



Series 2000 Autoflow Fan/Heater and Control Installation Instructions

Installation Manual

PNEG-900

Date: 12-18-12

GSI GROUP



PNEG-900

This equipment shall be installed in accordance with the current INSTALLATION CODES FOR GAS BURNING APPLICANCES AND EQUIPMENT, CAN1_B149.1 and B149.2 or applicable provincial regulations which should be carefully followed in all cases. Authorities having jurisdiction should be consulted before installations are made.

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Safety Guidelines

This manual contains information that is important for you, the owner/operator, to know and understand. This information relates to protecting **personal safety** and **preventing equipment problems**. It is the responsibility of the owner/operator to inform anyone operating or working in the area of this equipment of these safety guidelines. To help you recognize this information, we use the symbols that are defined below. Please read the manual and pay attention to these sections. Failure to read this manual and its safety instructions is a misuse of the equipment and may lead to serious injury or death.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.



DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.



WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.



CAUTION, used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.



NOTICE is used to address practices not related to personal injury.



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.

Series 2000 Autoflow Installation and Operating Instructions

Thank you for choosing a Top Dry Series 2000 Autoflow unit. It is designed to give excellent performance and service for many years.

This manual describes the installation for all standard production Top Dry Series 2000 single fan, multi-fan and 2000 Series Autoflow 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.

Proper Use of Product

This product is intended for the use of drying small grains only. Any other use is a misuse of the product.

This product has sharp edges. These sharp edges may cause serious injury. To avoid injury handle sharp edges with caution and use proper protective clothing and equipment at all times.

Guards are removed for illustration purposes only. All guards must be in place before and during operation.

1. Safety

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.

2. Decals

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

Safety decals should be read and understood by all people in the grain handling area. The rotating blade, fire warning decals and voltage danger decal must be displayed on the fan can. The decal DC-GBC-1A shown [on Page 9](#) should be present on the inside bin door cover of the 2 ring door, 24" porthole door cover and the roof manway cover.

If a decal is damaged or is missing contact:

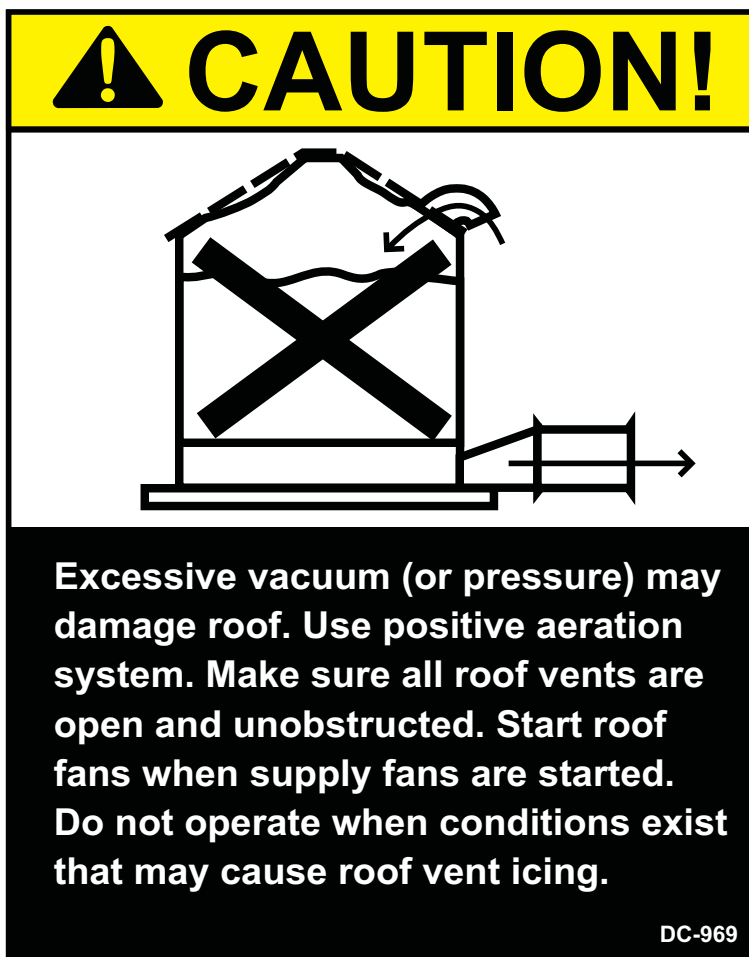
GSI Decals

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

A free replacement will be sent to you.

Roof Damage Warning and Disclaimer

The manufacturer 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. The manufacturer 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.



⚠ DANGER



HIGH VOLTAGE.

- Will cause serious injury or death.
- Lockout power before servicing.

DC-1224

DC-1224

⚠ DANGER



Rotating flighting will kill or dismember.



Flowing material will trap and suffocate.



Crusted material will collapse and suffocate.

**Keep clear of all augers.
DO NOT ENTER this bin!**

If you must enter the bin:

1. Shut off and lock out all power.
2. Use a safety harness and safety line.
3. Station another person outside the bin.
4. Avoid the center of the bin.
5. Wear proper breathing equipment or respirator.

Failure to heed these warnings will result in serious injury or death.

DC-GBC-1A

DC-GBC-1A

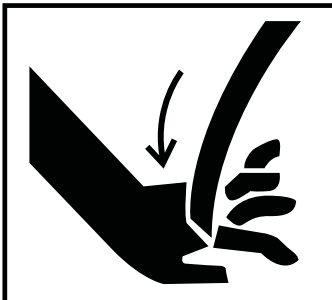


⚠ WARNING

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

DC-1227

DC-1227



⚠ WARNING

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

DC-1225

DC-1225

3. Installation

Fan/Heater Mounting

NOTE: Do not install this control panel near any transformers or any other device that will produce an electro magnetic field.

1. Inspect the fan platform for proper installation per instructions in the Top Dry erection manual.
2. Raise the Top Dry fan/heater units to the platform. Use the [Table below](#) to determine the height of the platform from the base of the Top Dry unit.
3. Mount the Top Dry fan/heater units to the bin entrance sheets. Fan legs should set on the platform.

Top Dry Bin Eave Height

# of Rings	Eave Height
5	18'-5"
6	22'-1"
7	25'-9"
8	29'-5"
9	33'-1"
10	36'-9"
11	40'-5"

Autoflow Control Box Mounting

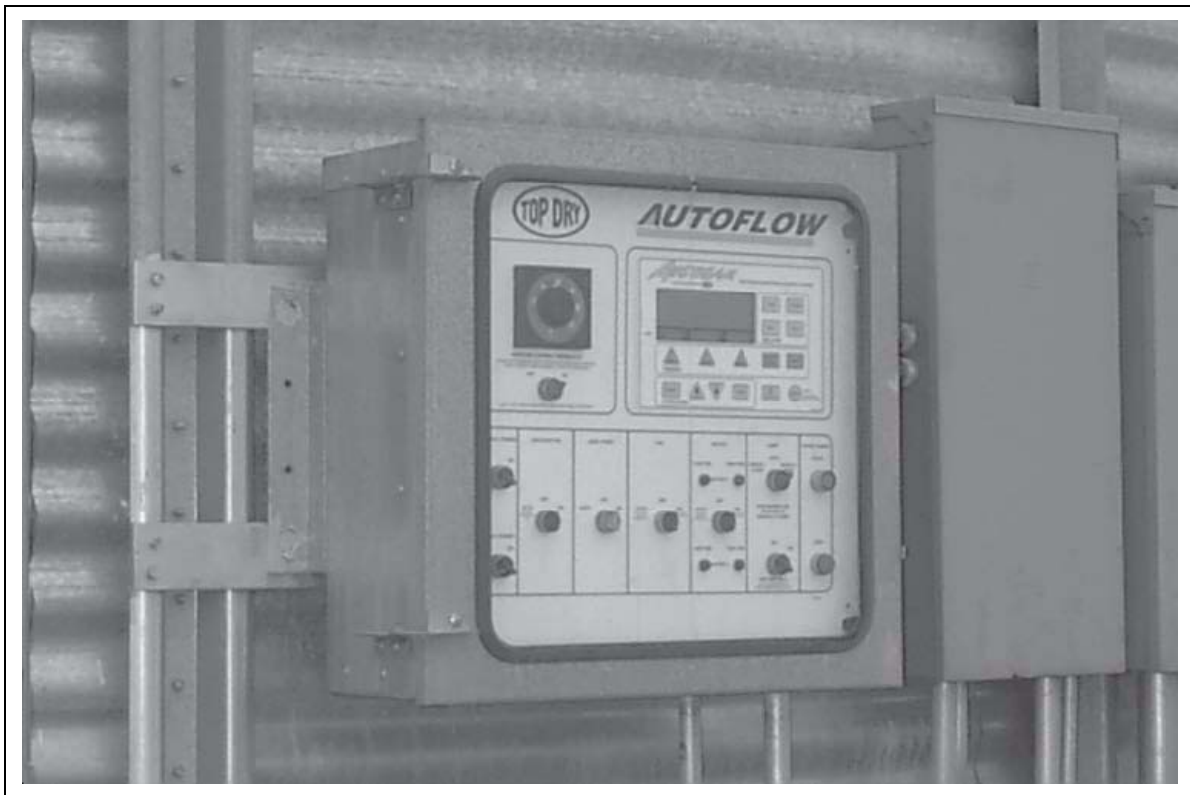


Figure 3A Autoflow Control Box Mounted on Bin

3. Installation

1. The Autoflow control box should be mounted at eye-level. Make sure to mount the Autoflow control box so that the fan/heater unit(s) are in view.
2. Keep in mind that wire will be used to interconnect the Autoflow control box with the fan/heater unit(s), fill system control box, actuator and all rotary switches.
3. Use the hole pattern in [Figure 3C on Page 12](#) to drill holes for mounting the Autoflow control box.

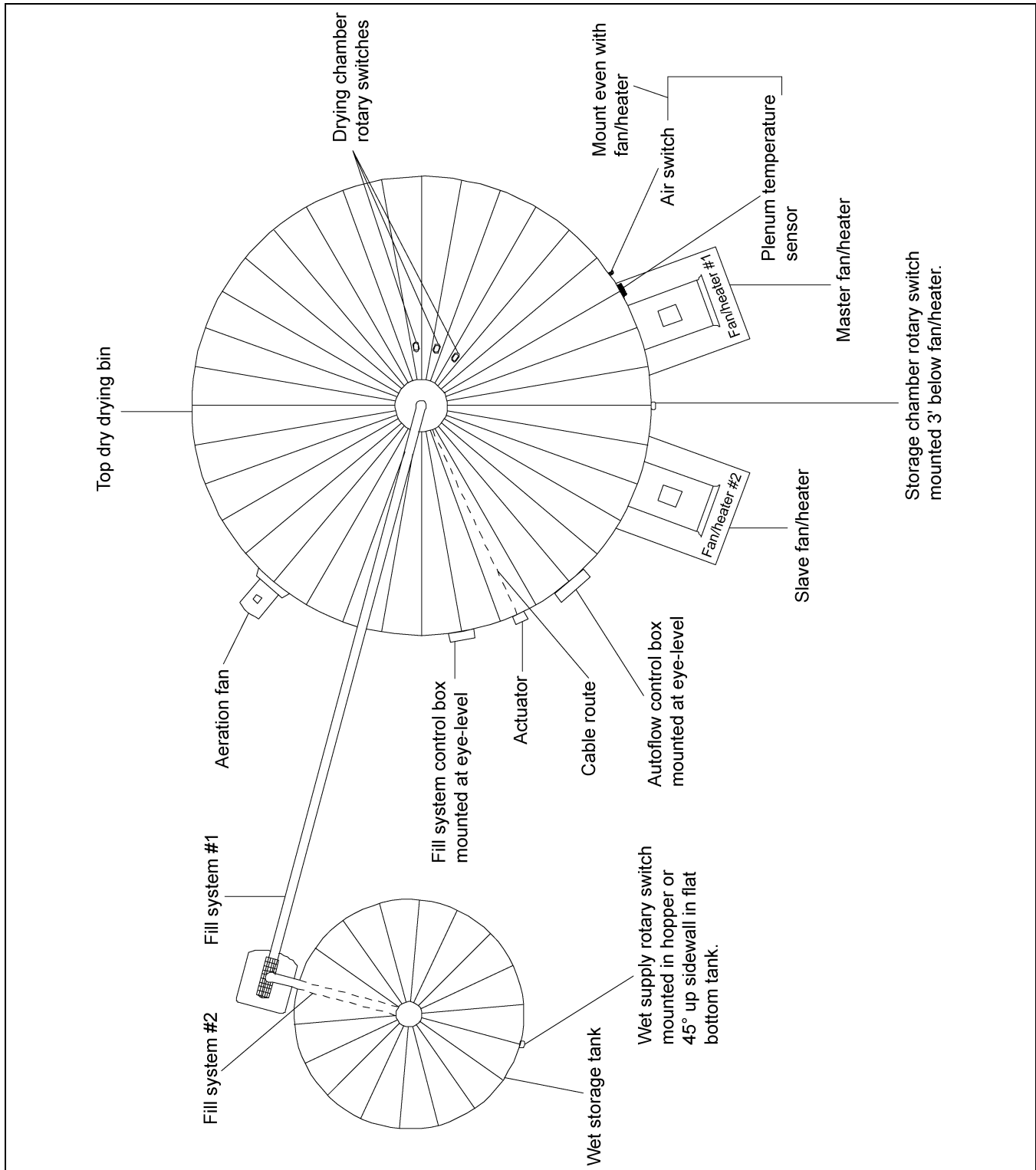


Figure 3B Component Placement

3. Installation

Series 2000 Autoflow Control Box Bolt Pattern

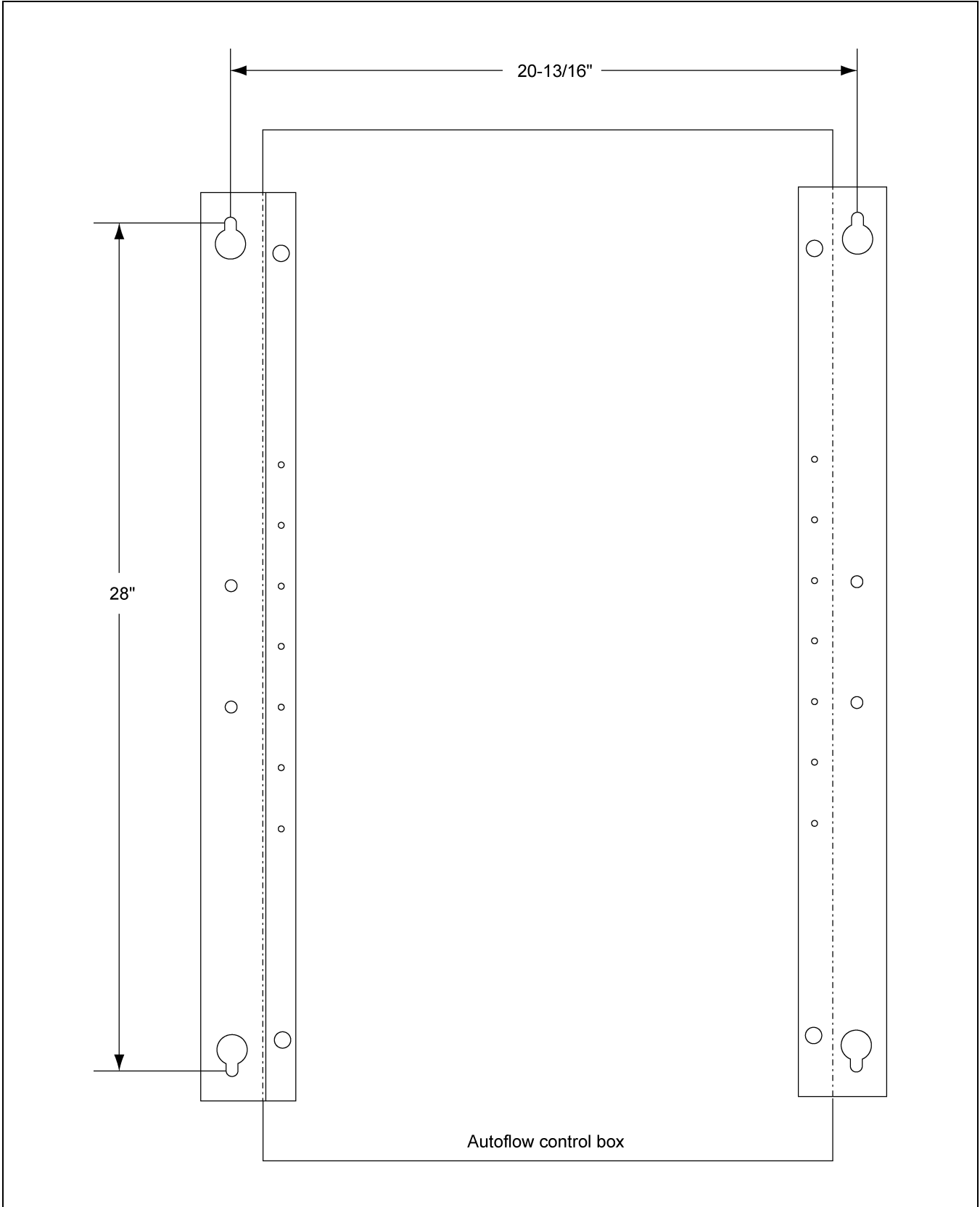


Figure 3C Illustration of the bolt pattern for the autoflow control box.

Control Box Mounting

Fill System Control Box Mounting

1. The fill system control box should be mounted at eye-level. Make sure to install the fill system control box so that the fill system(s) and aeration fan are in view.
2. Keep in mind that wire will be used to interconnect the fill system control box with the Autoflow control box; and, that power wires will have to be run from the entrance panel to the fill system control box to power the fill system and aeration fan motors, which will also run from the fill system control box.
3. Use the pattern in [Figure 3E on Page 14](#) to drill holes for the fill system control box.

