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Service & Mechanical Parts

6450, 6458, 6464, 7676, & 8282 TG1L/R (RA)



**Read the
separate
safety
manual
before
installing,
operating,
or servicing**



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We warrant to the original purchaser that MILNOR machines including electronic hardware/software (hereafter referred to as "equipment"), will be free from defects in material and workmanship for a period of one year from the date of shipment (unless the time period is specifically extended for certain parts pursuant to a specific MILNOR published extended warranty) from our factory with no operating hour limitation. This warranty is contingent upon the equipment being installed, operated and serviced as specified in the operating manual supplied with the equipment, and operated under normal conditions by competent operators.

Providing we receive written notification of a warranted defect within 30 days of its discovery, we will—at our option—repair or replace the defective part or parts, EX Factory (labor and freight specifically NOT included). We retain the right to require inspection of the parts claimed defective in our factory prior to repairing or replacing same. We will not be responsible, or in any way liable, for unauthorized repairs or service to our equipment, and this warranty shall be void if the equipment is tampered with, modified, or abused, used for purposes not intended in the design and construction of the machine, or is repaired or altered in any way without MILNOR's written consent.

Parts damaged by exposure to weather, to aggressive water, or to chemical attack are not covered by this warranty. For parts which require routine replacement due to normal wear—such as gaskets, contact points, brake and clutch linings, belts, hoses, and similar parts—the warranty time period is 90 days.

We reserve the right to make changes in the design and/or construction of our equipment (including purchased components) without obligation to change any equipment previously supplied.

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BMP720097/19036

How to Get the Necessary Repair Components



This document uses Simplified Technical English.
Learn more at <http://www.asd-ste100.org>.

You can get components to repair your machine from the approved supplier where you got this machine. Your supplier will usually have the necessary components in stock. You can also get components from the Milnor® factory.

Tell the supplier the machine model and serial number and this data for each necessary component:

- The component number from this manual
- The component name if known
- The necessary quantity
- The necessary transportation requirements
- If the component is an electrical component, give the schematic number if known.
- If the component is a motor or an electrical control, give the nameplate data from the used component.

To write to the Milnor factory:

Pellerin Milnor Corporation
Post Office Box 400
Kenner, LA 70063-0400
UNITED STATES

Telephone: 504-467-2787
Fax: 504-469-9777
Email: parts@milnor.com

— End of BIUUUD19 —

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Table 1. Trademarks

AutoSpot [™]	GreenFlex [™]	MilMetrix [®]	PulseFlow [®]
CBW [®]	GearTrace [™]	MilTouch [™]	RAM Command [™]
Drynet [™]	GreenTurn [™]	MilTouch-EX [™]	RecircONE [®]
E-P Express [®]	Hydro-cushion [™]	MILRAIL [™]	RinSave [®]
E-P OneTouch [®]	Mentor [®]	Miltrac [™]	SmoothCoil [™]
E-P Plus [®]	Mildata [®]	PBW [™]	Staph Guard [®]
Gear Guardian [®]	Milnor [®]		

End of document: BNUUUU02

Safety

1

Safety—Dryers, Conditioners, and Shakers

1. General Safety Requirements—Vital Information for Management Personnel [Document BIUUUS04]

Incorrect installation, neglected preventive maintenance, abuse, and/or improper repairs, or changes to the machine can cause unsafe operation and personal injuries, such as multiple fractures, amputations, or death. The owner or his selected representative (owner/user) is responsible for understanding and ensuring the proper operation and maintenance of the machine. The owner/user must familiarize himself with the contents of all machine instruction manuals. The owner/user should direct any questions about these instructions to a Milnor® dealer or the Milnor® Service department.

Most regulatory authorities (including OSHA in the USA and CE in Europe) hold the owner/user ultimately responsible for maintaining a safe working environment. Therefore, the owner/user must do or ensure the following:

- recognize all foreseeable safety hazards within his facility and take actions to protect his personnel, equipment, and facility;
- work equipment is suitable, properly adapted, can be used without risks to health or safety, and is adequately maintained;
- where specific hazards are likely to be involved, access to the equipment is restricted to those employees given the task of using it;
- only specifically designated workers carry out repairs, modifications, maintenance, or servicing;
- information, instruction, and training is provided;
- workers and/or their representatives are consulted.

Work equipment must comply with the requirements listed below. The owner/user must verify that installation and maintenance of equipment is performed in such a way as to support these requirements:

- control devices must be visible, identifiable, and marked; be located outside dangerous zones; and not give rise to a hazard due to unintentional operation;
- control systems must be safe and breakdown/damage must not result in danger;
- work equipment is to be stabilized;
- protection against rupture or disintegration of work equipment;
- guarding, to prevent access to danger zones or to stop movements of dangerous parts before the danger zones are reached. Guards to be robust; not give rise to any additional hazards; not be easily removed or rendered inoperative; situated at a sufficient distance from the danger zone; not restrict view of operating cycle; allow fitting, replacing, or maintenance by restricting access to relevant area and without removal of guard/protection device;
- suitable lighting for working and maintenance areas;
- maintenance to be possible when work equipment is shut down. If not possible, then protection measures to be carried out outside danger zones;
- work equipment must be appropriate for preventing the risk of fire or overheating; discharges of gas, dust, liquid, vapor, other substances; explosion of the equipment or substances in it.

