	<ul style="list-style-type: none"> <li>Tighten connectors</li> <li>Feed burner with loop circuit</li> <li>Increase</li> <li>Clean</li> <li>Open</li> <li>Add additive to light oil</li> </ul>
Pump unprimed after prolonged pause	<ul style="list-style-type: none"> <li>Return pipe not immersed in fuel</li> <li>Air enters suction piping</li> </ul>	<ul style="list-style-type: none"> <li>Bring to same height as suction pipe</li> <li>Tighten connectors</li> </ul>
Pump leaks light oil	<ul style="list-style-type: none"> <li>Leakage from sealing organ</li> </ul>	<ul style="list-style-type: none"> <li>Replace pump</li> </ul>
Smoke in flame - dark Bacharach	<ul style="list-style-type: none"> <li>Not enough air</li> <li>Nozzle worn or dirty</li> <li>Nozzle filter clogged</li> <li>Erroneous pump pressure</li> <li>Dirty fan</li> <li>Flame stability disk dirty, loose, or deformed</li> <li>Boiler room air vents insufficient</li> </ul>	<ul style="list-style-type: none"> <li>Adjust head and fan gate according to Manual</li> <li>Replace</li> <li>Clean or replace</li> <li>Adjust to between 10 - 14 bar</li> <li>Clean</li> <li>Clean, tighten in place, or replace</li> <li>Increase</li> </ul>
- yellow Bacharach	<ul style="list-style-type: none"> <li>Too much air</li> </ul>	<ul style="list-style-type: none"> <li>Adjust head and fan gate according to Manual</li> </ul>



FAULT	PROBABLE CAUSE	SUGGESTED REMEDY
Dirty combustion head	- Nozzle or filter dirty	Replace
	- Unsuitable nozzle delivery or angle	See recommended nozzles
	- Loose nozzle	Tighten
	- Impurities on flame stability spiral	Clean
	- Erroneous head adjustment or not enough air	Adjust as per Manual instructions; open gate valve
	- Blast tube length unsuited to boiler	Contact boiler manufacturer

## 7.8 FUEL CIRCUIT



## 8 STORAGE



FOR OVER WINTER STORAGE IT IS ADVISABLE TO KEEP THE DRYER IN A COVERED AND DRY PLACE. SUITABLY PROTECT THE CONTROL PANEL AND THE DIESEL BURNER UNIT.



WHETHER THE MACHINE IS IN TRANSPORT MODE OR FULLY EXTENDED REMOVE THE WEIGHT FROM THE TYRES USING THE ADJUSTABLE JACKS.

## 9 WIRING DIAGRAMS

WIRING DIAGRAMS - PLEASE REFER TO SEPARATE ATTACHMENT WHICH WILL REFER TO PARTICULAR MODEL, YEAR BUILD ETC.