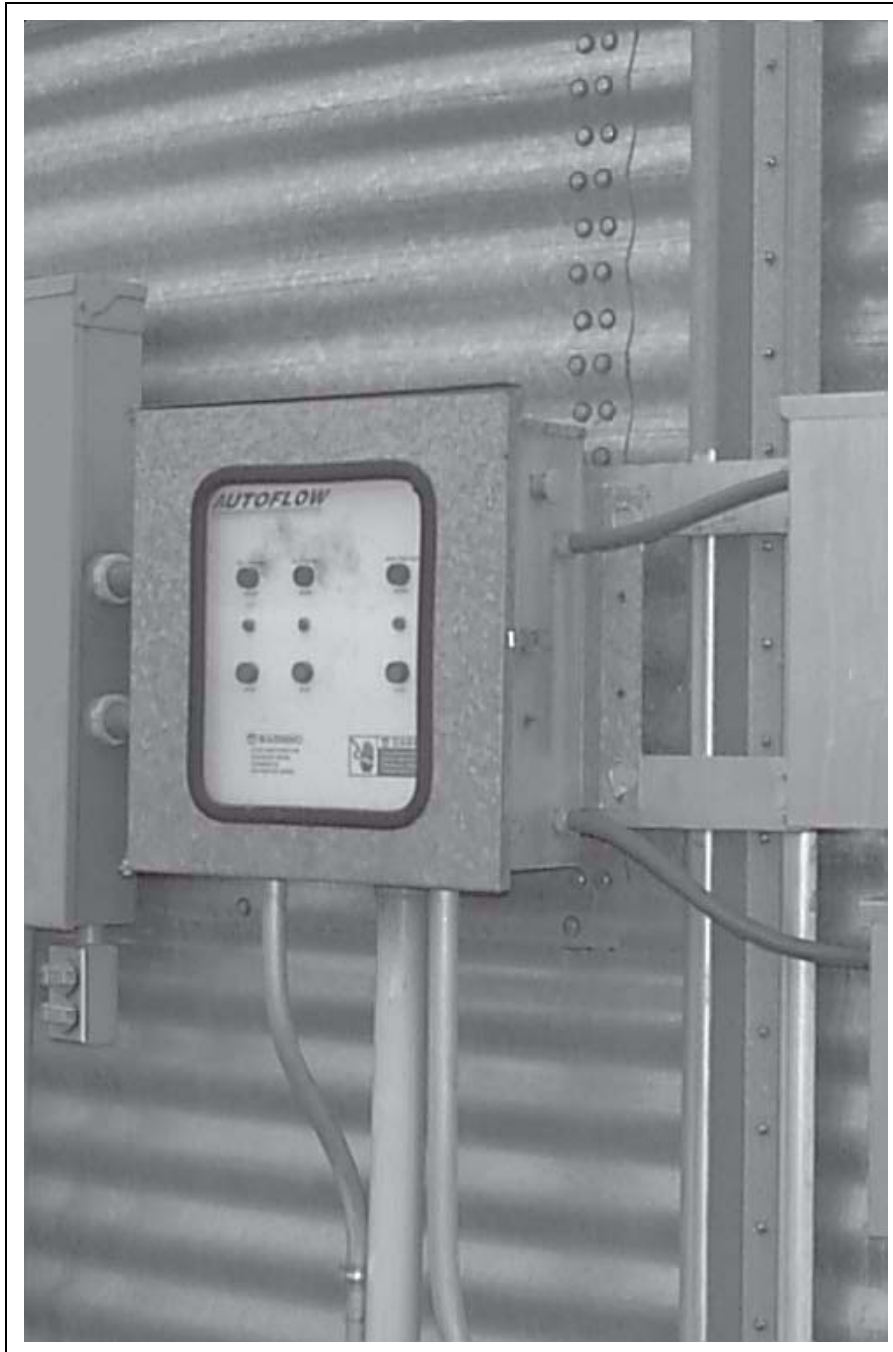


Figure 3D *Fill System Control Box Mounted to Bin*

3. Installation

Fill System Control Box Bolt Pattern

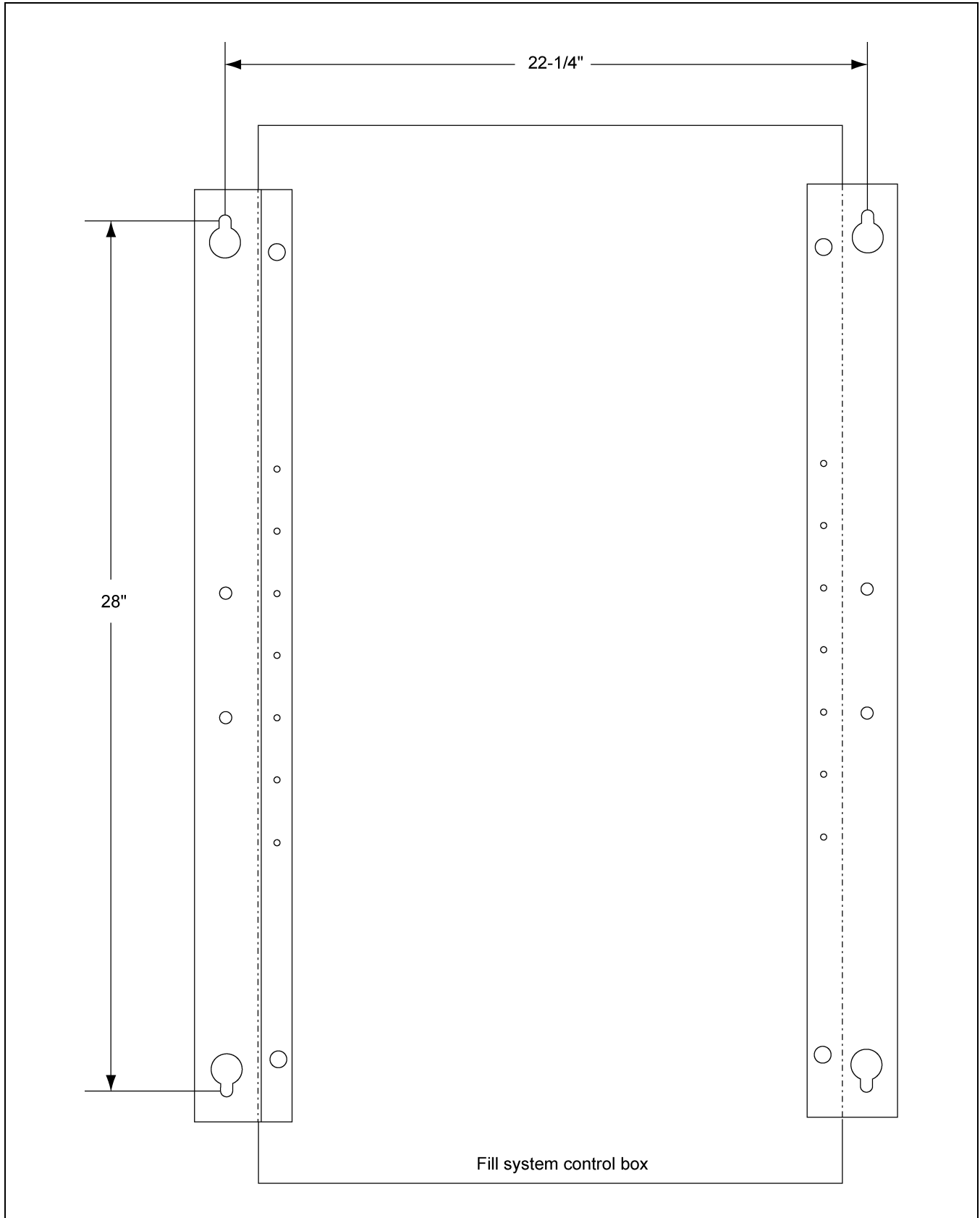


Figure 3E Illustration of the bolt pattern for the fill system control box.

Actuator Control Box Mounting

1. Mark the third sidewall ring from the ground to indicate the cable path if dump chutes and cable are already installed.
2. Make sure that all dump chutes and chains are EVENLY adjusted so that when one chute is level the others are level as well.
3. Keep in mind that wire will be used to interconnect the actuator control box with the Autoflow control box; and, that a 110V power supply will need to run from the entrance panel to the actuator control box to power the 24V DC battery charger.
4. Use the pattern in *Figure 3G on Page 16* to drill holes for the actuator control box.
5. If the horizontal seam bolts are within 1" horizontally of the hole pattern shown, existing holes may be used to attach the actuator.
6. Use four (4) 5/16" x 1-1/4" bin bolts and washers with bolt heads to the inside of the bin.
7. Do not attach the dump chute cable to the actuator at this time. The cable should not be installed until after the actuator unit is completely wired and tested.

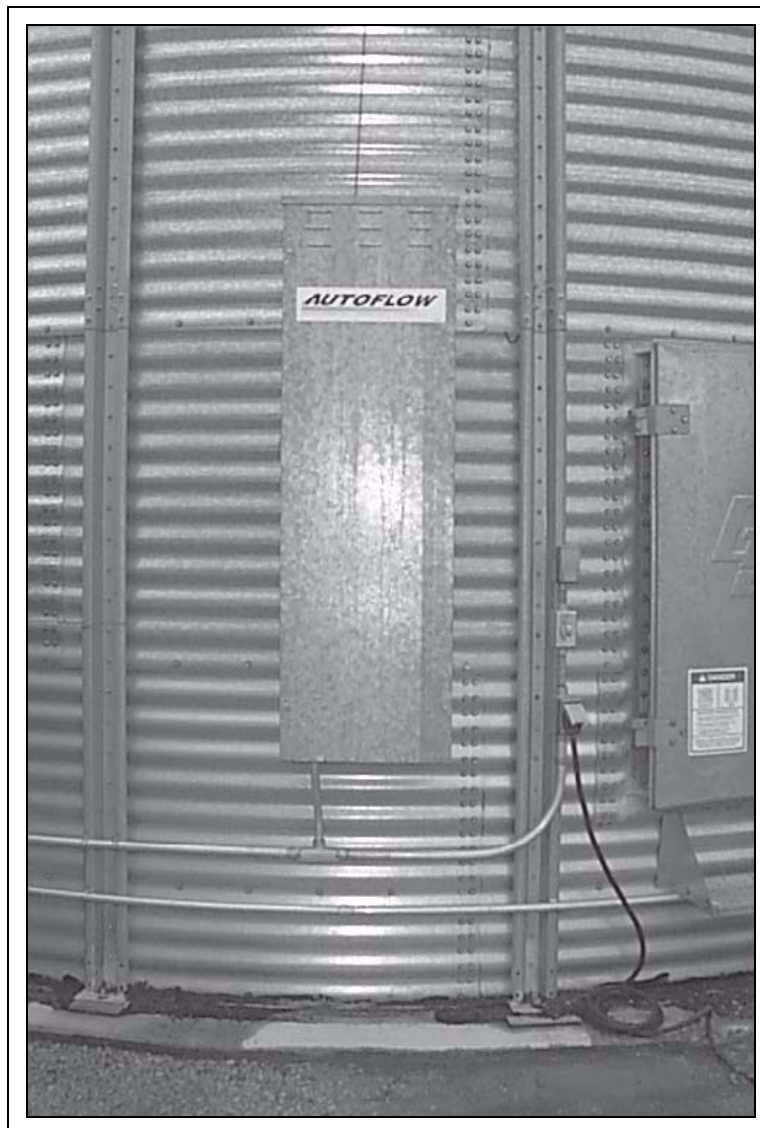


Figure 3F Actuator Control Box Mounted to Bin

3. Installation

Actuator Control Box Mounting (Continued)

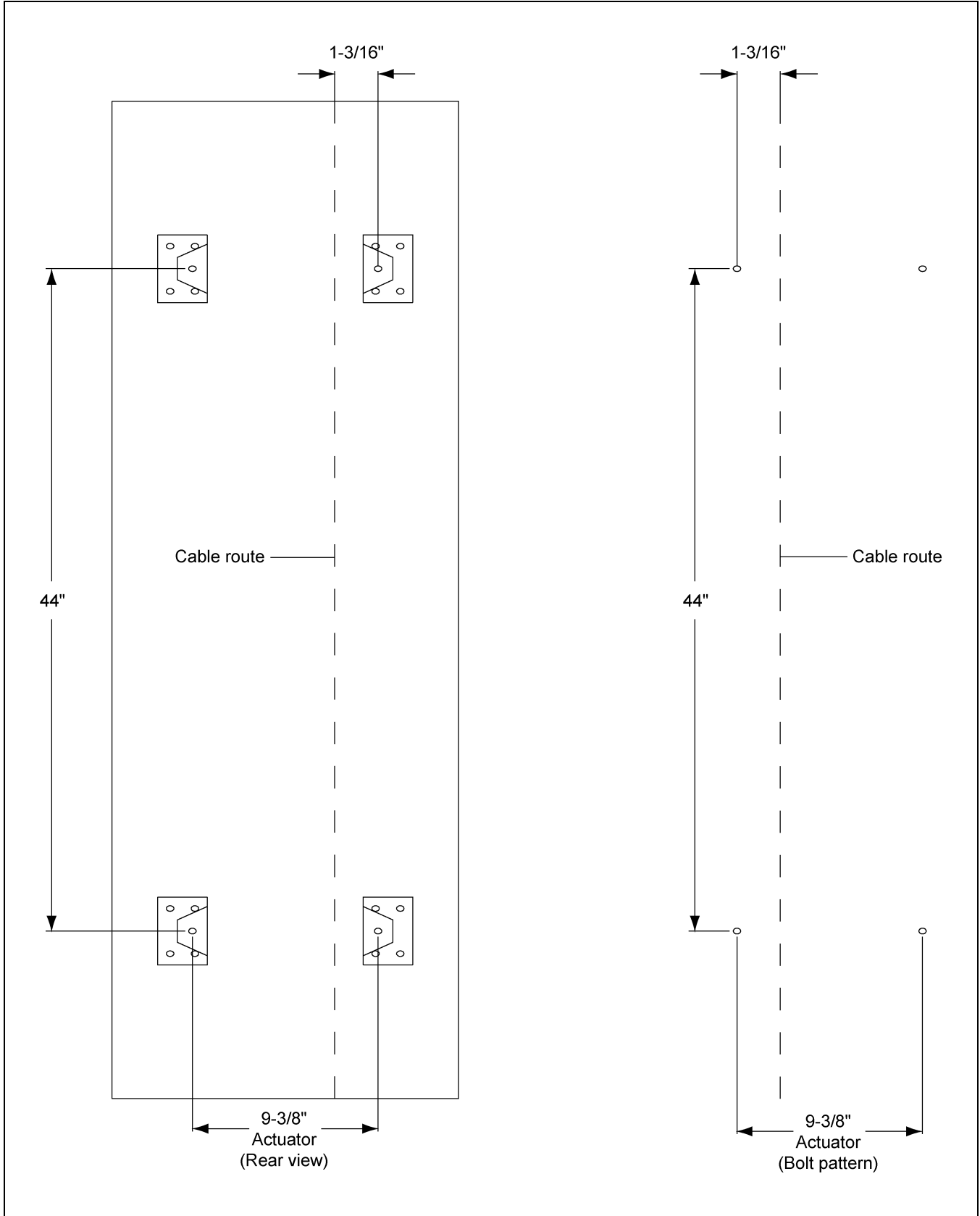


Figure 3G Bolt Pattern to Drill Holes for the Actuator Control Box

Multi-Grain Temperature Sensor

1. Remove the two (2) wires attached to the grain temperature sensor connected to terminal #22 and terminal #23 in the fan control box.
2. Mount the four (4) grain temperature sensor brackets evenly around the drying chamber on outside leveling band posts. *(See Figure 3I on Page 18.)*
3. Mount the brackets with bin bolts so that the sensor is 8-1/2" above the floor sheet rib for Auto drying mode and 10-1/2" above the floor sheet rib for Batch drying mode. For AUTO drying, the bottom hole in the mounting bracket should align with the third hole from the bottom of the leveling band post. For BATCH drying, the bottom hole in the mounting bracket should align with the fourth hole from the bottom of the leveling band post.
4. Wire tie the cords so they feed up the leveling band post and across the top leveling band.
5. Route the cords through the space between the roof and the top sidewall sheet. There should be enough on all temperature sensor brackets to exit the drying chamber at the same place.
6. Route the cords into the junction box after the junction box has been mounted to the bin.
7. Wire the four (4) temperature sensors as shown in *Figure 3H* and *on Page 19*.

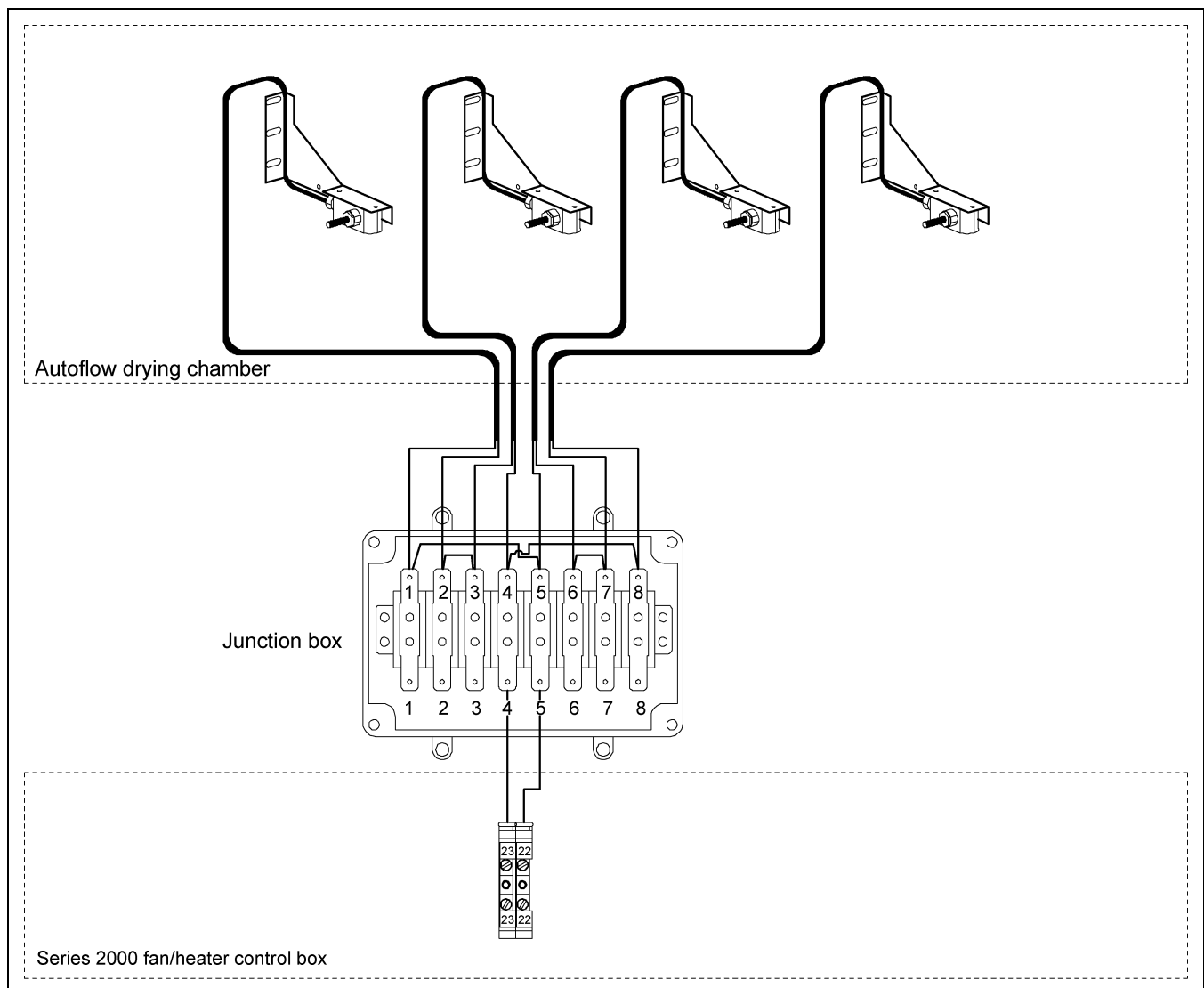


Figure 3H Illustration of the grain temperature sensor interconnection.

3. Installation

Grain Temperature Sensor Mounted to Leveling Band Post

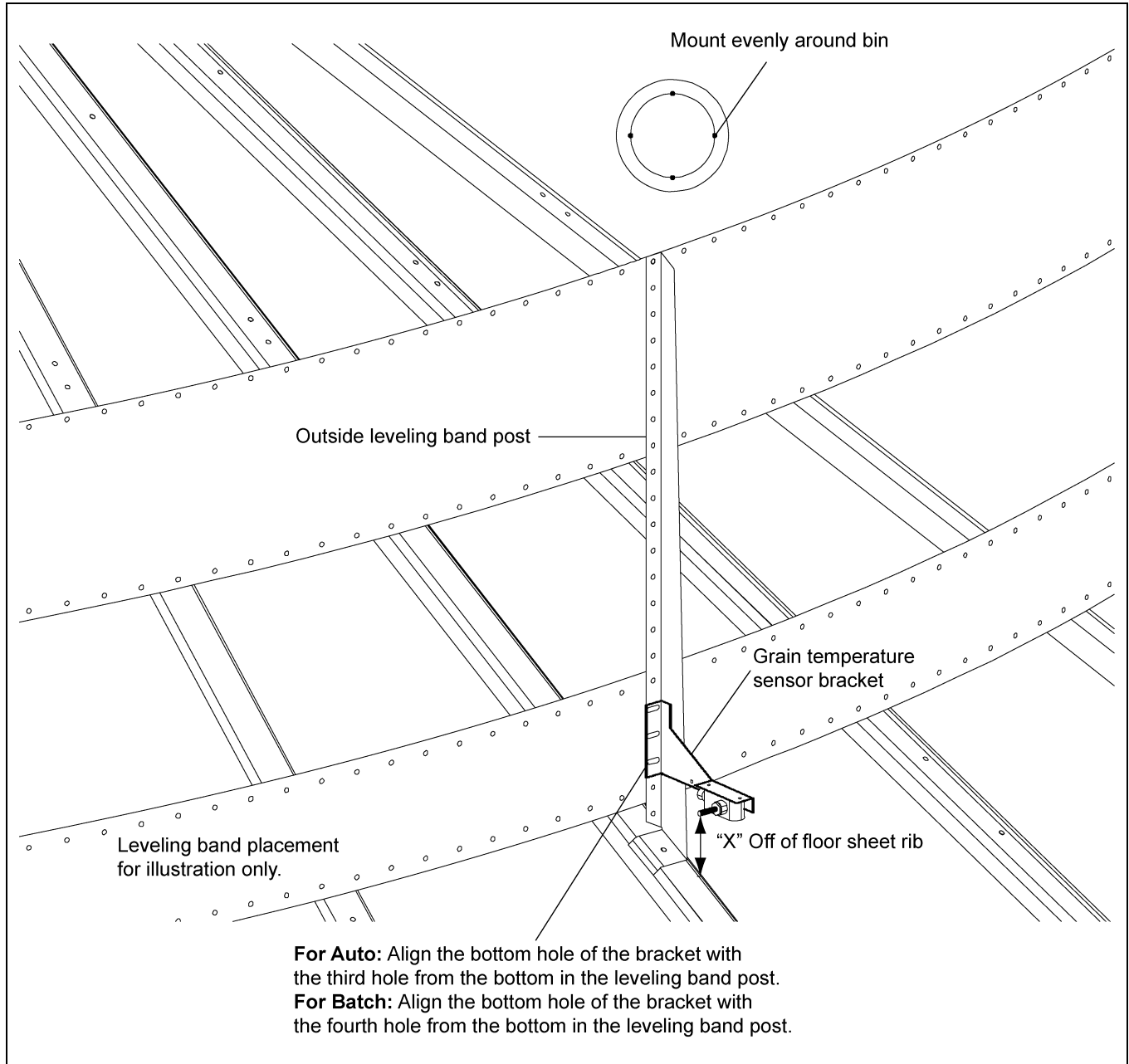


Figure 31 Illustration of grain temperature sensor mounted on outside leveling band post.