- 1.1. **Laundry Facility**—Provide a supporting floor that is strong and rigid enough to support—with a reasonable safety factor and without undue or objectionable deflection—the weight of the fully loaded machine and the forces transmitted by it during operation. Provide sufficient clearance for machine movement. Provide any safety guards, fences, restraints, devices, and verbal and/or posted restrictions necessary to prevent personnel, machines, or other moving machinery from accessing the machine or its path. Provide adequate ventilation to carry away heat and vapors. Ensure service connections to installed machines meet local and national safety standards, especially regarding the electrical disconnect (see the National Electric Code). Prominently post safety information, including signs showing the source of electrical disconnect.
- 1.2. **Personnel**—Inform personnel about hazard avoidance and the importance of care and common sense. Provide personnel with the safety and operating instructions that apply to them. Verify that personnel use proper safety and operating procedures. Verify that personnel understand and abide by the warnings on the machine and precautions in the instruction manuals.
- 1.3. **Safety Devices**—Ensure that no one eliminates or disables any safety device on the machine or in the facility. Do not allow machine to be used with any missing guard, cover, panel or door. Service any failing or malfunctioning device before operating the machine.
- 1.4. **Hazard Information**—Important information on hazards is provided on the machine safety placards, in the Safety Guide, and throughout the other machine manuals. **Placards must be kept clean so that the information is not obscured. They must be replaced immediately if lost or damaged. The Safety Guide and other machine manuals must be available at all times to the appropriate personnel.** See the machine service manual for safety placard part numbers. Contact the Milnor Parts department for replacement placards or manuals.
- 1.5. **Maintenance**—Ensure the machine is inspected and serviced in accordance with the norms of good practice and with the preventive maintenance schedule. Replace belts, pulleys, brake shoes/disks, clutch plates/tires, rollers, seals, alignment guides, etc. before they are severely worn. Immediately investigate any evidence of impending failure and make needed repairs (e.g., cylinder, shell, or frame cracks; drive components such as motors, gear boxes, bearings, etc., whining, grinding, smoking, or becoming abnormally hot; bending or cracking of cylinder, shell, frame, etc.; leaking seals, hoses, valves, etc.) Do not permit service or maintenance by unqualified personnel.

2. **Safety Alert Messages—Internal Electrical and Mechanical Hazards** [Document BIUUUS11]

The following are instructions about hazards inside the machine and in electrical enclosures.



WARNING 1: Electrocution and Electrical Burn Hazards—Contact with electric power can kill or seriously injure you. Electric power is present inside the cabinetry unless the main machine power disconnect is off.

- Do not unlock or open electric box doors.
- Do not remove guards, covers, or panels.
- Do not reach into the machine housing or frame.
- Keep yourself and others off of machine.
- Know the location of the main machine disconnect and use it in an emergency to remove all electric power from the machine.



WARNING 2: Entangle and Crush Hazards—Contact with moving components normally isolated by guards, covers, and panels, can entangle and crush your limbs. These components move automatically.

- Do not remove guards, covers, or panels.
- Do not reach into the machine housing or frame.
- Keep yourself and others off of machine.
- Know the location of all emergency stop switches, pull cords, and/or kick plates and use them in an emergency to stop machine motion.



CAUTION 3: Burn Hazards—Contact with hot goods or machine components can burn you.

- Do not remove guards, covers, or panels.
- Do not reach into the machine housing or frame.

3. Safety Alert Messages—External Mechanical Hazards [Document BIUUUS12]

The following are instructions about hazards around the front, sides, rear or top of the machine.

4. Safety Alert Messages—Cylinder and Processing Hazards

[Document BIUUUS13]

The following are instructions about hazards related to the cylinder and laundering process.



DANGER 4: Entangle and Sever Hazards—Contact with goods being processed can cause the goods to wrap around your body or limbs and dismember you.

- Do not attempt to open the door or reach into the cylinder until the cylinder is stopped.
- Do not touch goods inside or hanging partially outside the turning cylinder.
- Know the location of all emergency stop switches, pull cords, and/or kick plates and use them in an emergency to stop machine motion.
- Know the location of the main machine disconnect and use it in an emergency to remove all electric power from the machine.



WARNING 5: Crush Hazards—Contact with the turning cylinder can crush your limbs. The cylinder will repel any object you try to stop it with, possibly causing the object to strike or stab you.

- Do not attempt to open the door or reach into the cylinder until the cylinder is stopped.
- Do not place any object in the turning cylinder.



WARNING 6: Confined Space Hazards—Confinement in the cylinder can kill or injure you. Hazards include but are not limited to panic, burns, poisoning, suffocation, heat prostration, biological contamination, electrocution, and crushing.

- Do not attempt unauthorized servicing, repairs, or modification.



WARNING 7: Explosion and Fire Hazards—Petroleum and latex materials are flammable. They can produce explosive fumes when heated.

- Do not use flammable solvents in processing.
- Do not load machine with goods containing dry cleaning materials.
- Do not use the machine in the presence of solvent fumes.



WARNING 8: Poison and Corrosion Hazards—Synthetic solvents such as perchloroethylene are toxic. They can produce poisonous phosgene gas (mustard gas) and/or corrosive hydrochloric acid when heated.

- Do not load machine with goods containing dry cleaning materials.
- Do not use the machine in the presence of solvent fumes.



WARNING 9: Fire Hazards—Overheated goods can catch fire spontaneously in the machine or after discharge.

- Verify the overheat control system and plant fire extinguishers are functioning before operating the machine. Be sure to turn water supply on after testing.
- In the event of a fire, thoroughly wet all goods.
- Test or inspect the system after every automatic actuation, or monthly.



CAUTION 10: Burn Hazards—Contact with hot goods or machine components can burn you.

- Do not remove guards, covers, or panels.
- Do not reach into the machine housing or frame.
- Use care when handling recently-processed goods.

5. Safety Alert Messages—Unsafe Conditions [Document BIUUUS14]

5.1. Damage and Malfunction Hazards

5.1.1. Hazards Resulting from Inoperative Safety Devices



WARNING 11: Multiple Hazards—Operating the machine with an inoperative safety device can kill or injure personnel, damage or destroy the machine, damage property, and/or void the warranty.

- Do not tamper with or disable any safety device or operate the machine with a malfunctioning safety device. Request authorized service.



WARNING 12: Electrocution and Electrical Burn Hazards—Electric box doors—Operating the machine with any electric box door unlocked can expose high voltage conductors inside the box.

- Do not unlock or open electric box doors.



WARNING 13: Entangle and Crush Hazards—Guards, covers, and panels—Operating the machine with any guard, cover, or panel removed exposes moving components.

- Do not remove guards, covers, or panels.



WARNING 14: Fire Hazards—Sprinkler and overheat control—Failure to supply water to the sprinkler or to open the manual valve, or failure of the overheat control, eliminates the machine's internal fire protection. Normally the machine stops and water is sprayed into the cylinder if outlet temperature reaches 240 degrees Fahrenheit (116 degrees Celsius).

