PNEG-1590
Dryer Final Assembly & Testing Checklist

Customer Name: _____

Order #: _____ **Serial #:** _____ **MET#:** _____

Model #: _____ **Date:** _____

Basket Assembly Checklist

___ ___ Check Order for all Dryer Options
___ ___ Check for loose bolts on dryer (Hit screens and panels and listen for rattles).
___ ___ Check that all screens installed with rough side out.
___ ___ Make sure Plenum Sensor located 36" from rear of Dryer.
___ ___ Check Wet Bin Tie Downs are installed.
___ ___ Check Hair Pins & Wedges are installed.
___ ___ Check that the plastic grommets are installed on the EMT conduit running to the back of the dryer.
___ ___ Check that all lock collars have been installed and the correct rotation applied.
___ ___ Blow off all metal filings from front and rear mounting angles.
___ ___ Check that bottom belt guard is installed correctly and motors are not pushing guards out.
___ ___ Check bottoms of control boxes for foreign material and blow out both if necessary.
___ ___ Check that both doors close without binding and will seal properly (Check weather seal on both doors for contact).
___ ___ Ground cable installed between both door and control box.
___ ___ Check that safety disconnect works properly.
___ ___ Check that hole plugs have been installed and siliconed.
___ ___ Ground lug installed.
___ ___ Check for loose connections by pulling on all control wires and tighten all power wires.
___ ___ Check that each wire has a label in both control boxes.
___ ___ Check and tighten all conduit fittings. Check upper junction box is siliconed.
___ ___ Put weep holes in bottom of white boxes.
___ ___ Make sure burner is centered
___ ___ Make sure grain hi-limits 210 are in grain column & plenum high limits 300 are in plenum

Review Paint Checklist

___ ___ Hand hold rail and grab bar.
___ ___ Shaft ends painted on Motors, Meter rolls, Augers
___ ___ Lock collars painted aluminum.
___ ___ Teflon sprayed on load motor shaft.
___ ___ Hitch
___ ___ Fan Heater blades have aluminum centers painted black for GSI / Aluminum for FFI.
___ ___ Venturi(s) & Grille Guards
___ ___ Pipe train painted black and touch up if necessary.
___ ___ All writing on metal removed.

Review Decal packing list to ensure all decals are on the dryer

___ ___ Two GSI "footballs" on frame (GSI).
___ ___ "Confined Space" decal on rear door (FFI).
___ ___ Auger warning on both sides of rear plenum closure door (GSI/FFI).
___ ___ Auger warning on both sides of access panel, front and rear (GSI).
___ ___ Auger warning on grain discharge. (1 inside and out) (GSI/FFI).
___ ___ Fire danger on rear access door. (1 inside and out) (GSI/FFI).
___ ___ Belt and chain warnings on inside of belt guard (GSI/FFI).
___ ___ Pulley guard has belt and chain warnings installed.
___ ___ Airswitch adjustment decal.
___ ___ Competitor flag installed (2000 series only).
___ ___ GSI decal installed on fan support panel (2000 series only).
___ ___ Error decal inside MCB (2000 series only)
___ ___ Electrical hazard warning installed on fan can lid.
___ ___ Electrical hazard warning beside fan can control box.
___ ___ Warning on meter roll access door (Each Door).
___ ___ Electrical warning decal on Network Fan/Heater box
___ ___ Model # (Single fan, above can in front and above door in rear) (2 fan, below bottom of fan on front panel).