Height of Sensor Bracket	
Drying Mode	Height of "X"
Auto	8-1/2"
Batch	10-1/2"

Close-Up Detail of Grain Temperature Sensor Wiring

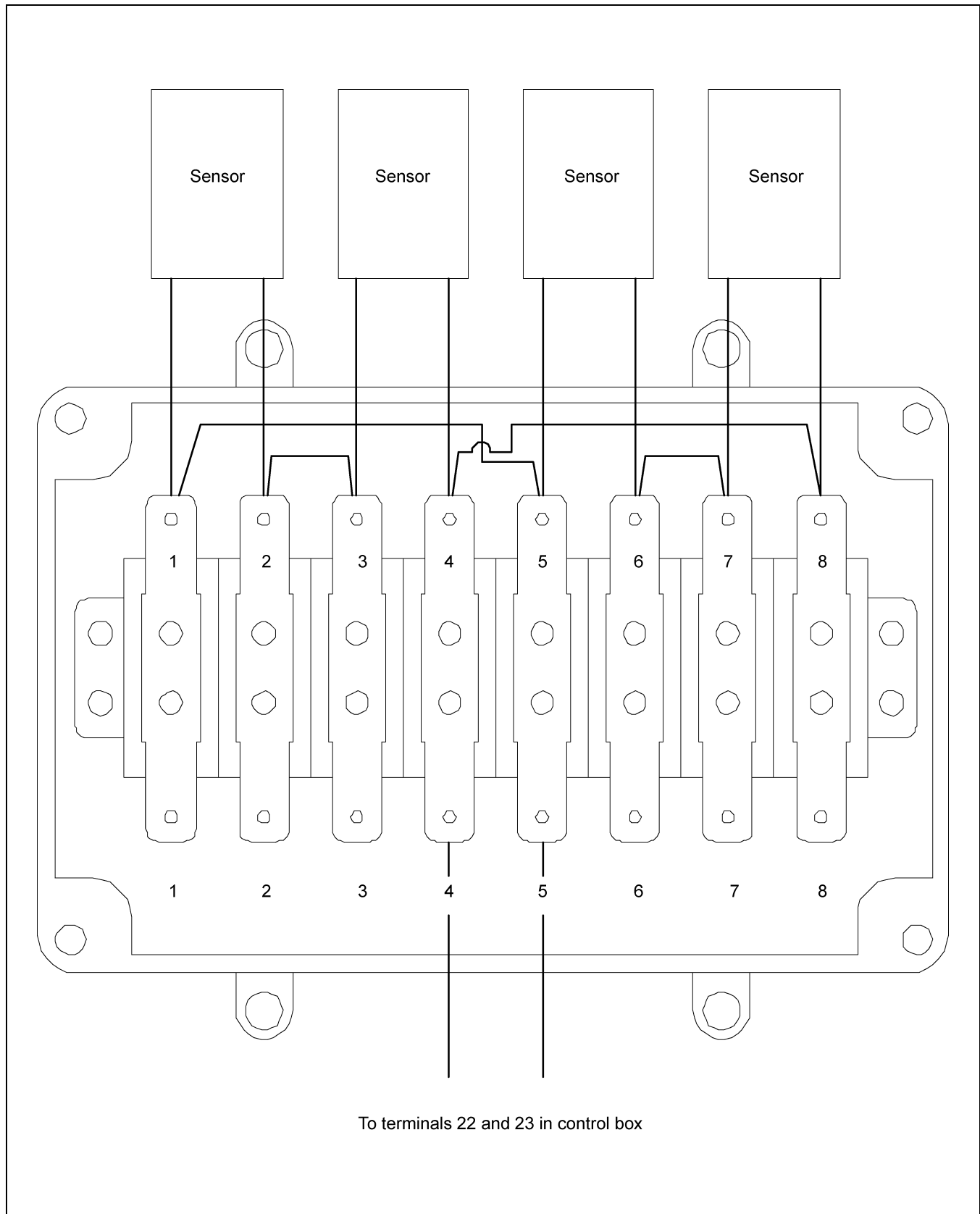


Figure 3J

3. Installation

Plenum Temperature Sensor

The plenum temperature sensor is the small grey PVC junction box attached by a cord to the fan/heater control box on the master fan/heater unit.

1. On either side of the fan/heater, drill one 3/4" hole even with the fan/heater unit in a valley on the bin sidewall.
2. Insert the probe through the 3/4" hole.
3. Position the housing so the cord exits the housing horizontally and the tabs fall on the sidewall peaks.
4. Use two (2) self-drilling screws to mount the housing to the bin sidewall.
5. Caulk between the housing and the sidewall to seal the gaps.

IMPORTANT: *If the top dry is a 2 fan unit, do not mount the plenum temperature sensor between the 2 fan/heater units.*



Figure 3K *Plenum Temperature Sensor on the Bin Sidewall*

Plenum High-Limit Installation

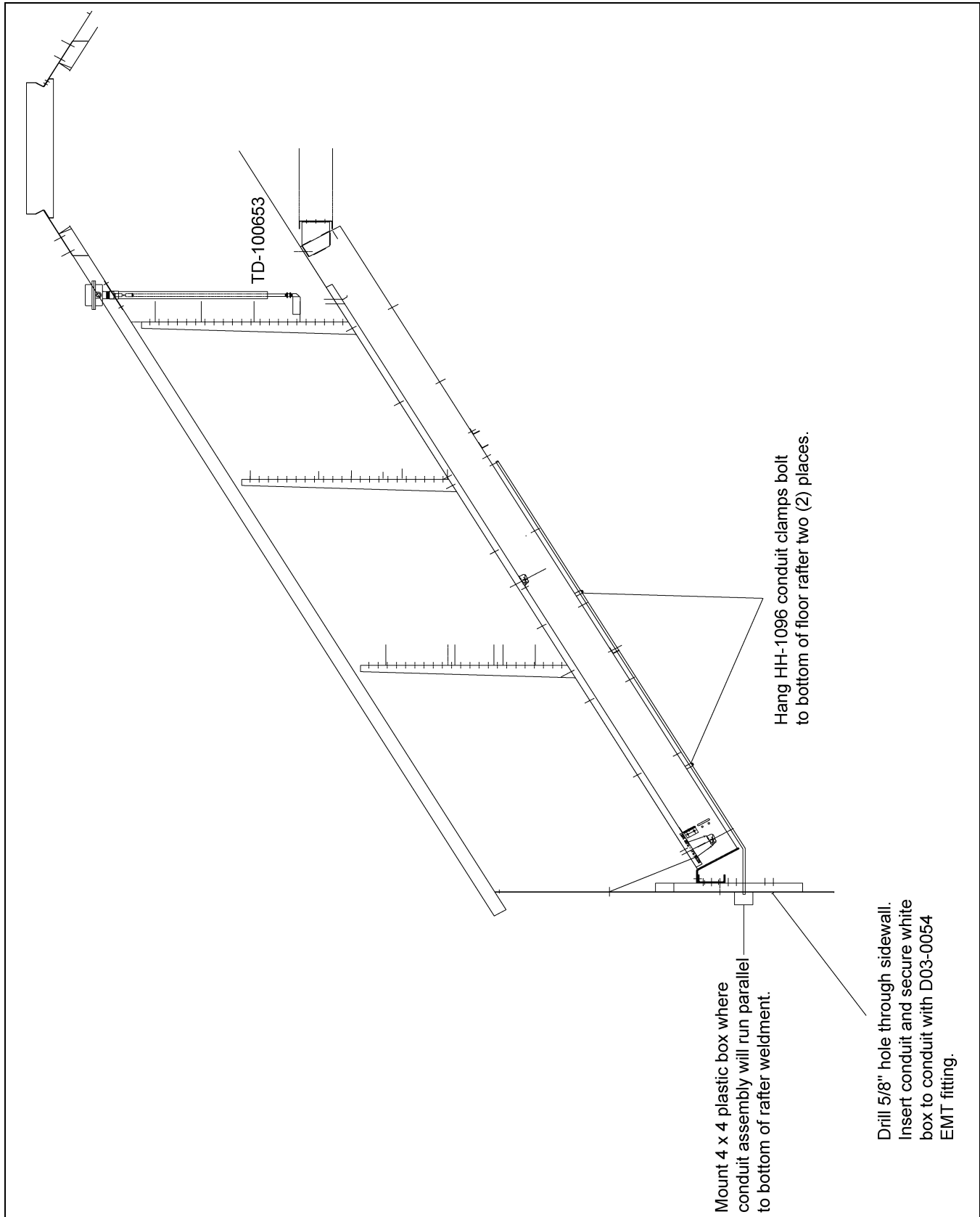


Figure 3L 30' Top Dry Layout Plenum High-Limit

3. Installation

Top Dry Plenum High-Limit Installation

1. Assemble two (2) pieces of conduit together with coupler.
2. Mount conduit clamps to conduit assembly.
3. Locate conduit assembly on the bottom of a rafter at least 2' to one side of the fan entrance. Do not install between 2 fan entrances.
4. Mark bin wall where conduit will pass through and drill a hole just large enough to allow the conduit to pass through. Seal hole with caulking when complete.
5. Install white PVC box assembly on outside of bin wall.
6. Insert 10' capillary into conduit assembly.
7. Connect SJO cord to high-limit and connect wires to terminal #20 and terminal #21 on the master fan terminal strip. These terminals are J7-08 and J7-03.

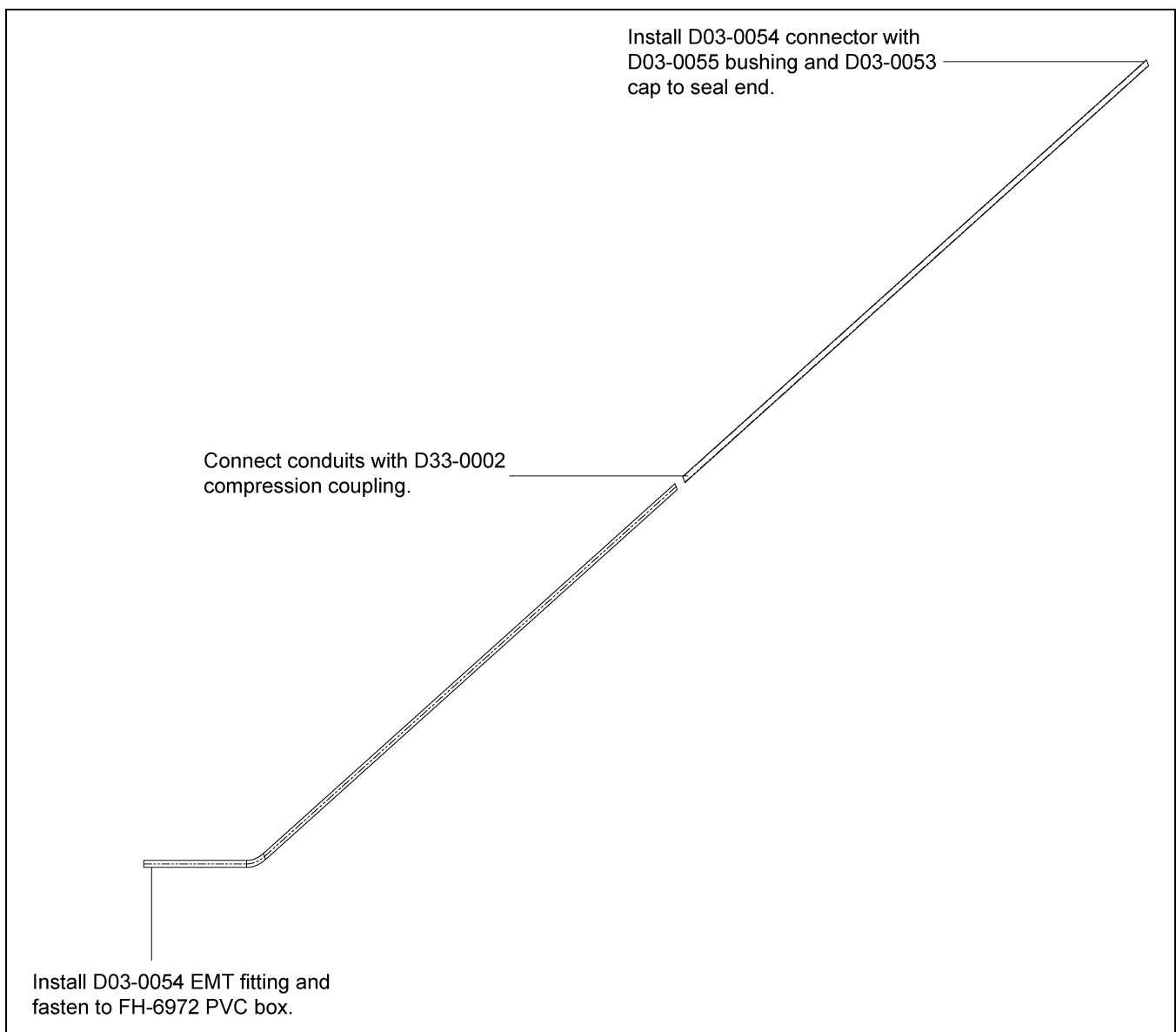


Figure 3M

Wet Supply Rotary Switch

1. Drill a 2" diameter hole through the hopper bottom. If a flat bottom bin is being used for a wet storage tank the Wet Supply Rotary switch would be mounted 45° up the sidewall from the center of the bin. Example: If the wet storage bin is 18' in diameter then the Wet Supply Rotary switch would be mounted 9' up the sidewall.
2. If the bin is 2.66" corrugation, the hole should be centered on an outside hill.
3. If the bin is 4.00" corrugation, the hole should be centered on an outside valley.
4. Use the mounting plate as a pattern and drill four (4) 3/8" holes through the sidewall at the switch location so the plate can be bolted to the bin.
5. Add foam weather strip around the top and side of the mounting plate.
6. Caulk the underside of the mounting plate, on all sides of the 2" hole and where the plate meets the bin.
7. Bolt the mounting plate to the sidewall.
8. Attach the flex coupling to the rotary switch power pack using a roll pin.
9. Attach the 1 vane paddle to the flex coupling as shown in [Figure 30 on Page 24](#).
10. Apply teflon tape or pipe sealant (not included) to the rotary switch power pack threads and thread the rotary switch power pack into the mounting plate coupling.
11. Make sure that the conduit hole is facing down or is horizontal.