- Verify the overheat control system and plant fire extinguishers are functioning before operating the machine. Be sure to turn water supply on after testing.
- Keep the manual shut-off test valve open except when testing.
- Test or inspect the system after every automatic actuation, or monthly.



WARNING 15: Explosion and Fire Hazards—Gas train—Operating the machine with damaged or malfunctioning gas valves, safeties, controls, or piping can permit gas to escape into the fire box, cylinder, or laundry room. The enclosure will explode if gas comes in contact with any spark or flame.

- Do not operate the machine with any evidence of damage or malfunction.
- Stop the machine immediately and alert authorities if you smell gas.

5.1.2. Hazards Resulting from Damaged Mechanical Devices



WARNING 16: Multiple Hazards—Operating a damaged machine can kill or injure personnel, further damage or destroy the machine, damage property, and/or void the warranty.

- Do not operate a damaged or malfunctioning machine. Request authorized service.

5.2. Careless Use Hazards

5.2.1. Careless Operation Hazards—Vital Information for Operator Personnel (see also operator hazards throughout manual)



WARNING 17: Multiple Hazards—Careless operator actions can kill or injure personnel, damage or destroy the machine, damage property, and/or void the warranty.

- Do not tamper with or disable any safety device or operate the machine with a malfunctioning safety device. Request authorized service.
- Do not operate a damaged or malfunctioning machine. Request authorized service.
- Do not attempt unauthorized servicing, repairs, or modification.
- Do not use the machine in any manner contrary to the factory instructions.
- Use the machine only for its customary and intended purpose.
- Understand the consequences of operating manually.



CAUTION 18: Goods Damage and Wasted Resources—Entering incorrect cake data causes improper processing, routing, and accounting of batches.

- Understand the consequences of entering cake data.

5.2.2. Careless Servicing Hazards—Vital Information for Service Personnel (see also service hazards throughout manuals)



WARNING 19: Electrocution and Electrical Burn Hazards—Contact with electric power can kill or seriously injure you. Electric power is present inside the cabinetry unless the main machine power disconnect is off.

- Do not service the machine unless qualified and authorized. You must clearly understand the hazards and how to avoid them.
- Abide by the current OSHA lockout/tagout standard when lockout/tagout is called for in the service instructions. Outside the USA, abide by the OSHA standard in the absence of any other overriding standard.



WARNING 20: Entangle and Crush Hazards—Contact with moving components normally isolated by guards, covers, and panels, can entangle and crush your limbs. These components move automatically.

- Do not service the machine unless qualified and authorized. You must clearly understand the hazards and how to avoid them.

- Abide by the current OSHA lockout/tagout standard when lockout/tagout is called for in the service instructions. Outside the USA, abide by the OSHA standard in the absence of any other overriding standard.



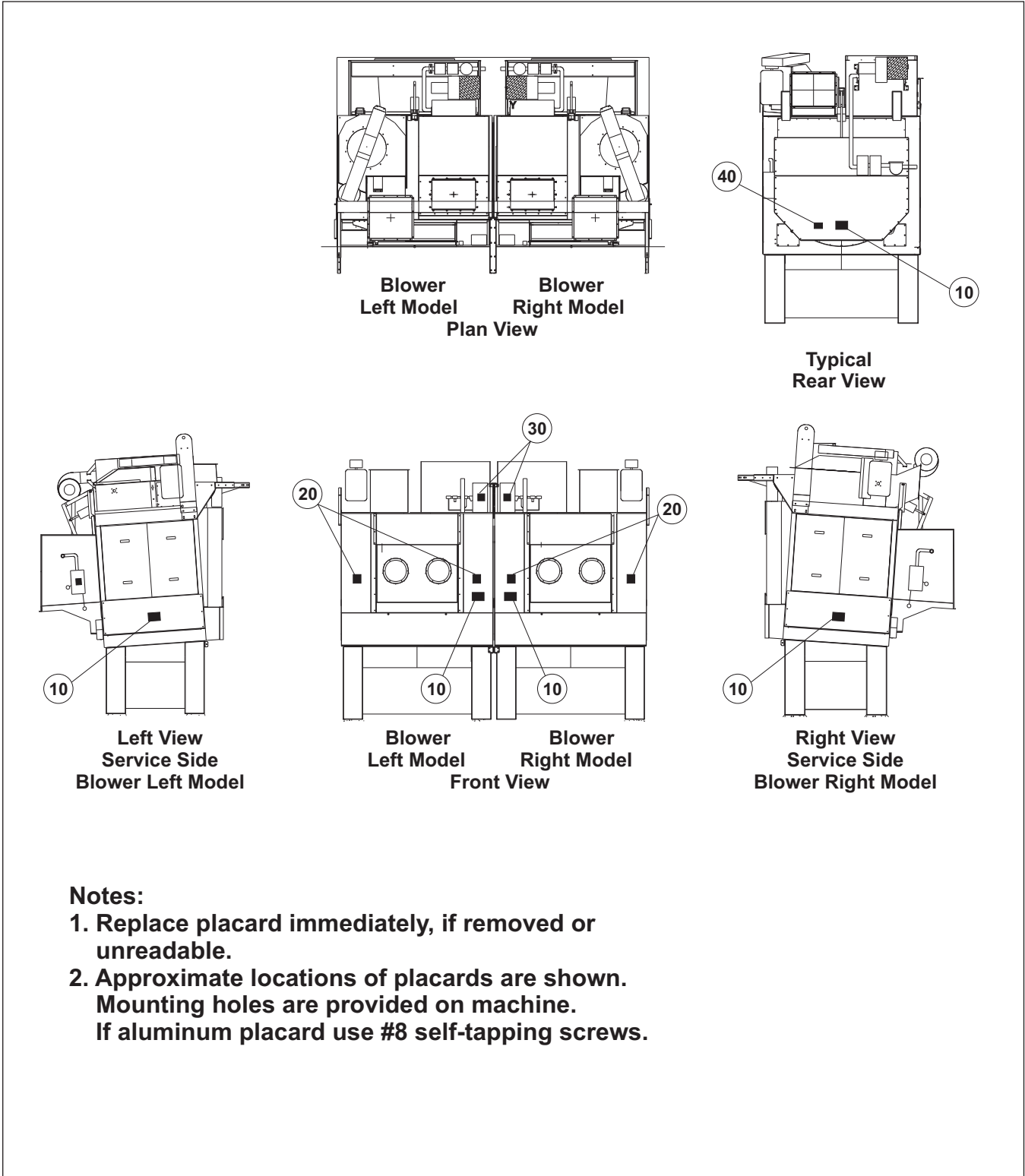
WARNING 21: Confined Space Hazards—Confinement in the cylinder can kill or injure you. Hazards include but are not limited to panic, burns, poisoning, suffocation, heat prostration, biological contamination, electrocution, and crushing.