Dryer Pre-fire Checklist

___ Check wiring in control boxes (Jumpers, loose wires, and strands).
___ Check wiring to the main power supply.
___ Check location of 1FI and 2FI wires, make sure 1 is on L1 and 2 is on L3.
___ Capacitor is installed on moisture control light (2000 series only).
___ Check all overloads are set at the rated amperage listed on motors rating plate.
___ Check wiring in fan boxes
___ Check fan overloads are set at the rated amperage listed on the motors rating plate.
___ Check direction of flow on all solenoids and regulators.
___ Perform a Dielectric Strength (Hi-Pot) test in accordance with work instruction QSD-000152.R00. ___ Pass, ___ Fail
___ Perform a Grounding Continuity test in accordance with work instruction QSD-000151.R00. ___ Pass, ___ Fail
___ Apply required power.
___ Install newest version of software into the computer. Version #_____
___ Check switch wiring using feature in program (Vision).
___ Check switch lights for correct colors.
___ Set dip switches on back of display I/O. 2 & 3 on for GSI, 2 on for FFI.
___ Put correct model number of dryer into computer.
___ Check LCD for backlighting.
___ Do all operating lights work?
___ Overload amp range: Load _____, Unload _____, Fan #1 _____, #2 _____, #3 _____, #4 _____, #5 _____, #6 _____.
___ Auxiliary overload amp range: Unload _____ Load _____.
___ Check 12 volt output. _____ Volts.
___ Check that grain and plenum temperature read out is correct.
___ Check the SCR drive resistor for the proper size.
___ Check outside light.
___ Check motor rotation: Unload (CCW) _____Load (CW) _____ Metering rolls (CW) _____ *Load CCW for FF* _____.
___ Ensure Aux contactor engages when load is on
___ Ensure Aux contactor engages when unload is on
___ Check Unload Auger for Excessive Vibration.
___ Metering roll RPM and BPH are displayed and counting.
___ Check 2 speed operation with moisture control on for low speed and off for high speed.
___ Turn pots on main I/O board fully to the right.
___ Set SCR board pots IR to 10 o'clock and CL to 4 o'clock.
___ Adjust minimum voltage for SCR drive to 9 volts @ 0 on pot display for vision set 9 volts @ 50 for (2000 series)
___ Adjust maximum voltage for SCR drive to 180 volts @ 1000 on pot display
___ Check for unload auger clean out time delay after SCR has shut off meter rolls.
___ Check load motor on and off operation with the mercury switch with delay.
___ Check the out of grain timer is working.
___ Check motor running amps: Unload _____amps. Load _____amps.
___ Run fans with airswitch on to make sure it is wired correctly.
___ Check the fan motor(s) running amps: Fan #1 _____ Fan #2 _____Fan #3 _____Fan #4 _____Fan #5 _____Fan #6 _____
___ Check total running amps of the dryer: _____amps.
___ Is there a 5 second time delay between each fan start-up.
___ Check 20 second safety on burners with burner on but with no gas attached. #1 ___ #2 ___ #3 ___ #4 ___ #5 ___ #6 ____

Dryer Burner Operation Checklist

___ Adjust the vaporizer coil (LP units only). Burner #1 _____ #2 _____ #3 _____ #4 _____ #5 _____ #6_____
___ Operate dryer in continuous flow mode.
___ Do all burners light: Burner #1 _____ #2 _____ #3 _____ #4 _____ #5 _____ #6 _____
___ Adjust gas pressure _____ 3 & 10 lbs. for LP, _____ 2 & 6 lbs. for natural gas.
___ Check burner pipe trains for gas leaks: Burner #1 _____ #2 _____ #3 _____ #4 _____ #5 _____ #6 _____
___ Do all burners cycle from high to low: Burner #1 _____ #2 _____ #3 _____ #4 _____ #5 _____ #6 _____
___ Cycle burner six times by using the burner control switch
___ Cycle burner six times by setting the computer to on/off fire
___ Operate dryer in staged batch mode 2 times.
___ Does moisture control hold at the end of the dry cycle?
___ Video dryer with all motors and burners on.
___ Burn all gas out of pipe train.

Safety Shutdown Checklist

___ Housing high limit for fan #1 _____ #2 _____ #3 _____ #4 _____ #5 _____ #6 _____
___ Vapor high limit for each fan (On LP units only) #1 _____ #2 _____ #3 _____ #4 _____ #5 _____ #6 _____
___ Fixed grain high limits: Lower ____ Middle ____ Upper ____.
___ Check discharge switch with unload running to check discharge vibration and ensure proper shut down
___ Remove grain sensor wires to ensure proper wiring
___ Auxiliary user safety.
___ Plenum high limit for each plenum chamber.
___ Motor overload.
___ Make sure all covers are on boxes and housing high limits

Post-Operative Checklist

___ Turn off DIP switch 2 on back of display I/O for both GSI and FFI.
___ Make sure pipe train has inlet plugged.
___ Check time and date.
___ Clear computers shutdown history.
___ Reset total bushels and batches.
___ Double check correct model # is installed in software.
___ Mercury switch is wire tied to dryer.
___ Make sure keys are provided for door.
___ Reset Airswitch DIP switch to off position (series 2000).
___ Reset on off fire Dip switch to off position (series 2000).
___ Put serial number and model number tag on upper control box door.
___ Are the ground rod, belt guard, wet bins, and wet bin hardware in the back of the dryer.
___ Proper manuals in the control box.
___ Key for load motor pulley is included.
___ MET sticker installed.
___ Canadian decals installed. (Canadian Version)
___ Copy of Packing List attached to test sheet.
___ Make sure wild leg is marked with orange tape.
___ Blow out both control boxes.
___ Make sure Hairpins are in lower door latches.
___ Double check dryer options.
___ Make sure rear door is shut.
___ Check door alignment to ensure handle mechanism aligns properly with handle and locks when in the on position.

_____ **Shipping package packing list checked off (Packing list attached to test sheet).**

Inspected by: _____ **Date:** _____

Approved by: _____ **Date:** _____

Shipped by: _____ **Date:** _____

Comments:

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