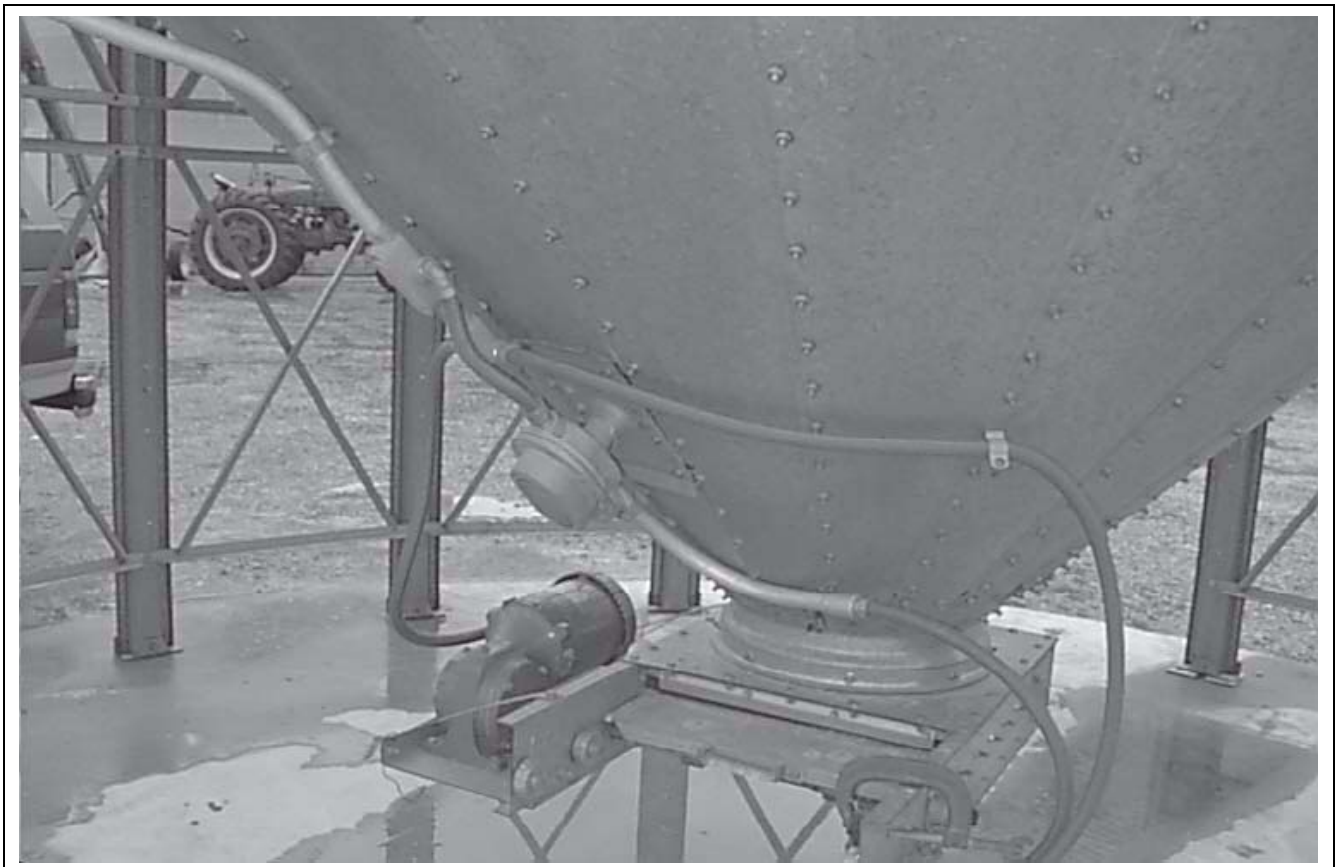


Figure 3N Wet Supply Rotary Switch Mounted on Wet Supply Tank

3. Installation

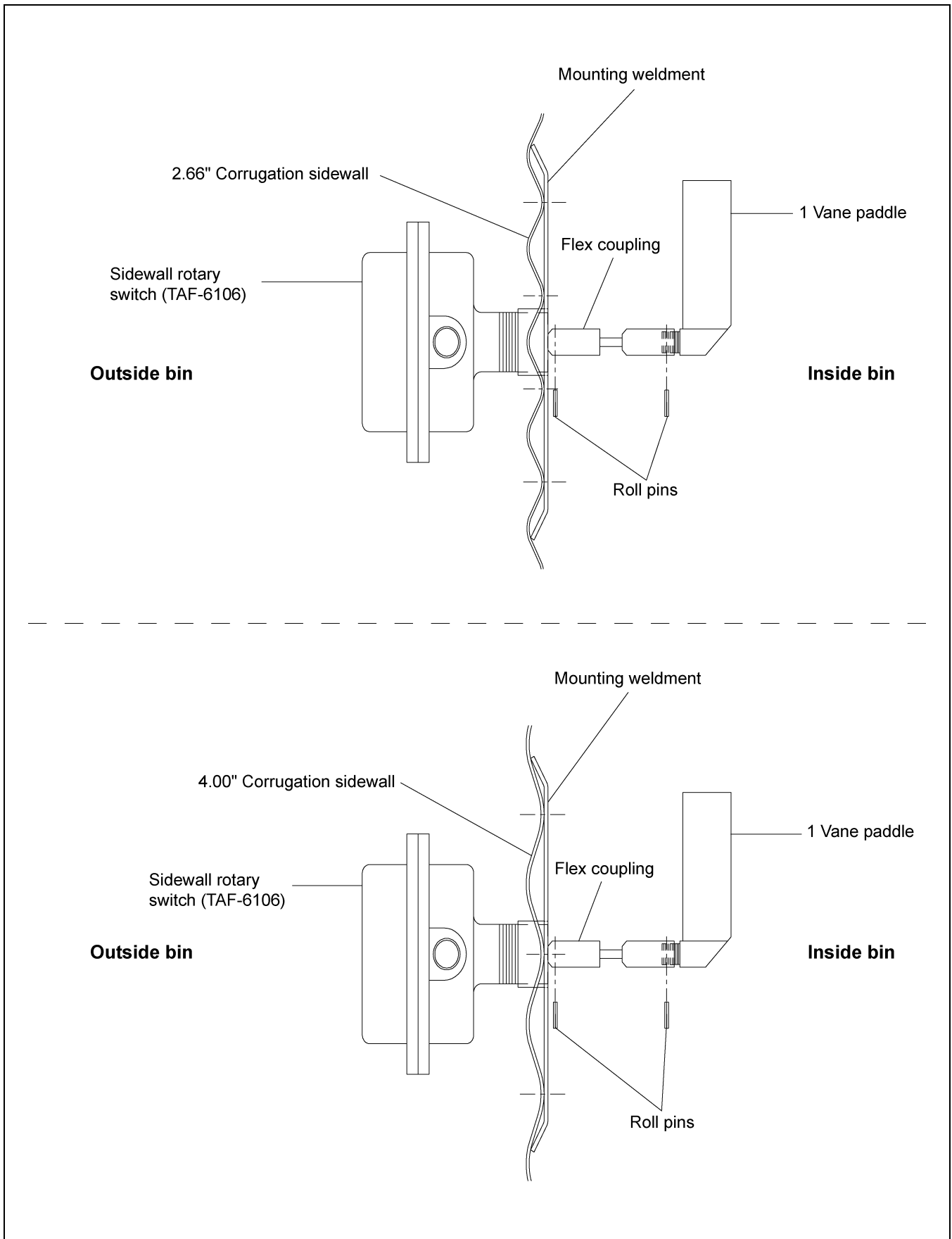


Figure 30

Storage Chamber High-Limit Rotary Switch Installation

1. Drill a 2" diameter hole through the sidewall 3' below the fan/heater.
2. If the bin is 2.66" corrugation, the hole should be centered on an outside hill.
3. If the bin is 4.00" corrugation, the hole should be centered on an outside valley.
4. Use the mounting plate as a pattern and drill four (4) 3/8" holes through the sidewall at the switch location so the plate can be bolted to the bin.
5. Add foam weather strip around the top and side of the mounting plate.
6. Caulk the underside of the mounting plate, on all sides of the 2" hole and where the plate meets the bin.
7. Bolt the mounting plate to the sidewall.
8. Attach the flex coupling to the rotary switch power pack using a roll pin.
9. Attach the 1 vane paddle to the flex coupling as shown in [Figure 3Q on Page 26](#).
10. Apply teflon tape or pipe sealant (not included) to the rotary switch power pack threads and thread the rotary switch power pack into the mounting plate coupling.
11. Make sure that the conduit hole is facing down or is horizontal.



Figure 3P Storage Chamber Rotary Switch

3. Installation

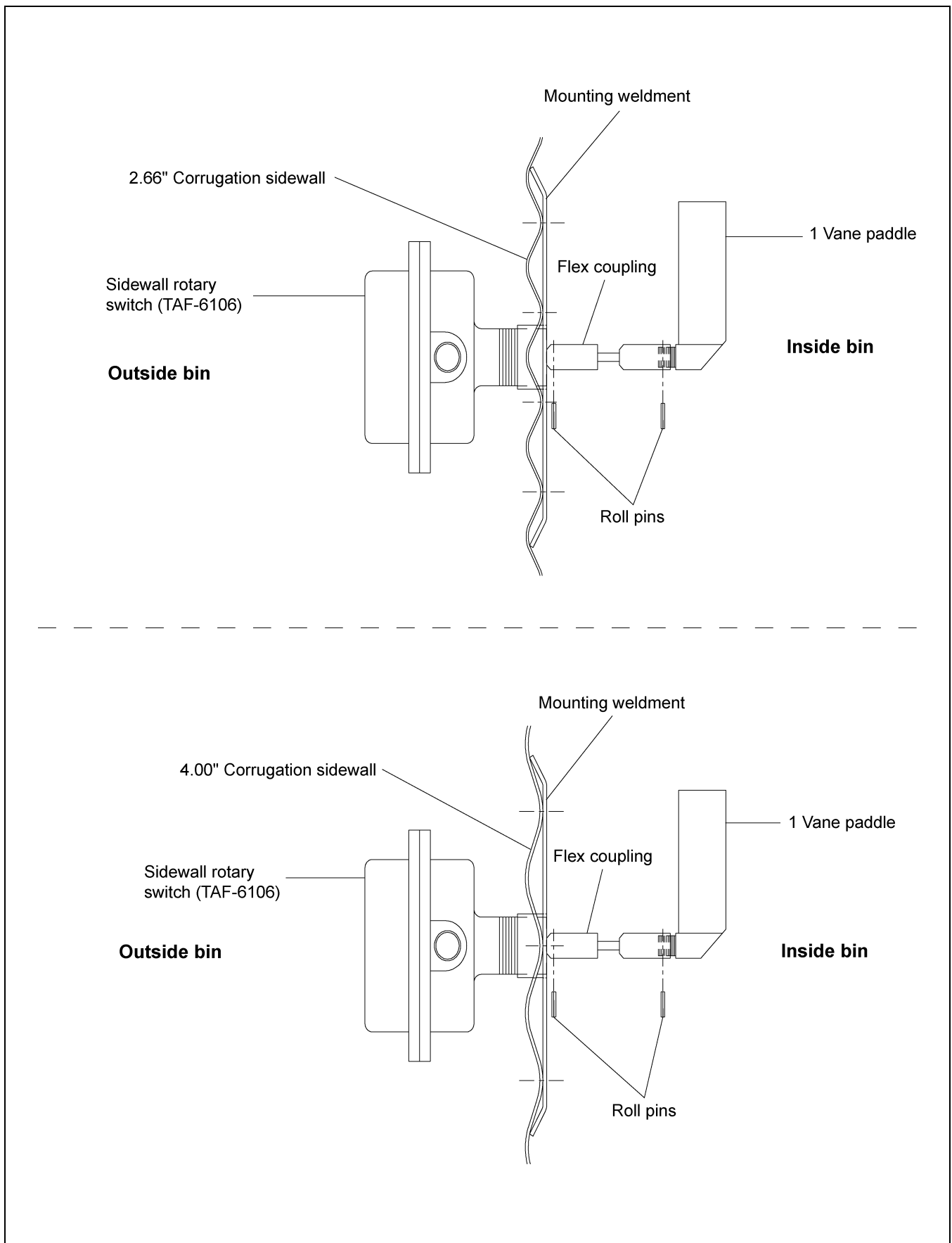


Figure 3Q

Drying Chamber Rotary Switches Mounted in Bin Roof

The three (3) Drying Chamber rotary switches are used by the Series 2000 Autoflow to monitor the location of grain in the drying chamber. The rotary switch with the shortest shaft extension is the Drying Chamber Overflow Rotary switch. It is used as a safety in the event the Chamber High-Level Rotary switch fails. The rotary switch with the longest extension is the Drying Chamber Low-Level Rotary switch. It is used to inform the computer when the peak has been covered with grain so the drying process can begin; and, will shut down if the drying chamber empties unexpectedly. The third rotary switch is the Drying Chamber High-Level Rotary switch. It is used to inform the dryer when the drying chamber is full so loading can stop.

When mounting the Drying Chamber Rotary switches some foresight is needed. The Drying Chamber Rotary switches should be located in close proximity to one another to lessen the amount of conduit and wiring required. The rotary switches should also be mounted so that they are located in an area of the drying chamber that fills evenly with the rest of the drying chamber. The component placement [on Page 11](#) shows the placement of the Drying Chamber Rotary switches in relation to the fill system #1 transport auger/downspout.

The rotary switches should NOT be located in a part of the drying chamber that fills unevenly with the rest of the drying chamber. If the area of the drying chamber where the rotary switches are located fills faster than the rest of the drying chamber the drying chamber will not fill to capacity and uneven drying will result. If the area of the drying chamber where the rotary switches are located fills slower than the rest of the drying chamber an overflow situation may occur.

It is very critical that the drying chamber fill evenly and that the grain falls from fill system #1 directly onto the perforated cone in the drying chamber.

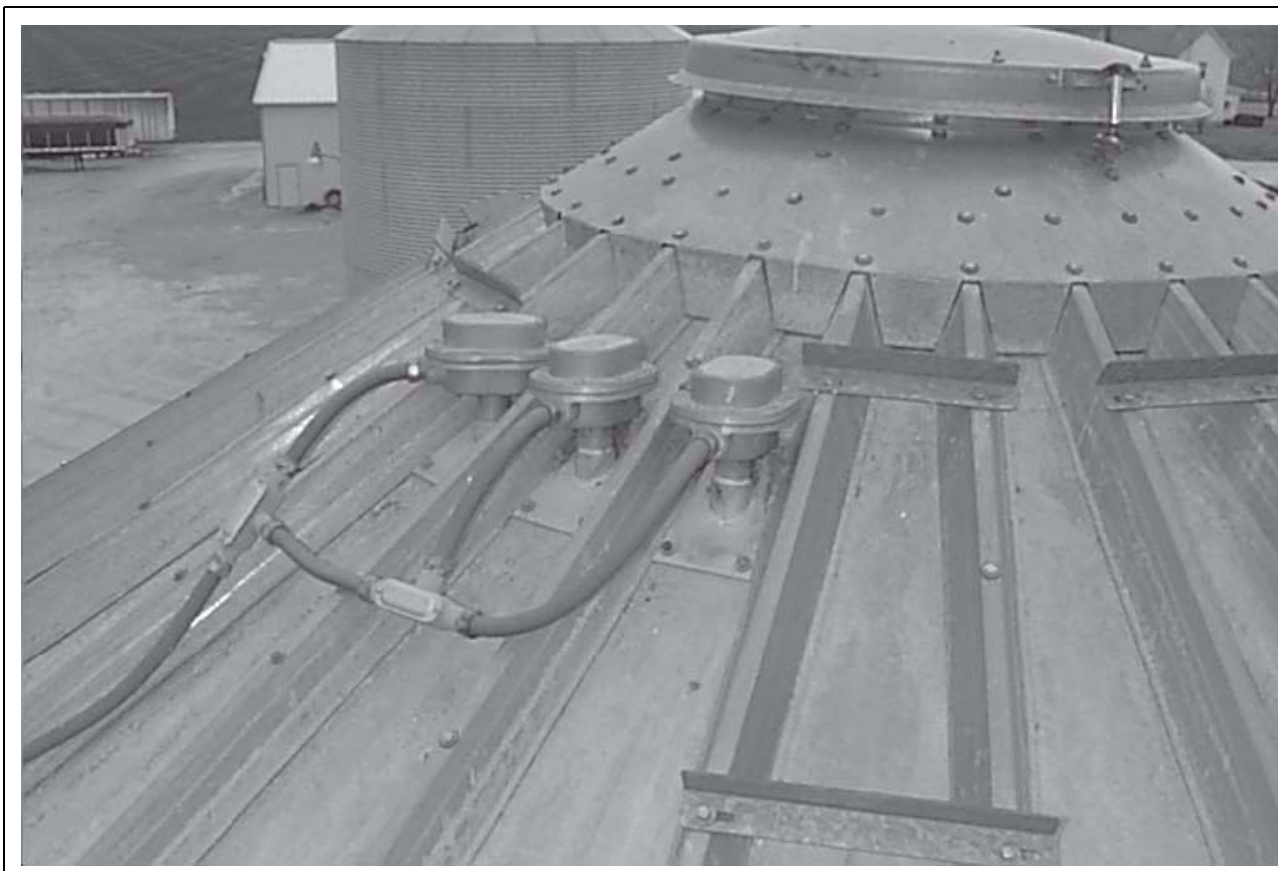


Figure 3R

3. Installation

Drying Chamber Low-Level Rotary Switch Installation

1. Drill a 2" diameter hole through the roof panel at the location shown in [Figure 3S](#). See component placement [on Page 11](#) for proper placement in relation to fill auger.
2. Use the mounting plate as a pattern and drill four (4) 3/8" holes through the roof panel at the switch location so the plate can be bolted to the roof.
3. Attach the flex coupling to the rotary switch power pack using a roll pin.
4. Apply teflon tape or pipe sealant (not included) to the rotary switch power pack threads and thread the rotary switch power pack into the mounting plate coupling.
5. Make sure that the conduit hole is at right angles with the roof panel ribs or facing towards the eave.
6. Caulk the underside of the mounting plate and on all sides of the 2" hole.
7. Bolt the assembly to the roof panel.
8. Attach the shaft extension according to [Figure 3T on Page 29](#).
9. Apply teflon tape or pipe sealant (not included) to the shaft guard.
10. Thread to underneath side of mounting plate.
11. Add the 1/4" drilled coupling to the shaft extension using the cotter pin.
12. Attach the 1 vane paddle to the flex coupling as shown in [Figure 3T on Page 29](#).

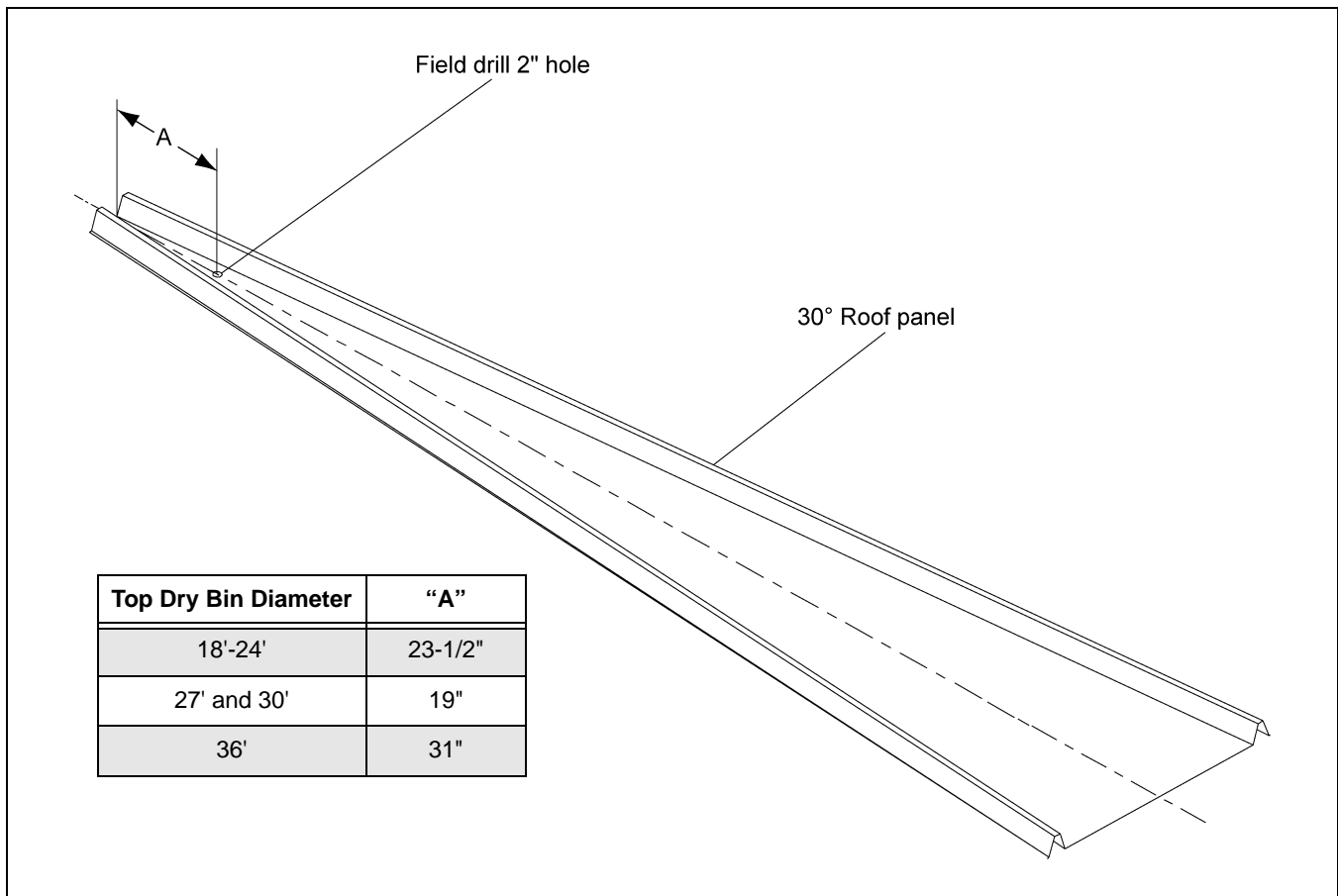


Figure 3S

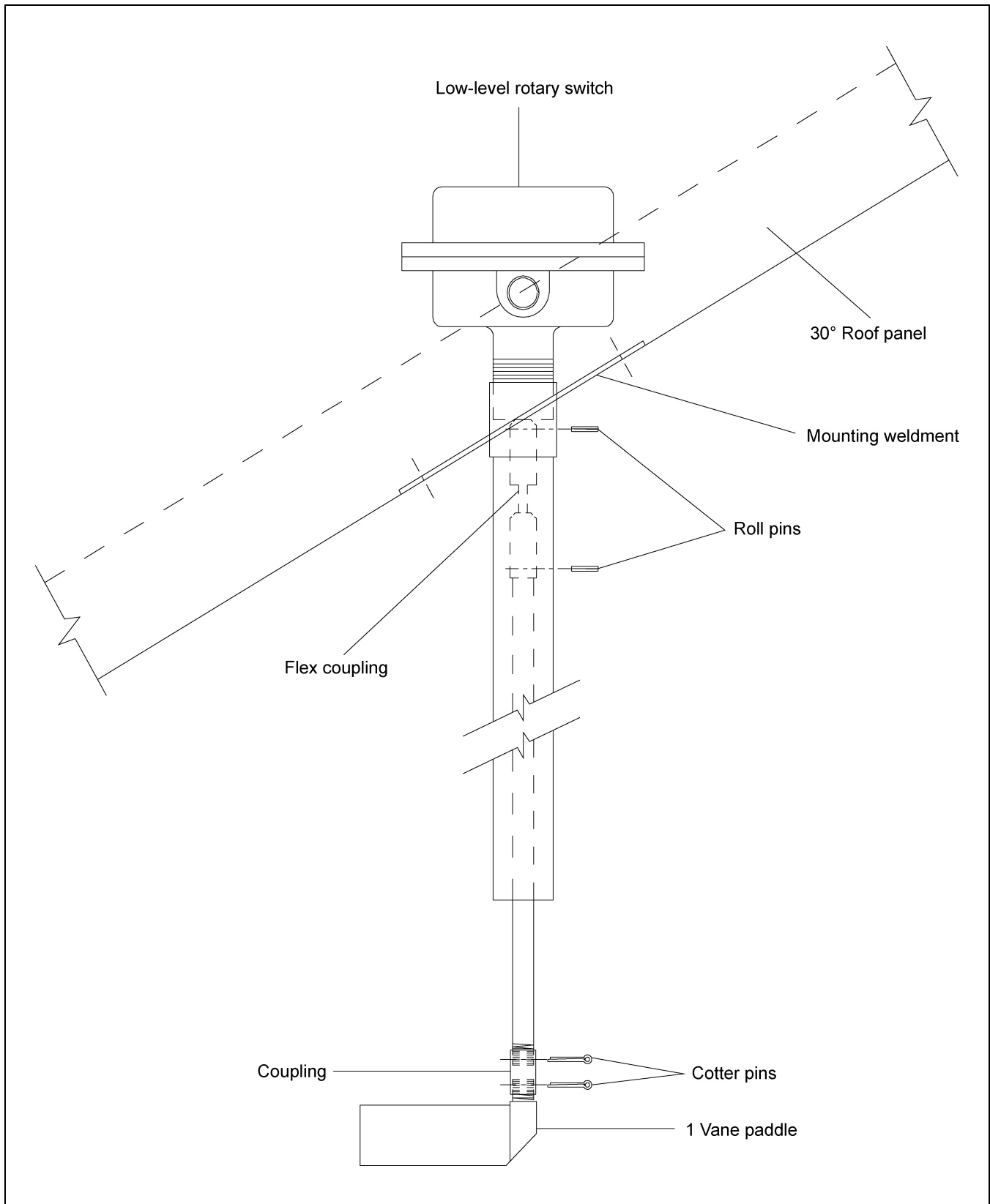


Figure 3T

3. Installation

Drying Chamber High-Level Rotary Switch Installation

1. Drill a 2" diameter hole through the roof panel at the location shown in [Figure 3S on Page 28](#). See component placement [on Page 11](#) for proper placement in relation to fill auger.
2. Assemble 1/4" shaft to rotary switch with 1/4" coupler and rolled pins.
3. Screw 1-1/4" pipe coupler to bottom of rotary switch.
4. Insert 1-1/4" pipe through adjustable roof mount weldment. Leave 1-1/4" pipe sticking out the top of the weldment 3" as shown in [Figure 3U](#).
5. Install switch assembly through 2" hole in roof.
6. Install paddle to 1/4" shaft assembly with coupler and rolled pins.