- Do not enter the cylinder until it has been thoroughly purged, flushed, drained, cooled, and immobilized.

— End of BIUUUS27 —

Safety Placard Use and Placement

5040, 5050, 6450, 6458, 6464, 7272, 7676 and 8282 Dryers



Notes:

- 1. Replace placard immediately, if removed or unreadable.
- 2. Approximate locations of placards are shown. Mounting holes are provided on machine. If aluminum placard use #8 self-tapping screws.

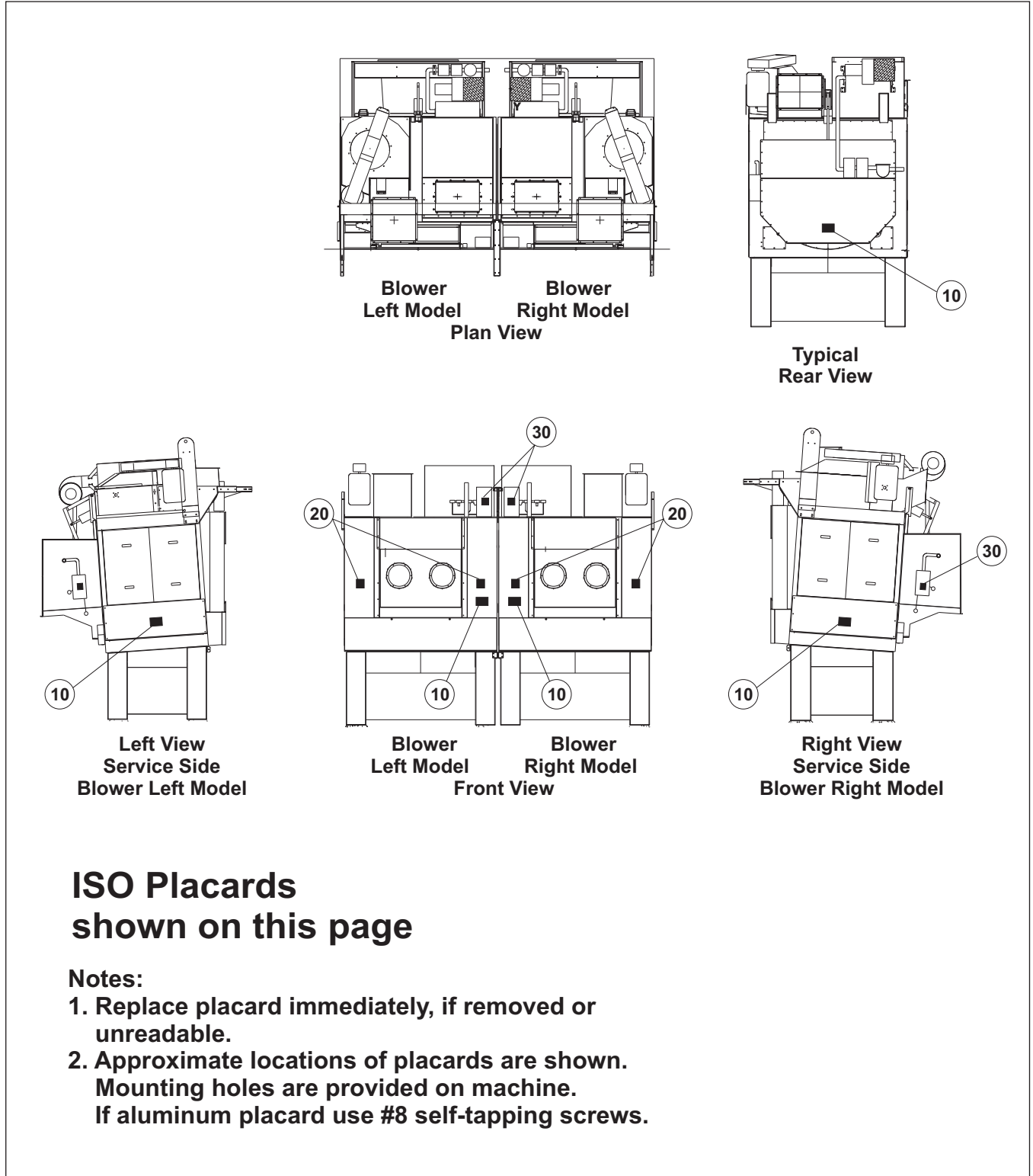
Safety Placard Use and Placement

5040, 5050, 6450, 6458, 6464, 7272, 7676, and 8282 Dryers

Parts List—Safety Placard Use and Placement Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----COMPONENTS-----				
all	10	01 10451B	NPLT:DRYER WARNINGS-TCATA	
All	20	01 10377A	NPLT:ELEC HAZARD LG-TCATA	
all	30	01 10375B	NPLT:ELEC HAZARD SMALL-TCATA	
all	40	01 10699A	NPLT:SERV HZRD-PLYEST-TCATA	

Safety Placard Use and Placement - ISO

5040, 5050, 6450, 6458, 6464, 7272, 7676, and 8282 Dryers



ISO Placards shown on this page

Notes:

1. Replace placard immediately, if removed or unreadable.
2. Approximate locations of placards are shown. Mounting holes are provided on machine. If aluminum placard use #8 self-tapping screws.

Safety Placard Use and Placement - ISO

5040, 5050, 6450, 6458, 6464, 7272, 7676, and 8282 Dryers

Parts List—Safety Placard Use and Placement				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----COMPONENTS-----				
All	10	01 10451X	NPLT:DRYER WARNINGS -ISO	
all	20	01 10377	NPLTE:"WARNING" 4X4	
all	30	01 10375	NPLTE:"WARNING" 2X2	

Service and Maintenance

2

Set the Heating System—Ratio Air Dryer

BNDGUM02.C01 0000341365 C.2 A.3 4/29/21, 8:48 AM Released

This document applies to dryers with a *ratio air* burner. See document BNDGUM01 for gas dryer models with an *air heat* burner.

1. About the Procedure

BNDGUM01.C10 0000344550 C.2 B.2 5/24/22, 8:31 AM Released

The differences between an *air heat* burner and a *ratio air* burner are important with regard to replacement parts and the procedure you use to set or confirm the correct gas and air flows.

Table 1. Current Dryer Models and Burner Types

Burner Type / Dryer Model	5050TG1_	6450TG1_	6458TG1_	6464TG1_	7676TG1_	8282TG1_
Air Heat	only	optional	standard	standard		
Ratio Air		standard	optional	optional	only	only

It can be necessary to set the heating system when the dryer is installed and when components of the gas train are replaced. You must be a technician trained to do work on gas trains and familiar with gas train components.

Necessary test equipment includes:

- A manometer such as Dwyer model 3T294.
- Tubes and fittings to connect to the taps (test ports) shown herein.
- In some cases, a fitting with a valve to control the gas released from the tap.

When you set the heating system, you will do a sequence of steps. In most steps you will make the necessary adjustments to change a measured pressure to match a specified value. Some terms used in this instruction are:


gas train the group of valves and related components that controls the flow of natural gas or propane into the dryer


flame control an electronic module that monitors and maintains a safe flame. Milnor® system dryers use two brands of flame control: **Fireye** (primarily for the USA and Canada) and **Landis + Gyr** (primarily for Europe).

setup mode a method of performing adjustments that activates the appropriate components for a given adjustment step. If your machine has the Fireye flame control, you must use the setup mode to make adjustments.

manual method a method of performing adjustments that runs a dry code manually and permits you to specify certain conditions for a given adjustment step. If your machine has the Landis + Gyr flame control, you must use the manual method to make adjustments.

manometer an instrument to measure fluid pressure

Reset button symbolized  in this procedure, refers to both the physical push button used to cancel a blinking light on the dryer status light panel and to the reset button on the flame control (Fireye or Landis + Gyr). In this procedure, use whichever reset component applies to the task.

Signal Cancel button symbolized  in this procedure, refers to the button on the dryer controller screen used to cancel the operator alarm.

Several types of **Dungs** gas train and the two types of flame control stated above are available to meet different local codes. Applicable models will use one of the types of gas train, corresponding flame control, and corresponding setup method listed in the following table. This instruction describes one general procedure, but indicates where you will do something one way or the other, depending on which of the two setup methods you use (which type of flame control you have).

Table 2. Gas Train and Flame Control Options

Type of Gas Train	Brand of Flame Control	Setup method
Natural Gas, CSA	Fireye	Setup Mode
Propane, CSA	Fireye	Setup Mode
Natural Gas, IRI	Fireye	Setup Mode
Natural Gas, Europe	Landis + Gyr	Manual (dry code) method
Propane, Europe	Landis + Gyr	Manual (dry code) method
Natural Gas, Australia	Landis + Gyr	Manual (dry code) method
Propane, Australia	Landis + Gyr	Manual (dry code) method
Natural Gas, Holland	Landis + Gyr	Manual (dry code) method

2. Summary of Steps and Required Values (Ratio Air)

BNDGUM02.C02 0000341364 C.2 B.2 2/14/22, 2:15 PM Released

Table 3. Applicable Models

Step	Gauge Points ¹	6450TG_		6458TG_, 6464TG_		7676TG_		8282TG_		
		Fireye	L+G	Fireye	L+G	Fireye	L+G	Fireye	L+G	
1	Starting conditions	n. a.	See Section 7.1 : Step 1: Set the starting conditions, page 8							
2	Static (incoming) gas pressure ²	GGG	30 (75)	30 (75)	25 (62)	25 (62)	40 (100)	40 (100)	40 (100)	40 (100)
3	Pilot gas regulator	GGP	3.0 (7.5)	1.3 (3.2)	3 (7.5)	3 (7.5)	3 (7.5)	3 (7.5)	3 (7.5)	3 (7.5)
4	Pilot flame	GGP	2.5 (6.2)	2.5 (6.2)	2.5 (6.2)	2.5 (6.2)	2.5 (6.2)	2.5 (6.2)	2.5 (6.2)	2.5 (6.2)
5	Enable heating	n. a.								
6	Differential air pressure range	GRH and GRL	n.a.	n.a.	n.a.	n.a.	9.5 (23.7) to 10 (24.9)	9.5 (23.7) to 10 (24.9)	9.5 (23.7) to 10 (24.9)	9.5 (23.7) to 10 (24.9)
7g	Differential gas pressure — natural gas (standard)									
	Range with manual butterfly valve full open	CFH and GFL	5.6 (13.9) to 6.0 (14.9)	5.6 (13.9) to 6.0 (14.9)	5.6 (13.9) to 6.0 (14.9)	5.6 (13.9) to 6.0 (14.9)	Record the value measured as explained in the instructions.			
	Acceptable range		4.7 (11.7) to 5.0 (12.4)	4.7 (11.7) to 5.0 (12.4)	4.5 (11.2) to 4.9 (12.2)	4.5 (11.2) to 4.9 (12.2)	5.4 (13.5) to 5.8 (14.4)	5.4 (13.5) to 5.8 (14.4)	5.4 (13.5) to 5.8 (14.4)	5.4 (13.5) to 5.8 (14.4)
	Target		4.9 (12.2)	4.9 (12.2)	4.7 (11.7)	4.7 (11.7)	5.6 (13.9)	5.6 (13.9)	5.6 (13.9)	5.6 (13.9)
7p	Differential gas pressure — propane (optional)									
	Range with manual butterfly valve full open	CFH and GFL	7.0 (17.4) to 7.5 (18.7)	7.0 (17.4) to 7.5 (18.7)	7.0 (17.4) to 7.5 (18.7)	7.0 (17.4) to 7.5 (18.7)	pending	pending	pending	pending

Applicable Models (cont'd.)