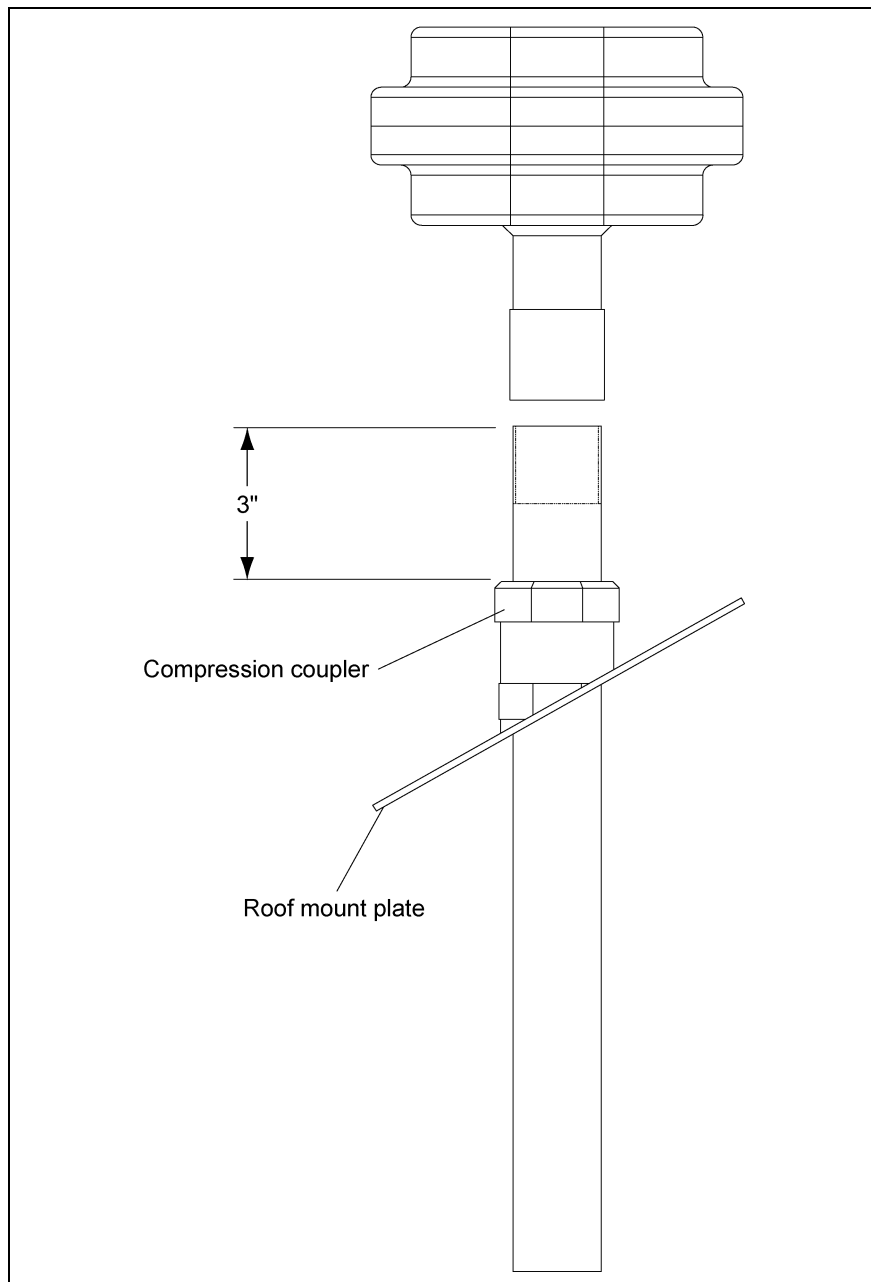


Figure 3U

Drying Chamber Overflow Rotary Switch Installation

1. Drill a 2" diameter hole through the roof panel at the location shown in [Figure 3S on Page 28](#). See component placement [on Page 11](#) for proper placement in relation to fill auger.
2. Use the mounting plate as a pattern and drill four (4) 3/8" holes through the roof panel at the switch location so the plate can be bolted to the roof.
3. Attach the flex coupling to the rotary switch power pack using a roll pin.
4. Apply teflon tape or pipe sealant (not included) to the rotary switch power pack threads and thread the rotary switch power pack into the mounting plate coupling.
5. Make sure that the conduit hole is at right angles with the roof panel ribs or facing towards the eave.
6. Caulk the underside of the mounting plate and on all sides of the 2" hole.
7. Bolt the assembly to the roof panel.
8. Attach the 3 vane paddle to the flex coupling as shown in [Figure 3V](#).

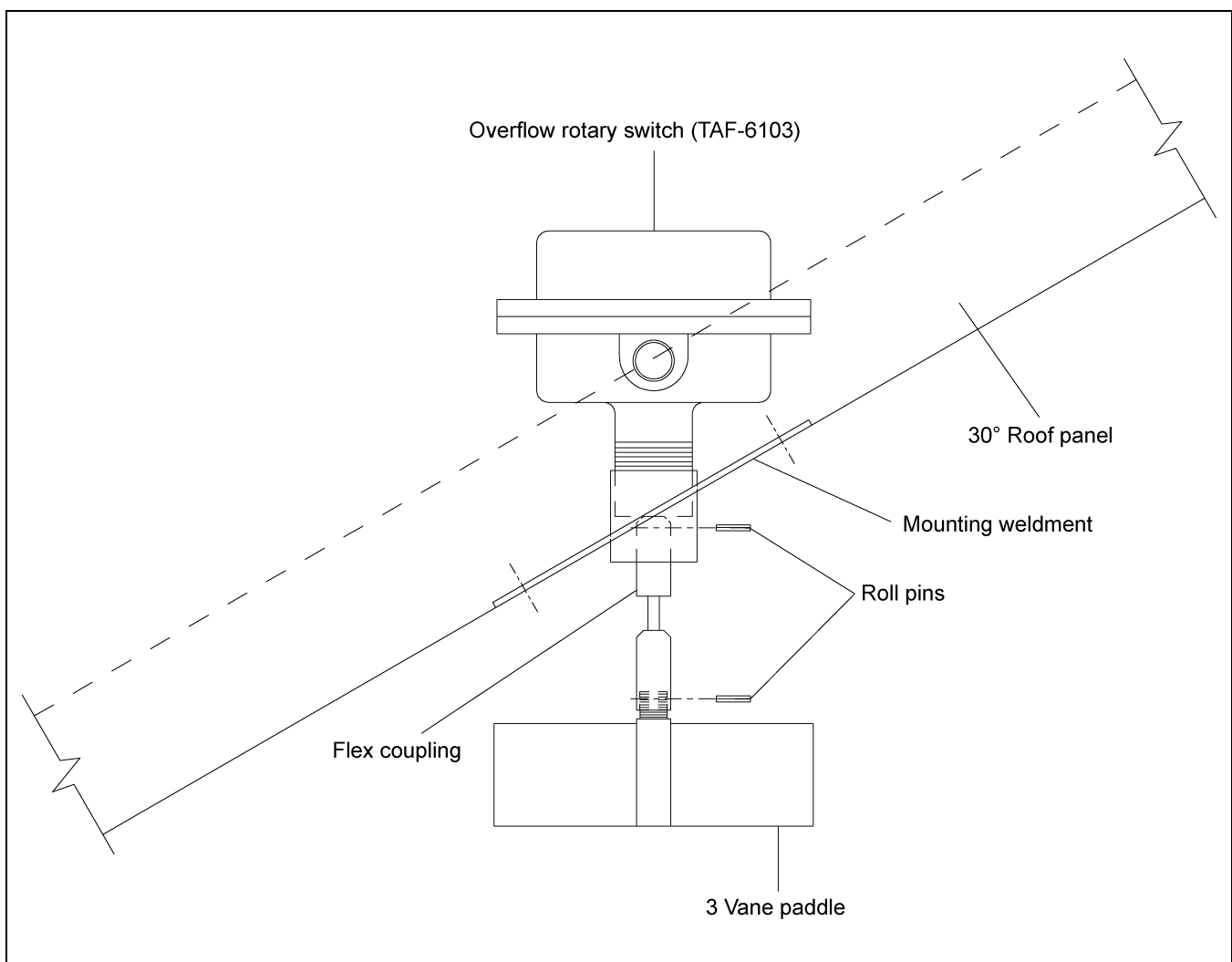


Figure 3V

3. Installation

Liquid Propane (LP)

Top Dry dryers have internal vaporizers and are designed to operate on liquid draw from the supply tank. Avoid using propane supply tanks that have been used for vapor draw for long periods of time. When using liquid draw systems, any moisture that may be present in tanks or lines may freeze when the system is used in cold weather. To avoid this situation, purge the system with methanol.

NOTICE

Do not use tanks which have previously been used for ammonia or fertilizer solutions. These substances are extremely corrosive and will damage fuel supply and burner parts.

Because the vaporizer coil may need to be adjusted during operation flexible hose suitable for LPs should be used for the final field connection.

See the [below](#) "Fuel Systems and Recommendations Chart" for liquid propane (LP) to determine the correct size line to run from the tank to the dryer. Have a qualified gas service person inspect the installation to be sure that everything is installed according to local codes and ordinances.

After installation is complete, check all connections for leaks with liquid detergent or comparable. Wear rubber gloves and eye protection. Avoid contact with liquid propane.



Do not use flame for leak testing.

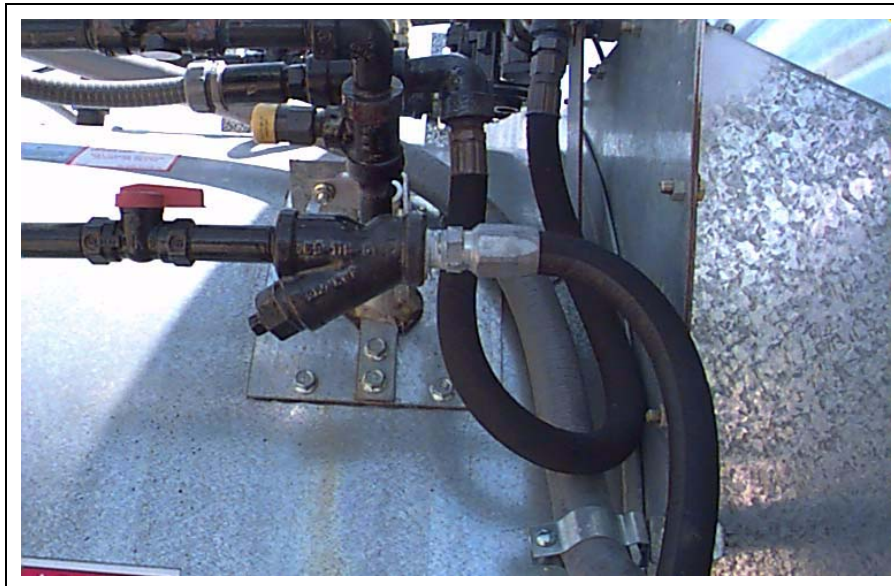


Figure 3W LP Line Field Connection

Fuel System Specifications and Recommendations Liquid Propane (LP)

Dryer Fan Size	Dryer Horsepower	Maximum Heat Capacity BTU per Hour	Maximum Fuel Flow Gallons per Hour	Minimum Line Size	Orifice Size	Minimum Operating Pressure	Maximum Operating Pressure
36"	15	5 Million	54	1/2"	21/64"	1 lb.	15 lbs.
40"	15	5.5 Million	60	1/2"	11/32"	1 lb.	15 lbs.
42"	30	9 Million	95	1/2"	0.328"	1 lb.	15 lbs.
42"	40	9.5 Million	104	3/4"	29/64"	1 lb.	15 lbs.

Natural Gas (NG)

This dryer is designed to operate on natural gas. Natural gas units have a larger orifice to accommodate lower pressures sometimes found with natural gas and do not have vaporizer coils like liquid propane units. A regulated pressure of 10 PSI minimum, 30 PSI maximum must be provided at the field connection point on the fan/heater unit, with gas available in sufficient volume to maintain the operating pressure.

See the [below](#) "Fuel Systems and Recommendations Chart" for natural gas (NG) to determine the correct size line to run to the dryer. Have a qualified gas service person inspect the installation to be sure everything is installed according to local codes and ordinances.

After installation is complete, check all connections for leaks with liquid detergent or comparable. Wear rubber gloves and eye protection.



Do not use flame for leak testing.

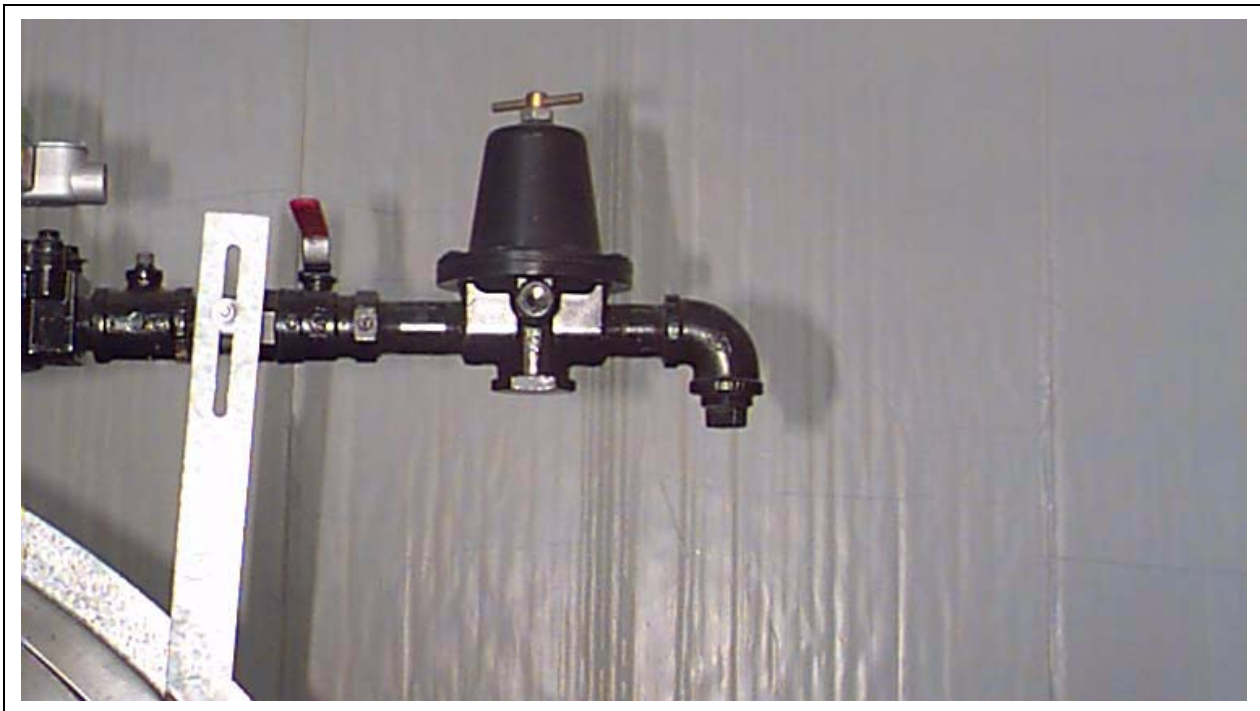


Figure 3X NG Line Field Connection

Fuel System Specifications and Recommendations Natural Gas (NG)

Dryer Fan Size	Dryer Horsepower	Maximum Heat Capacity BTU per Hour	Maximum Fuel Flow Cubic Ft. per Hour	Minimum Line Size	Orifice Size	Minimum Operating Pressure	Maximum Operating Pressure
36"	15	5 Million	5280	2"	1/2"	1 lb.	7 lbs.
40"	15	5.5 Million	5965	2"	17/32"	1 lb.	7 lbs.
42"	30	9 Million	9536	2"	43/64"	1 lb.	7 lbs.
42"	40	9.5 Million	10445	2"	45/64"	1 lb.	7 lbs.

4. Electrical Power Supply

Conduit Runs

Control Wires

Run #1 Autoflow control box to master fan/heater control box.

Five (5) - Control wires 16 gauge minimum. (**NOTE:** *A shielded two (2) conductor 16 gauge cable should be used for the network connections.*)

Run #2 Autoflow control box to actuator control box.

Five (5) - Control wires 16 gauge minimum.

Run #3 Autoflow control box to wet supply rotary switch.

Four (4) - Control wires 16 gauge minimum.

Run #4 Autoflow control box to storage chamber rotary switch.

Five (5) - Control wires 16 gauge minimum.

Run #5 Autoflow control box to drying chamber rotary switches.

Six (6) - Control wires 16 gauge minimum.

Run #6 Autoflow control box to fill system control box (if applicable).

Eleven (11) - Control wires 16 gauge minimum.

Run #7 Master fan/heater control box to slave fan/heater control box.

Four (4) - Control wires 16 gauge minimum. (**NOTE:** *A shielded two (2) conductor 16 gauge cable should be used for the network connections.*)

Run #8 Slave fan/heater #1 control box to slave fan/heater #2 control box.

Four (4) - Control wires 16 gauge minimum. (**NOTE:** *A shielded two (2) conductor 16 gauge cable should be used for the network connections.*)

Power/Motor Wires

Run #1 Entrance panel to master fan/heater control box (for fan motor).

Run #2 Entrance panel to slave fan/heater control boxes (if applicable, for fan motor).

Run #3 Entrance panel to fill system control box (if applicable).

1. For fill system #1 motor starter.
2. For fill system #2 motor starter (if applicable).
3. For aeration fan motor starter.

Run #4 Fill system control box to fill system #1 motor.

Run #5 Fill system control box to fill system #2 motor (if applicable).

Run #6 Fill system control box to aeration fan motor.

Run #7 Entrance panel to actuator control box.

1. 110V AC, 110V N, Ground wire for battery charger.

Grounding

All control boxes should be properly grounded with a ground lug mounted in each control box.

Power Supply

An adequate power supply and proper wiring are important factors to achieve 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 [on Page 39](#).)

Transformer and Wiring Voltage Drop

It is necessary to know the distance from the unit to the available transformer and the horsepower of the 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 [on Page 39](#) 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. Electrical Power Supply

Proper Installation of Ground Rod

The ground rod should not be driven into dry ground.

Follow these instructions for proper installation:

1. Dig a hole large enough to hold 1 to 2 gallons of water.
2. Fill hole with water.
3. Insert rod through water and jab it into the ground.
4. Continue jabbing the rod up and down. The water will work its way down the hole, making it possible to work the rod completely into the ground. This method of installing the rod gives a good conductive bond with the surrounding soil.
5. Connect the bare copper ground wire to the rod with the proper ground rod clamp. *(See Figure 4B on Page 37.)*
6. Connect the bare copper ground wire to the fan control boxes with a grounding lug.
7. Ground wire must not have any breaks or splices.

Dig a hole large enough to hold 1 or 2 gallons of water. Work the ground rod into the earth until it is completely in the ground.