Step		Gauge Points ¹	6450TG_		6458TG_, 6464TG_		7676TG_		8282TG_	
			Fireye	L+G	Fireye	L+G	Fireye	L+G	Fireye	L+G
	Acceptable range		4.6 (11.4) to 5.0 (12.4)	4.6 (11.4) to 5.0 (12.4)	4.6 (11.4) to 5.0 (12.4)	4.6 (11.4) to 5.0 (12.4)	pending	pending	pending	pending
	Target		4.8 (12)	4.8 (12)	4.8 (12)	4.8 (12)	pending	pending	pending	pending
8	Minimum fire temperature ABOVE AMBIENT	n. a.	70° F (21° C) to 80° F (27° C)(view on display)							
	Damper setting	n. a.	2							
9	Minimum main air pressure	GAM	1.2 (3)	1.2 (3)	1.2 (3)	1.2 (3)	1.7 (4.2)	1.7 (4.2)	1.5 (3.7)	1.5 (3.7)
—	Maximum main gas pressure	none	40 (100)	40 (100)	35 (87)	35 (87)	50 (124)	50 (124)	50 (124)	50 (124)
10	Minimum main gas pressure	GGL	8 (20)	8 (20)	15 (37)	15 (37)	17 (42)	17 (42)	17 (42)	17 (42)
11	Combustion air pressure switch	GRC	4.5 (11.2)	4.5 (11.2)	10 (25)	10 (25)	2 (5)	2 (5)	2 (5)	2 (5)
12	Maximum back (air) pressure	n. a.	0.8 (2)	0.8 (2)	0.8 (2)	0.8 (2)	0.8 (2)	0.8 (2)	0.8 (2)	0.8 (2)
<p>1. The reference point is atmosphere unless two values are shown for the gauge point.</p> <p>2. Must not exceed. A pressure that exceeds the maximum can damage the regulator.</p>										

3. Adjustment Components

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Figure 1. Gas Adjustment Components (6464TG1_ shown. 7676TG1_ models are similar.)

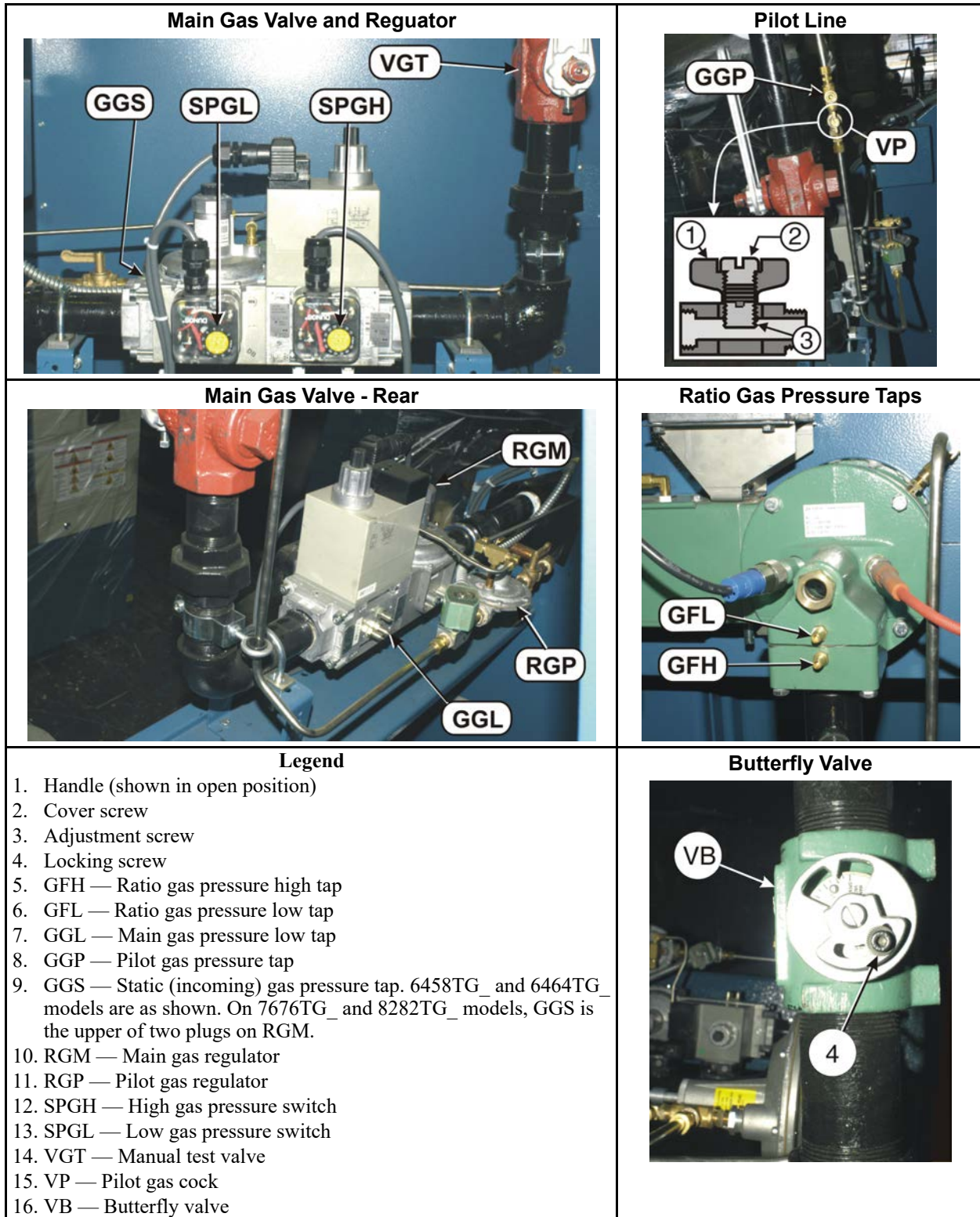


Figure 2. Air Adjustment Components (6464TG1_ shown. Other models are similar.)