Figure 4A

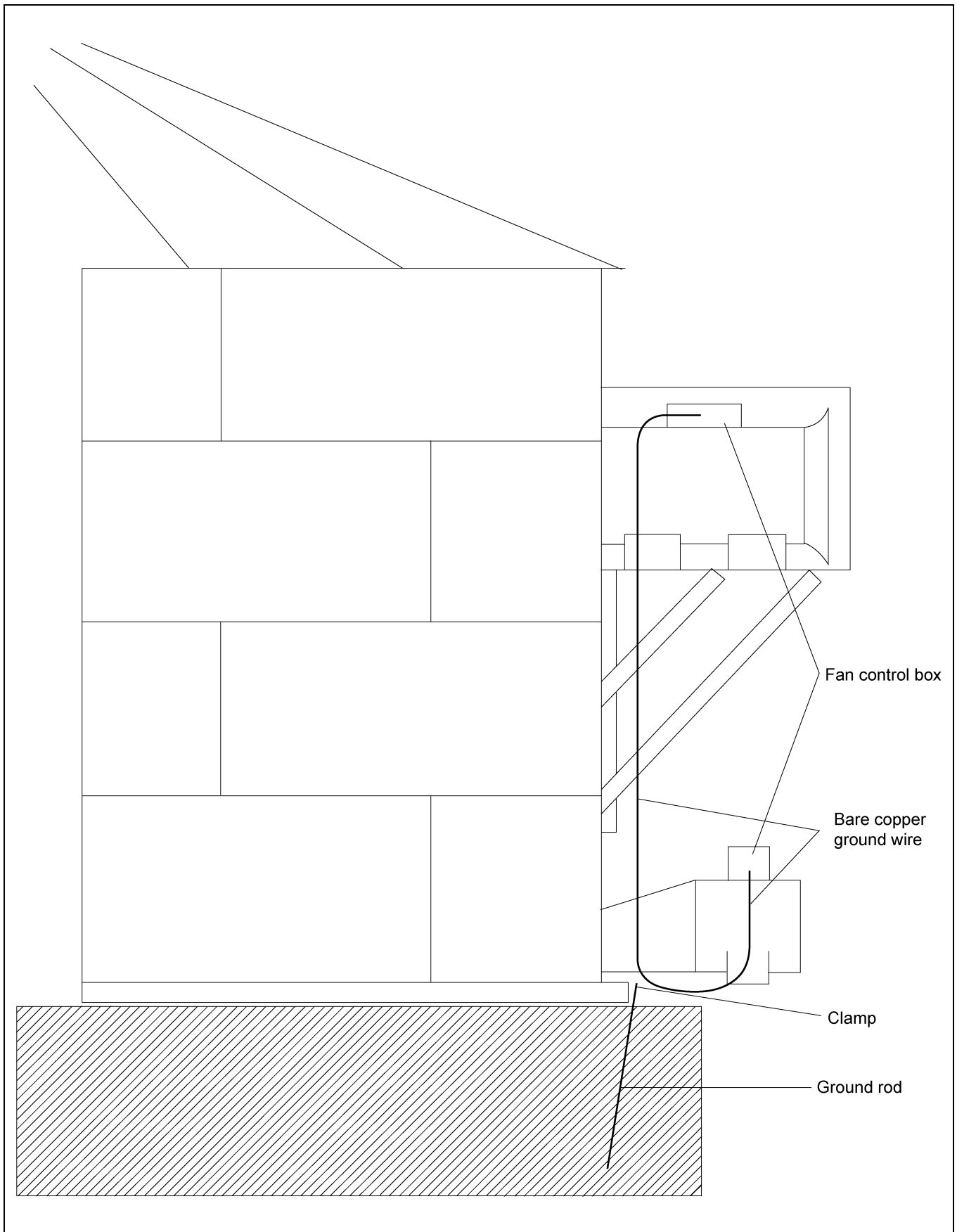


Figure 4B *The Top Dry and Ground Rod Attachment Illustration*

4. Electrical Power Supply

Power/Motor Wiring

The *Figure 4C* details the configuration for correct main power installation. Use the diagram in conjunction with the electrical load information and wire size information provided. The diagram details the correct main power installation for 220V 1 PH, 230V 3 PH, 460V 3 PH, 575V 3 PH and 380V 3 PH 50 Hz power supplies.

On all 3 phase systems put the leg with the highest potential difference between that leg and ground (wild or high voltage leg) on the center terminal (L2) at the motor starter.

NOTICE

Standard electrical safety procedures should be used. (Refer to the National Electrical Code Standard Handbook by the National Fire Protection Association.) A qualified electrician should make all electrical wiring installations. Follow all local or national electrical safety standards and ordinances when installing the equipment.

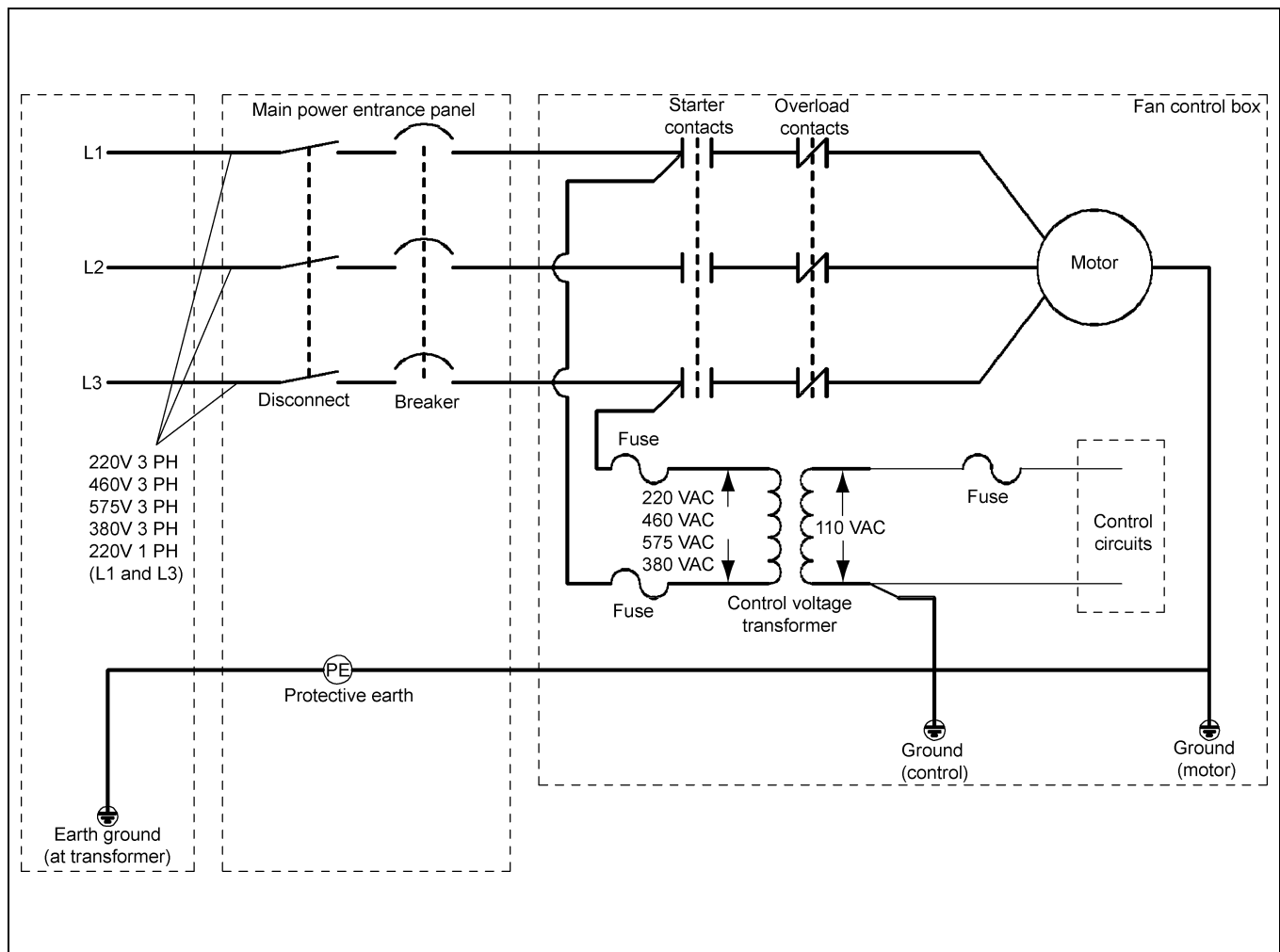


Figure 4C Main Power Schematic

Electrical Load Information

The [Chart below](#) provide information for the electrician wiring the grain dryer and are a reference guide for parts. It is recommended that you contact your local power company and have a representatives survey the installation to see that the wiring is compatible with their system and that adequate power is supplied to the unit. **NOTE:** *The only thing connected to the recommended service amps should be the grain dryer. Standard electrical safety procedures should be used. (Refer to the National Electrical Code Standard Handbook by the National Fire Protection Association.) A qualified electrician should make all electrical wiring installations.*

Dryer Fan Size	Voltage	Horsepower	Full Load Amps	Fuse (Slow Blow)	Breaker
36"	220V 1 PH	15	78	150	150
	208V 3 PH	15	44	125	125
	220V 3 PH	15	39	100	100
	380V 50 Hz	15	27	80	80
	460V 3 PH	15	20	50	50
	575V 3 PH	15	16	40	40
40"	220V 1 PH	15	78	150	150
	208V 3 PH	15	44	125	125
	220V 3 PH	15	39	100	100
	380V 50 Hz	15	27	80	80
	460V 3 PH	15	20	50	50
	575V 3 PH	15	16	40	40
42"	208V 3 PH	30	80	150	150
	220V 3 PH	30	74	150	150
	380V 50 Hz	30	39	100	100
	460V 3 PH	30	37	100	100
	575V 3 PH	30	30	80	80
42"	208V 3 PH	40	108	200	200
	220V 3 PH	40	102	200	200
	380V 50 Hz	40	47	100	100
	460V 3 PH	40	51	100	100
	575V 3 PH	40	40	100	100

4. Electrical Power Supply

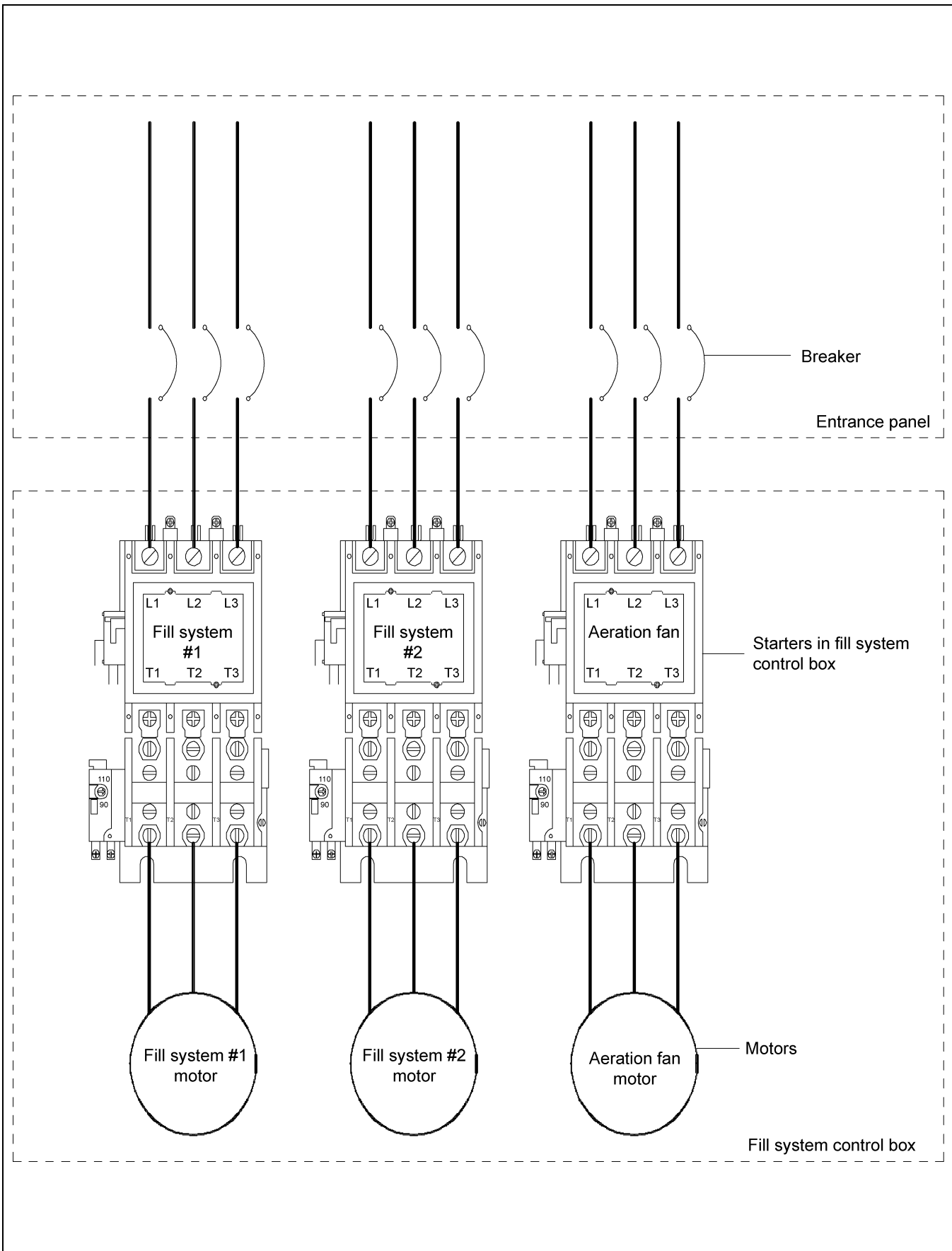


Figure 4D

Autoflow to Master Fan/Heater Unit Interconnect

The master fan/heater unit is the only fan and heater in a single fan unit. In two (2) fan units it is the fan/heater with the air switch, plenum temperature sensor and grain temperature sensor connected to it. DO NOT run the control wires for the master fan/heater in the same conduit as the power wires for the fan motor. To wire the master fan/heater unit to the Autoflow control box do the following.

NOTE: Do NOT use solid wire for interconnections.

NOTE: A shielded 16 gauge cable is recommended for use on the network connection. The network wires for this configuration are attached to terminal #4 and terminal #5. Ground each end of the shielded cable to the housing. A shielded 16 gauge 2 wire cable can be purchased from GSI. Part #WR-16/2S.

1. Run five (5) control wires from the Autoflow control box to the master fan/heater unit.
2. Connect the wires as shown in [Figure 4E](#).

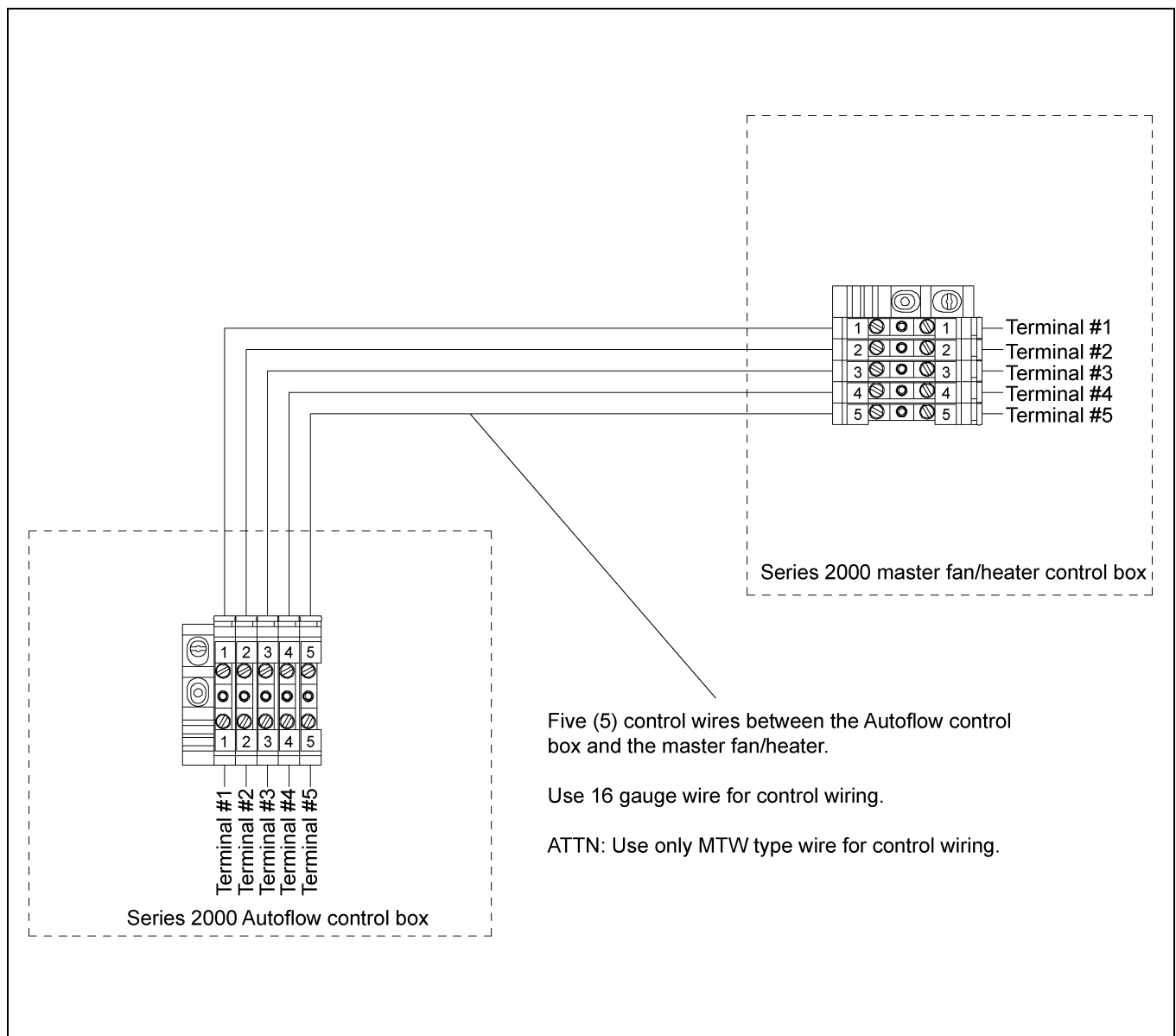


Figure 4E Master Fan and Heater Dip Switch Setting: #1 - "OFF"/All Others - "ON"

4. Electrical Power Supply

Autoflow to Actuator Interconnect

The actuator control box houses the 24V DC linear actuator, two (2) 12V DC batteries and a 24V DC battery charger. The linear actuator raises and lowers the dump chutes to unload grain automatically from the drying chamber to the storage chamber. The two (2) 12V DC batteries act as a back-up to prevent wet grain from dumping into the storage chamber during a power outage. The 24V DC battery charger provides a continuous recharge to the batteries.

To wire the actuator control box to the Autoflow control box do the following.

1. Run five (5) control wires from the Autoflow control box to the actuator control box.
2. Run three (3) power wires from the entrance panel to the actuator control box.
3. Connect the wires as shown in [Figure 4F](#).

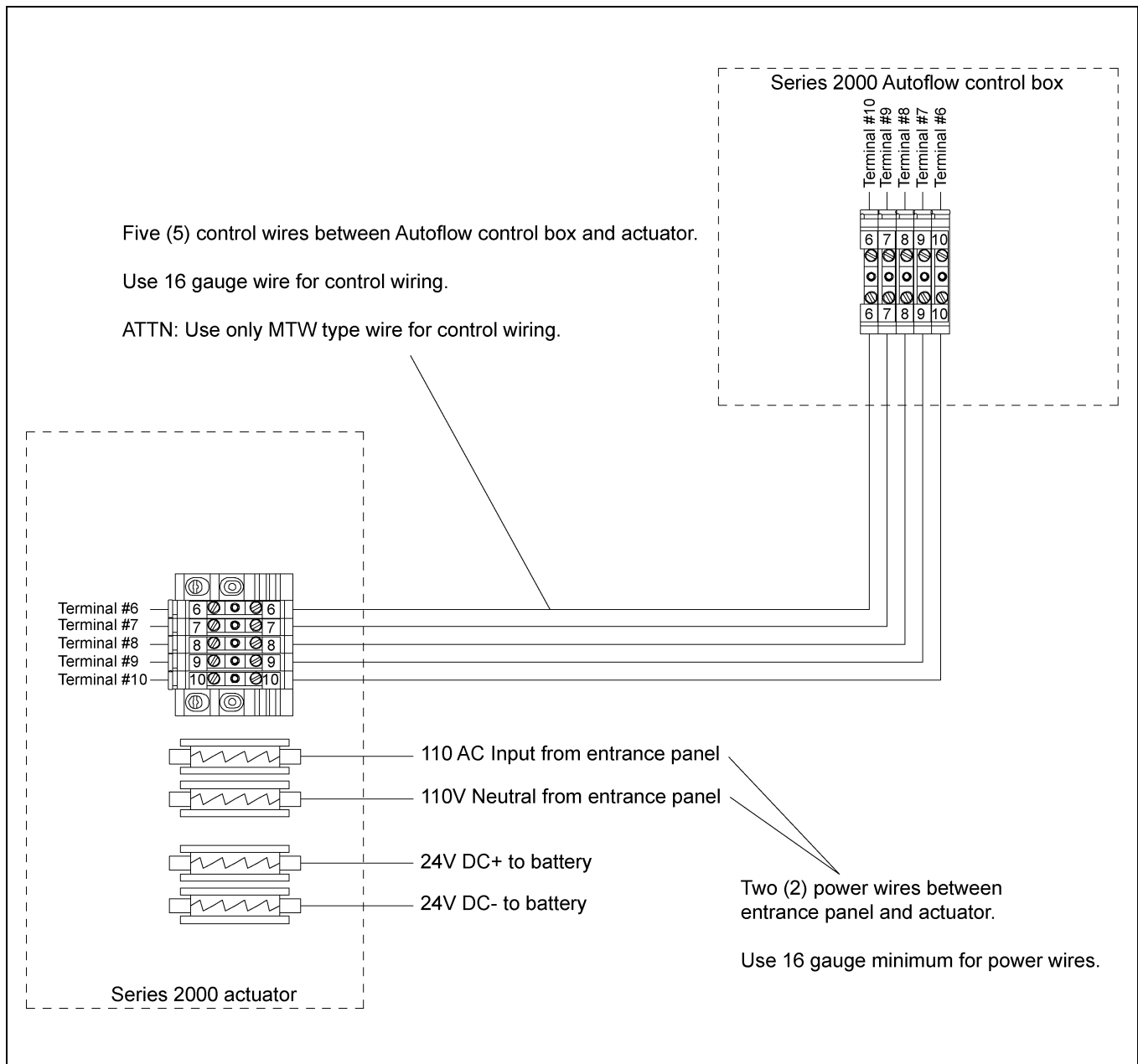


Figure 4F

Autoflow to Wet Supply Rotary Switch Interconnect

The 110V AC rotary switch located in the wet storage tank is used to inform the computer on the availability of wet grain. The Wet Supply Rotary switch use 110V AC to power the motor and 12V DC+ to switch a signal back to the computer.

To wire the Wet Supply Rotary switch to the Autoflow control box do the following:

1. Run four (4) control wires from the Autoflow control box to the Wet Supply Rotary switch.
2. Connect the wires as shown in [Figure 4G](#).

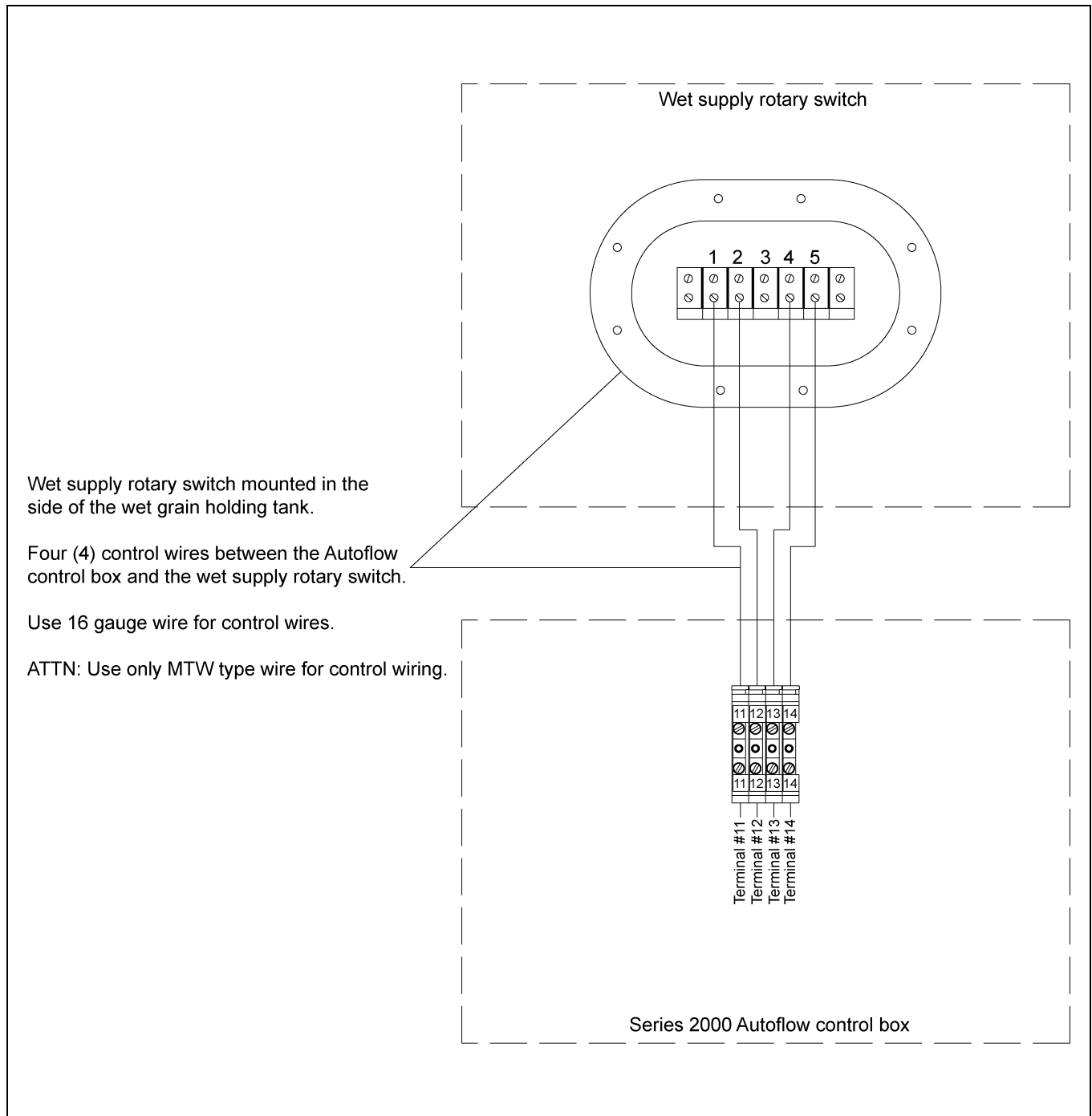


Figure 4G

4. Electrical Power Supply

Autoflow to Storage Chamber Rotary Switch Interconnect

The 110V AC rotary switch located in the storage tank is used to inform the computer on the availability of wet grain. The Storage Chamber Rotary switch is mounted 3' below the fan/heater unit(s). The Storage Chamber Rotary switch use 110V AC to power the motor and 12V DC+ to switch a signal back to the computer.

To wire the storage chamber rotary switch to the Autoflow control box do the following:

1. Run five (5) control wires from the Autoflow control box to the Storage Chamber Rotary switch.
2. Connect the wires as shown in [Figure 4H](#).

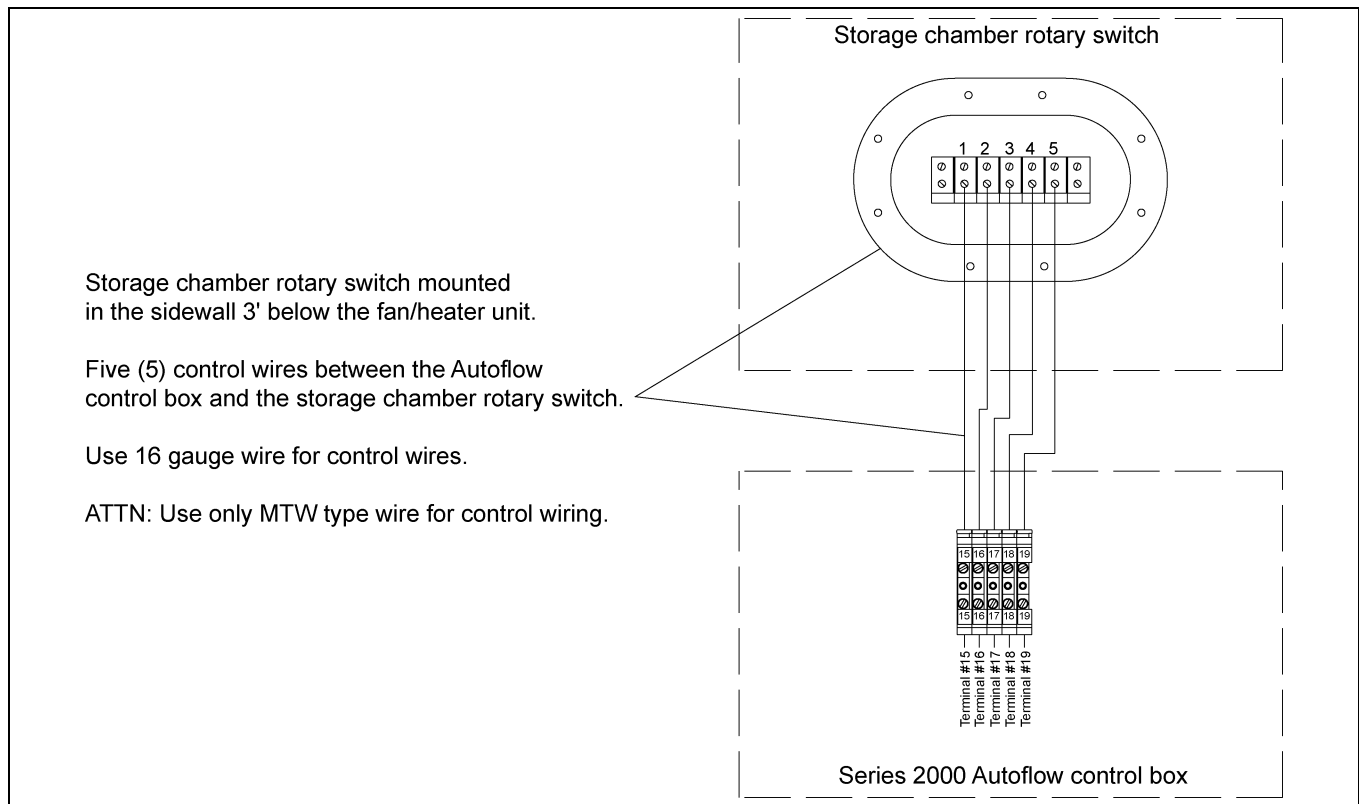


Figure 4H

Autoflow to Drying Chamber Rotary Switches Interconnect

The three (3) 110V AC rotary switches located in the drying chamber are used to inform the computer on the location of grain in the drying chamber. The rotary switch with the shortest extension is the Drying Chamber Overflow Rotary switch. It is used as a safety in the event the Chamber High-Level Rotary switch fails. The rotary switch with the longest extension is the Drying Chamber Low-Level Rotary switch. It is used to inform the computer when the peak has been covered with grain so the drying process can begin; and, will shut the dryer down if the drying chamber empties unexpectedly. The third rotary switch is the Drying Chamber High-Level Rotary switch. It is used to inform the dryer when the drying chamber is full. The Drying Chamber Rotary switches use 110V AC to power the motor and 12V DC+ to switch a signal back to the computer. The 110V AC, 110V N and the 12V DC+ wires can be jumped from rotary switch to rotary switch to lessen the wires needed.

To wire the Drying Chamber Rotary switches to the Autoflow control box do the following:

1. Run six (6) control wires from the Autoflow control box to the Drying Chamber Rotary switches.
2. Connect the wires as shown in [Figure 4I on Page 45](#).

4. Electrical Power Supply

Autoflow to Fill System Control Box Interconnect

The fill system control box houses the starter(s) for the fill system(s) that load grain into the Top Dry Autoflow unit and for the aeration fan. DO NOT run the control wires for the fill system control box in the same conduit used for the power wires for the fill system and aeration fan motors. To wire the fill system control to the Autoflow control box do the following.

1. Run eleven (11) control wires from the Autoflow control box to the fill system control box.
2. Connect the wires as shown in [Figure 4J](#).

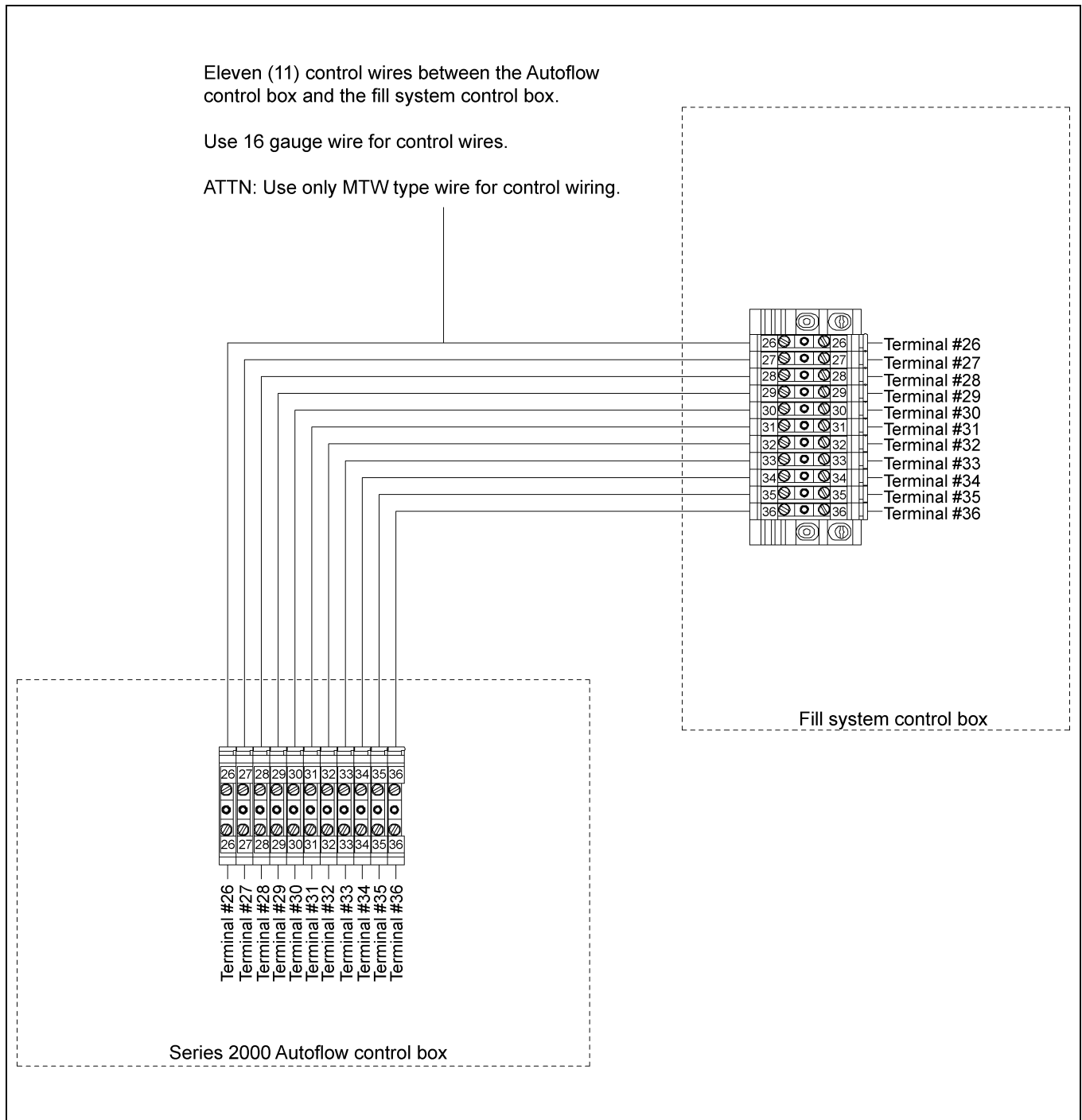


Figure 4J

Autoflow to Ground Interconnect

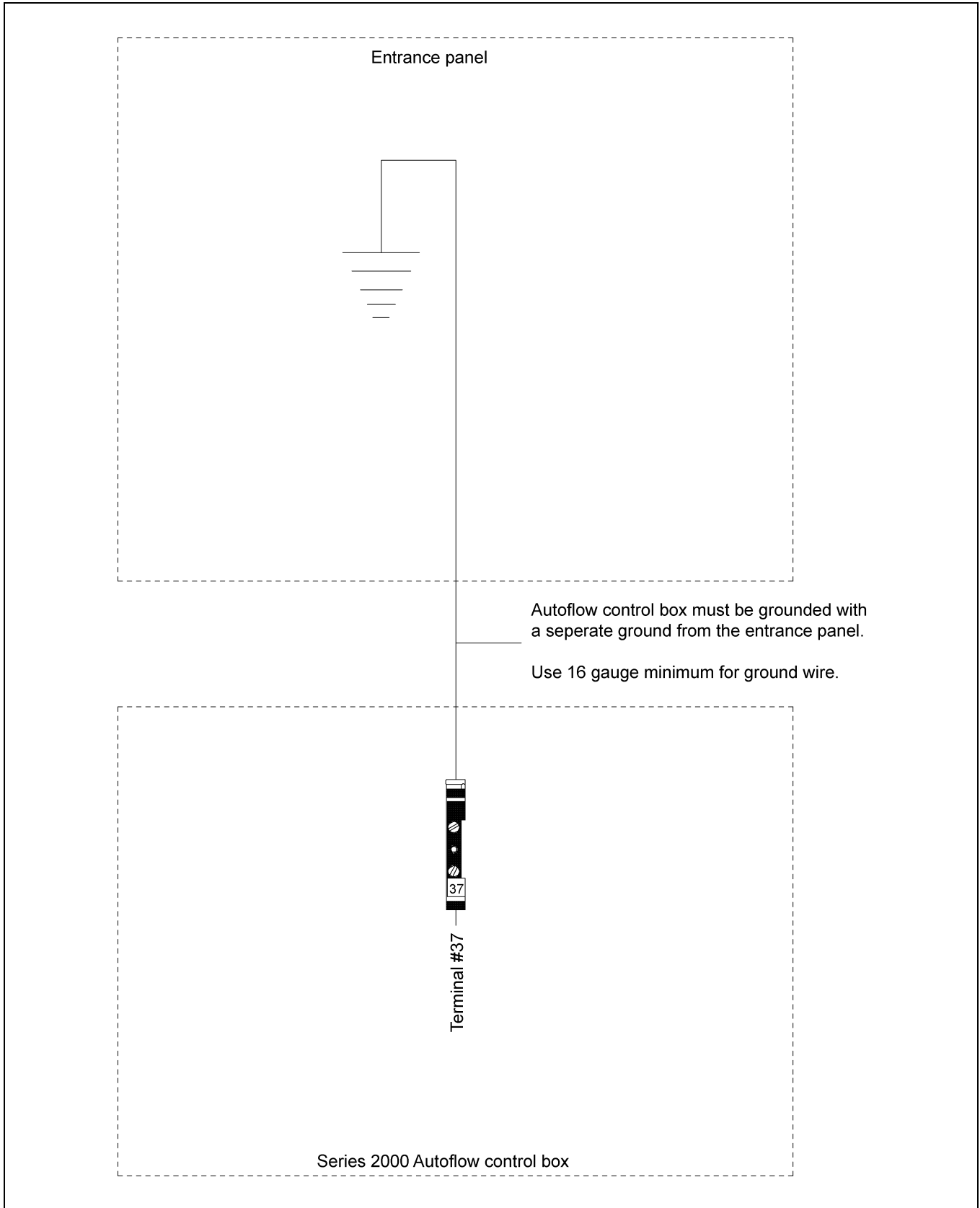


Figure 4K

4. Electrical Power Supply

Master to Slave Interconnect

A slave fan/heater unit can be added to operate in unison with the master fan/heater unit. The interconnect between the master and slave fan/heater units remains the same regardless of the type or presence of a control center. To wire a slave fan/heater unit to a master fan/heater unit do the following:

NOTE: Do NOT use solid wire for interconnection.

1. Run four (4) 16 gauge MTW type wires from the master fan/heater unit to the slave fan/heater unit.
2. Connect the wires as shown in [Figure 4L](#).

NOTE: A shielded 16 gauge cable is recommended for use on the network connections. The network connections for this configuration are attached to terminal #8 and terminal #9 in the master unit and terminal #3 and terminal #4 in the slave unit. Ground each end of the shielded cable to the housing. A shielded 16 gauge 2 wire cable can be purchased from GSI. Part #WR-16/2S.