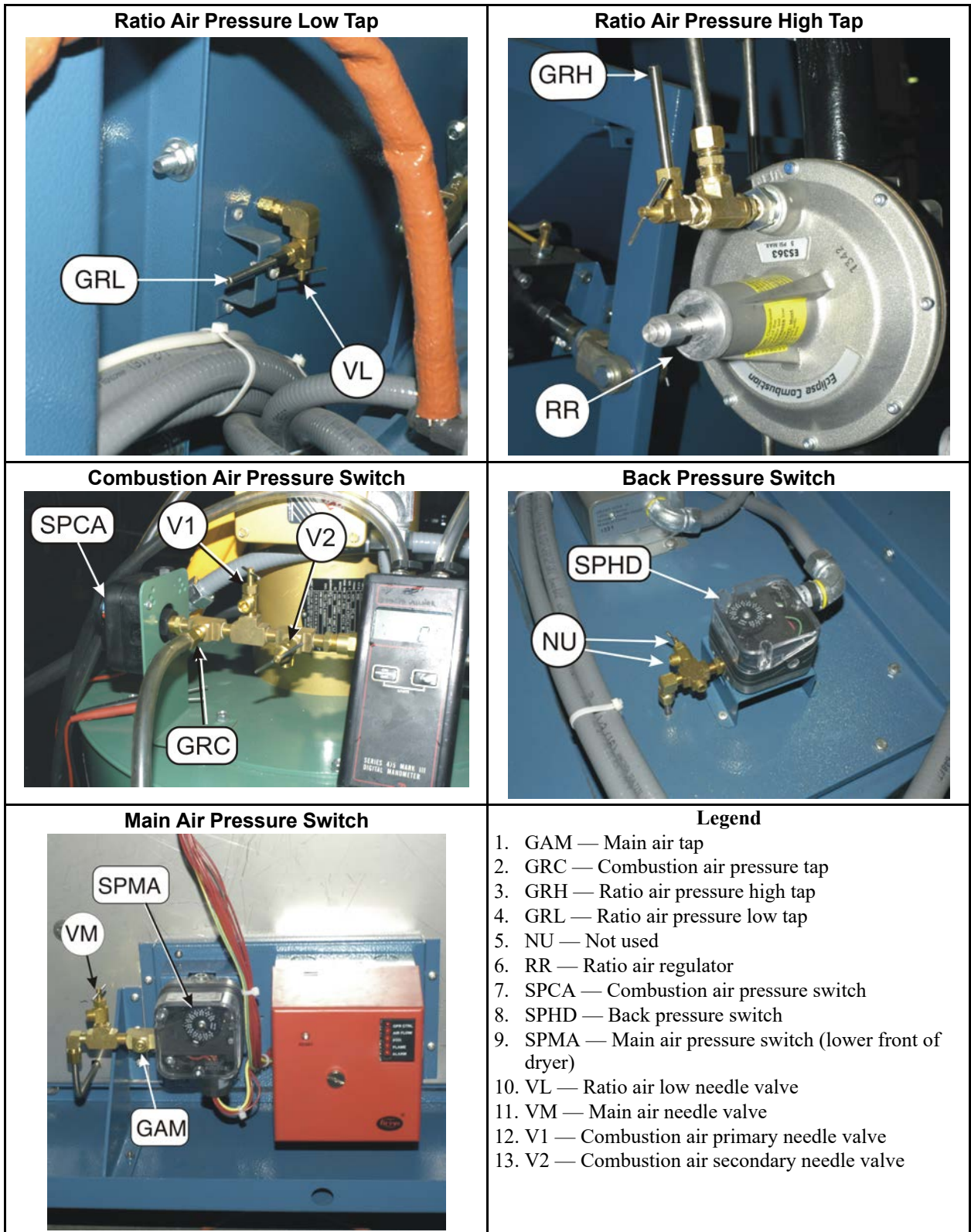
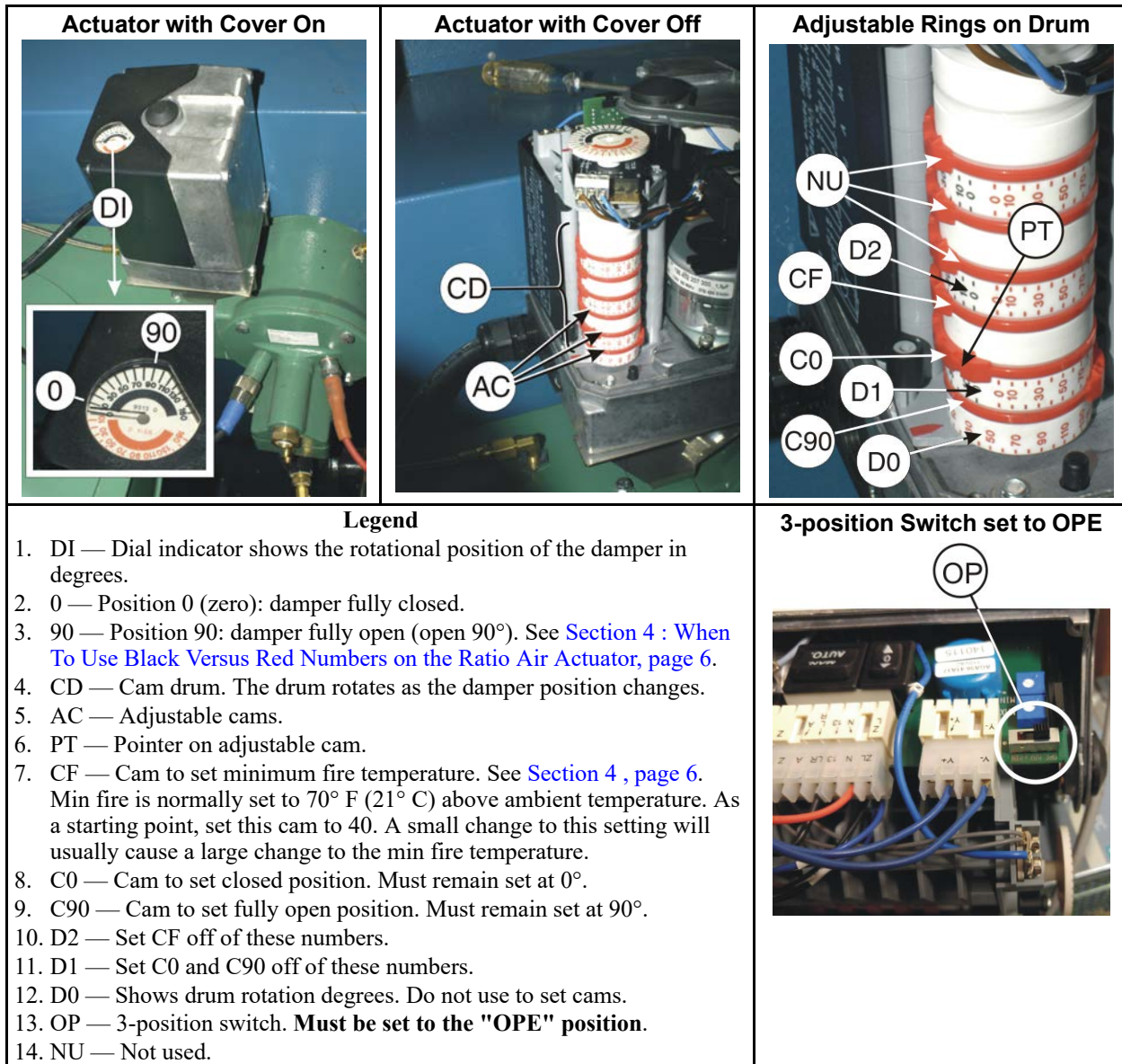