Slave #1 Fan and Heater Dip Switch Setting: #2 - “OFF”/All Others - “ON”

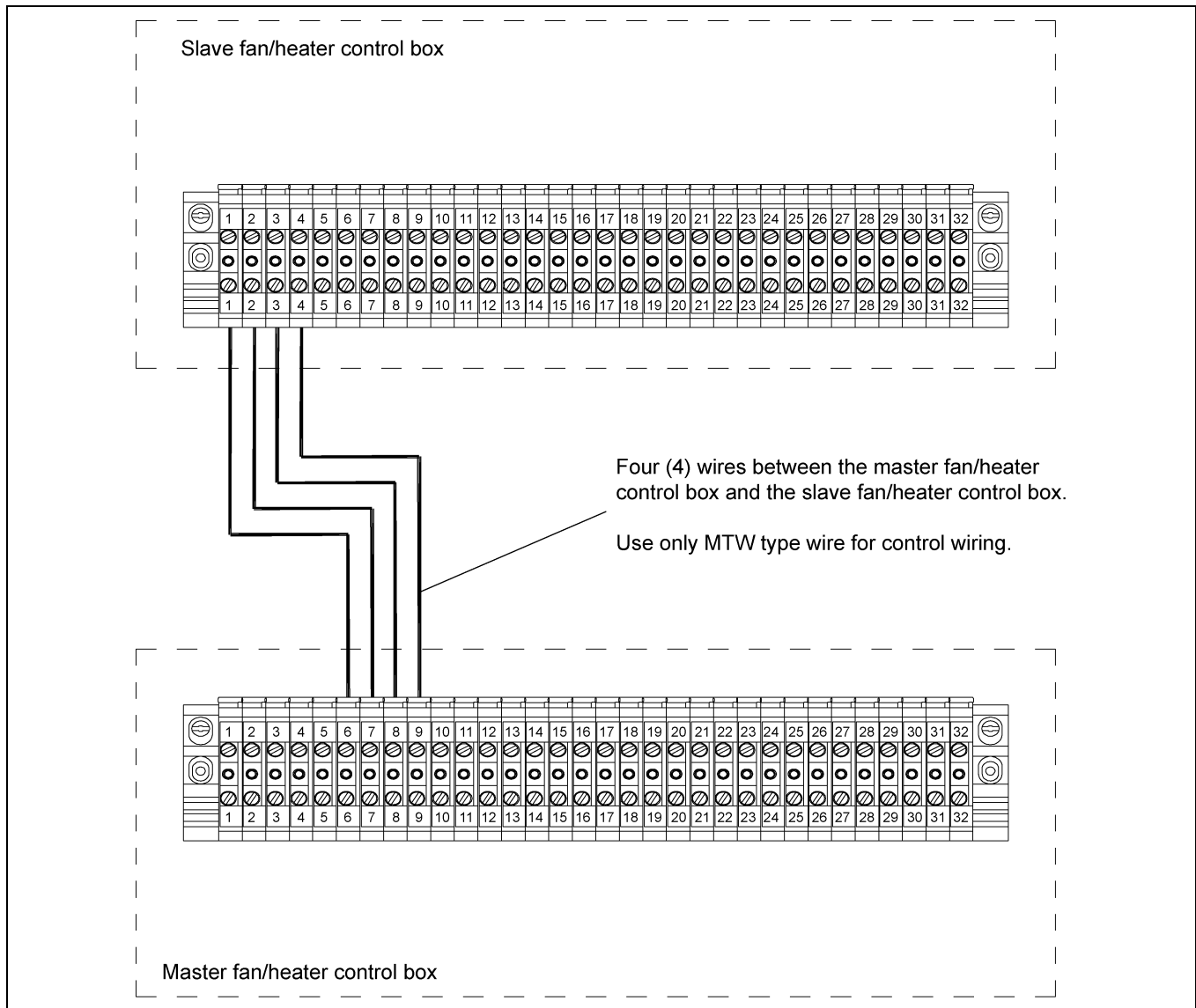


Figure 4L Wiring for a slave fan/heater unit to a master fan/heater unit.

Slave to Slave Interconnect

A second slave fan/heater unit can be added to operate in unison with the master fan/heater unit and another slave fan/heater unit. This would create a three (3) fan unit. The interconnect between the first slave fan/heater unit and the second slave fan/heater unit remains the same regardless of the type or presence of a control center. To wire a second slave fan/heater unit to another slave fan/heater unit do the following:

NOTE: Do NOT use solid wire for interconnection.

1. Run four (4) 16 gauge MTW type wires from the first slave fan/heater unit to the second slave fan/heater unit.
2. Connect the wires as shown in [Figure 4M](#).

NOTE: A shielded 16 gauge cable is recommended for use on the network connections. The network connections for this configuration are attached to terminal #7 and terminal #8 in slave #1 and terminal #3 and terminal #4 in slave #2. Ground each end of the shielded cable to the housing. A shielded 16 gauge 2 wire cable can be purchased from GSI. Part #WR-16/2S

Slave #2 Fan and Heater Dip Switch Setting: #1 and #2 - “OFF”/ All Others - “ON”

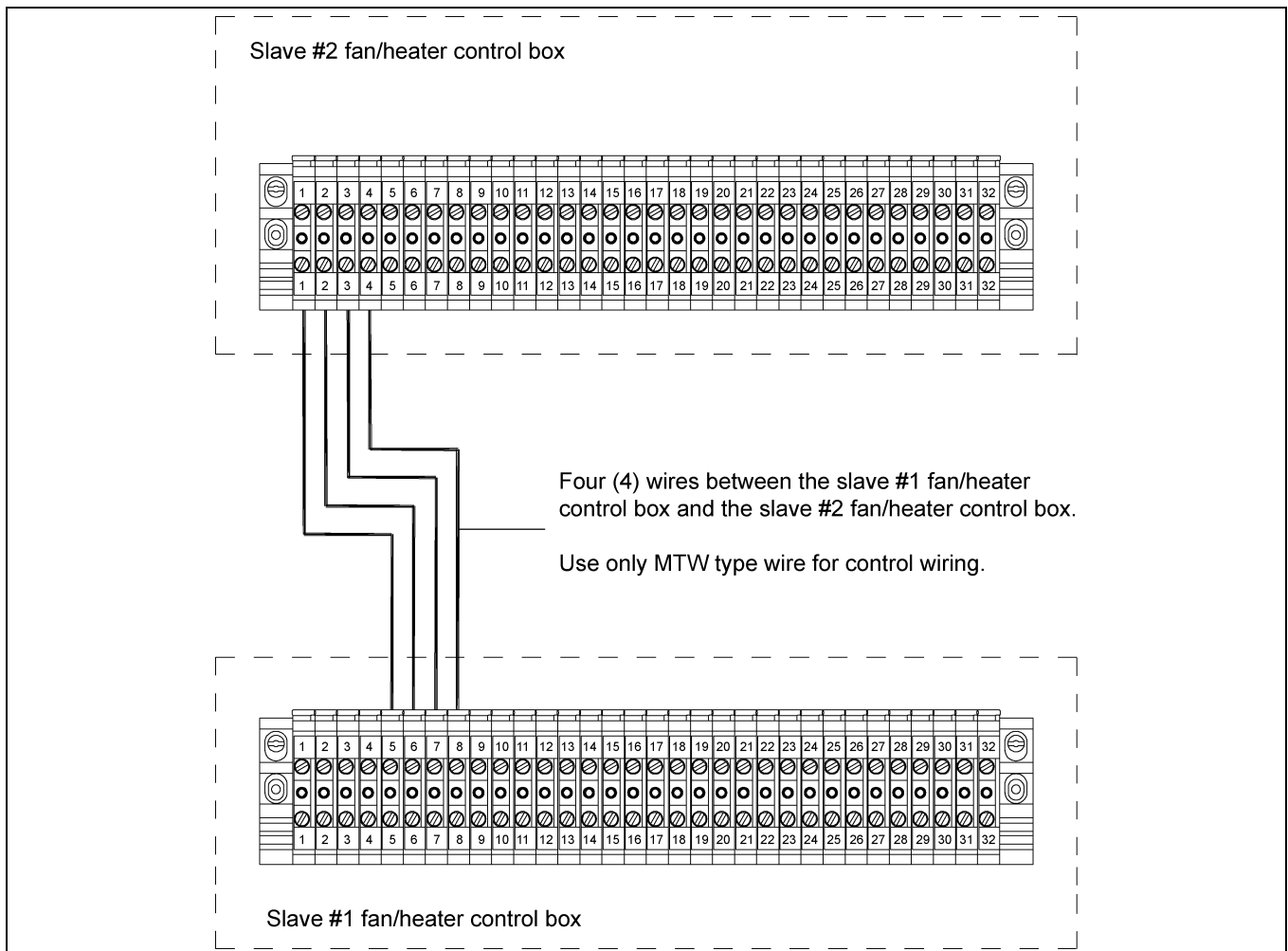


Figure 4M Wiring for a second slave fan/heater unit to another slave fan/heater unit.

4. Electrical Power Supply

Battery Hook-Up

Two (2) lawn and garden type 12V DC batteries are required for proper operation of the actuator control box. The two (2) 12V DC batteries are wired in series to provide the 24V DC linear actuator with the voltage required to operate. The two (2) 12V DC batteries should be mounted on the shelves provided in the actuator control box.

To wire the two (2) 12V DC batteries to the 24V DC battery charger do the following:

1. Mount the two (2) 12V DC batteries in the actuator control box on the proper shelves.
2. Install a jumper from the negative terminal on one battery to the positive terminal on the other battery.
3. Attach the red wire coming from the fuse block and the positive lead on the 24V DC battery charger to the open positive terminal on one battery.
4. Attach the black wire coming from the fuse block; and the negative lead on the 24V DC battery charger to the open negative terminal on the other battery.
5. Use [Figure 4N](#) to guide installation.

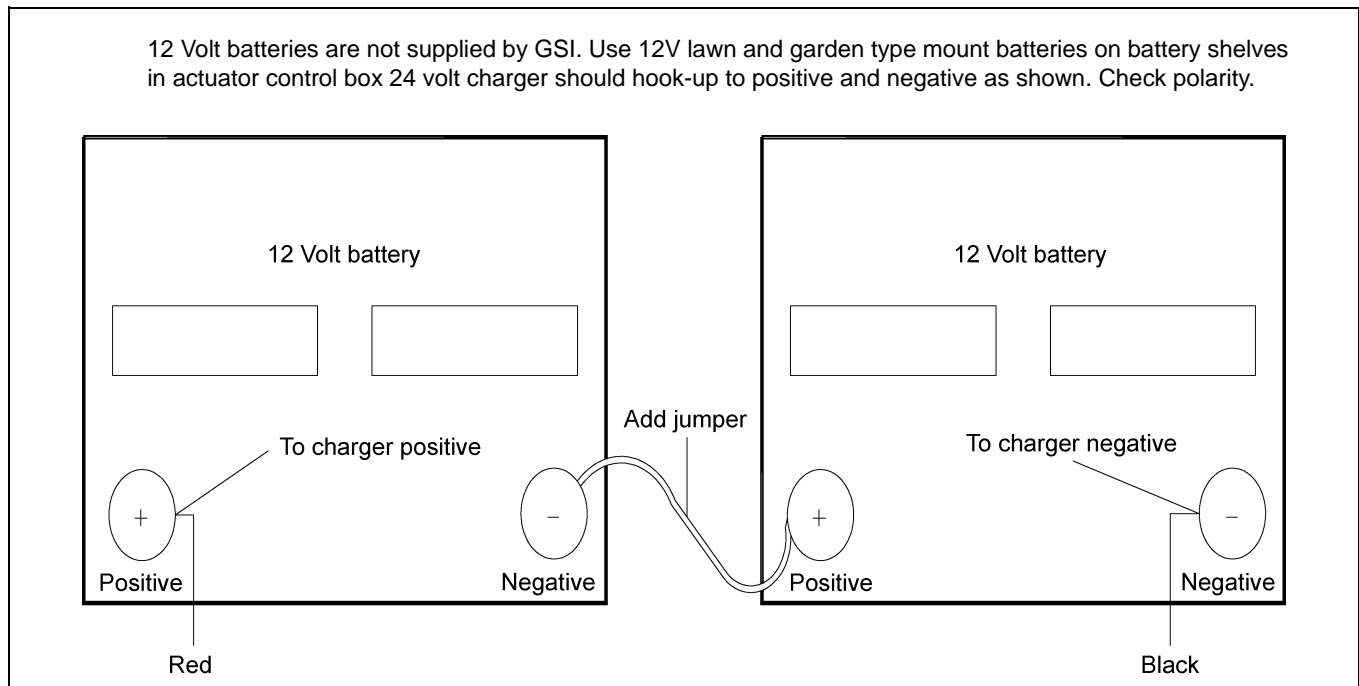


Figure 4N

Dump Chute Cable Installation

After complete installation of the Autoflow unit, the cable should be hooked up to the linear actuator in the actuator control box. To test the linear actuator and install the cable do the following:

1. Turn all switches on the Autoflow control front panel to the "OFF" position.
2. Make sure the Emergency Stop switches on all the control boxes are pulled out.
3. Turn the Control Power switch to the "ON" position.
4. The display should read "stopped" at the bottom.
5. While watching the linear actuator turn the Dump switch to the "MANUAL OPEN" position.

6. The linear actuator should extend down 16".
7. Place the Dump switch in the "AUTO" position and press the Stop switch.
8. The linear actuator should retract and stop.
9. Place the Control Power switch in the "OFF" position and push the Emergency Stop switch in on the Autoflow and actuator control boxes.
10. Route the cable as shown in [Figure 40](#).
11. Make sure that all dump chutes are approximately 5° below level when in the closed position.
12. Double check all dump chutes to make sure that they are all adjusted the same when in the closed position. The Autoflow unit will not operate properly if the dump chutes are adjusted unevenly.

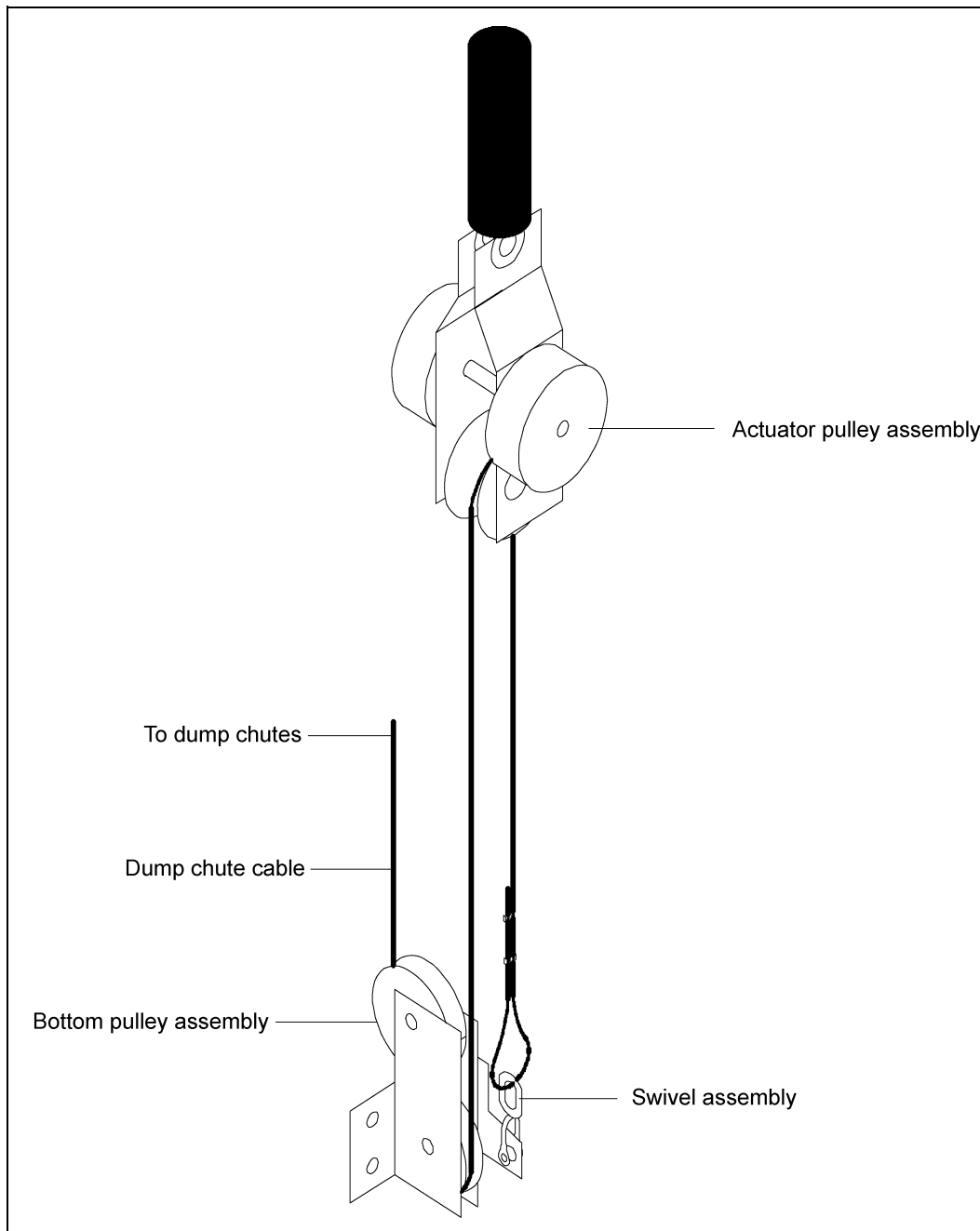


Figure 40

NOTES

GSI Group, LLC Limited Warranty

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 after sale to the original end-user or if a foreign sale, 14 months from arrival at port of discharge, whichever is earlier. The end-user's sole remedy (and GSI's only obligation) is to repair or replace, at GSI's option and expense, products that in GSI's judgment, contain a material defect in materials or workmanship. Expenses incurred by or on behalf of the end-user without prior written authorization from the GSI Warranty Group shall be the sole responsibility of the end-user.

Warranty Extensions:

The Limited Warranty period is extended for the following products:

	Product	Warranty Period	
AP Fans and Flooring	Performer Series Direct Drive Fan Motor	3 Years	* Warranty prorated from list price: 0 to 3 years - no cost to end-user 3 to 5 years - end-user pays 25% 5 to 7 years - end-user pays 50% 7 to 10 years - end-user pays 75%
	All Fiberglass Housings	Lifetime	
	All Fiberglass Propellers	Lifetime	
Cumberland Feeding/Watering Systems	Feeder System Pan Assemblies	5 Years **	** Warranty prorated from list price: 0 to 3 years - no cost to end-user 3 to 5 years - end-user pays 50%
	Feed Tubes (1-3/4" and 2.00")	10 Years *	
	Centerless Augers	10 Years *	
	Watering Nipples	10 Years *	
Grain Systems	Grain Bin Structural Design	5 Years	
Grain Systems Farm Fans Zimmerman	Portable and Tower Dryers	2 Years	† Motors, burner components and moving parts not included. Portable dryer screens included. Tower dryer screens not included.
	Portable and Tower Dryer Frames and Internal Infrastructure †	5 Years	

GSI further warrants that the portable and tower dryer frame and basket, excluding all auger and auger drive components, shall be free from defects in materials for a period of time beginning on the twelfth (12th) month from the date of purchase and continuing until the sixtieth (60th) month from the date of purchase (extended warranty period). During the extended warranty period, GSI will replace the frame or basket components that prove to be defective under normal conditions of use without charge, excluding the labor, transportation, and/or shipping costs incurred in the performance of this extended warranty.

Conditions and Limitations:

THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE LIMITED WARRANTY DESCRIPTION SET FORTH ABOVE. SPECIFICALLY, GSI MAKES NO FURTHER WARRANTY OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING, WITHOUT LIMITATION, WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR USE IN CONNECTION WITH: (I) 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.

GSI shall not be liable for any direct, indirect, incidental or consequential damages, including, without limitation, loss of anticipated profits or benefits. The sole and exclusive remedy is set forth in the Limited Warranty, which shall not exceed the amount paid for the product purchased. 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.

GSI assumes no responsibility for claims resulting from construction defects or unauthorized modifications to products which it manufactured. Modifications to products not specifically delineated in the manual accompanying the equipment at initial sale will void the Limited Warranty.

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. This Limited Warranty extends solely to products manufactured by GSI.

Prior to installation, the end-user has the responsibility to comply with federal, state and local codes which apply to the location and installation of products manufactured or sold by GSI.

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.

G S I G R O U P



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