Figure 3. Ratio Air Actuator



4. When To Use Black Versus Red Numbers on the Ratio Air Actuator

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Each cam on the drum has two sets of numbers—one black and one red. You must use the color that corresponds to a left-hand or right-hand dryer. If the eighth character of your dryer model (see your nameplate) is "L" use only the red numbers. If it is an "R" use only the black numbers. For example, for dryer model 6464TG1L, use the red numbers. For model 6464TG1R, use the black numbers.

5. How to Access Setup Mode A to Test SPCA and Mode C to Ignite the Pilot

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Display or Action	Explanation
<div style="border: 1px solid black; padding: 2px; width: fit-content;"> WAITING FOR LOAD ***** </div>	The display after the power up sequence
<div style="border: 1px solid black; padding: 2px; width: fit-content; margin: 0 auto;">MANUAL</div>	Accesses manual mode menu (press <div style="border: 1px solid black; padding: 2px; width: fit-content; margin: 0 auto;">CANCEL</div> to return to automatic).
<div style="border: 1px solid black; padding: 2px; width: fit-content;"> RETURN TO AUTOMATIC 00 </div>	Shows the display in manual mode
<div style="display: flex; justify-content: center; gap: 10px;"> <div style="border: 1px solid black; padding: 2px; width: 20px; text-align: center;">1</div> <div style="border: 1px solid black; padding: 2px; width: 20px; text-align: center;">2</div> </div>	Selects the setup procedure
<div style="border: 1px solid black; padding: 2px; width: fit-content;"> SETUP PROCEDURE 12 </div>	The display with the setup procedure accessed.
<div style="border: 1px solid black; padding: 2px; width: fit-content; margin: 0 auto;">ENTER</div>	Advances to setup mode A (Set Combustion Air)
<div style="display: flex; justify-content: center; gap: 5px;"> <div style="border: 1px solid black; padding: 2px; width: fit-content;">ENTER</div>, <div style="border: 1px solid black; padding: 2px; width: fit-content;">ENTER</div> </div>	Advances to setup mode C (Set Pilot Valve)
<div style="display: flex; justify-content: center; gap: 10px;"> <div style="border: 1px solid black; padding: 2px; width: 20px; text-align: center;">0</div>, <div style="border: 1px solid black; padding: 2px; width: 20px; text-align: center;">0</div> </div>	Selects “RETURN TO AUTOMATIC”

6. How to Manually Control the Main Air Damper and Modulating Gas Valve

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Display or Action	Explanation
<div style="border: 1px solid black; padding: 2px; width: fit-content;"> WAITING FOR LOAD ***** </div>	The display after the power up sequence.
<div style="border: 1px solid black; padding: 2px; width: fit-content; margin: 0 auto;">MANUAL</div>	Accesses the manual load menu
<div style="border: 1px solid black; padding: 2px; width: fit-content;"> SELECT DRY CODE 00 REDRY </div>	
<div style="border: 1px solid black; padding: 2px; width: fit-content; margin: 0 auto;">ENTER</div>	Accepts the selected dry code and prompts for load size
<div style="border: 1px solid black; padding: 2px; width: fit-content;"> ENTER LOAD SIZE 0 FULL LOAD </div>	
<div style="border: 1px solid black; padding: 2px; width: fit-content; margin: 0 auto;">ENTER</div>	Consequences of this action
<div style="border: 1px solid black; padding: 2px; width: fit-content;"> LOAD DRYER WITH REDRY </div>	Ignore this prompt.
<div style="border: 1px solid black; padding: 2px; width: fit-content; margin: 0 auto;">ENTER</div>	Starts the cycle.
<div style="border: 1px solid black; padding: 2px; width: fit-content;"> LOADING </div>	This display appears.
<div style="border: 1px solid black; padding: 2px; width: fit-content;"> 00F TIC TOC 000 VP xx xxxAxxx xxx xxx </div>	This display appears. The VP value alternates with an air value.

Wait for the burner to ignite and for outlet temperature to rise to the programmed value.

	Stops the timer and accesses the manual control panel for temperature, damper and basket rotation.								
<table border="1" style="border-collapse: collapse; width: 100%;"> <tr> <td style="padding: 2px;">TICHTOC</td> <td style="padding: 2px;">LDA</td> <td style="padding: 2px;">MVP</td> <td style="padding: 2px;">BSPD</td> </tr> <tr> <td style="padding: 2px;">xxx+xxx</td> <td style="padding: 2px;">x0x</td> <td style="padding: 2px;">0x</td> <td style="padding: 2px;">xxxx</td> </tr> </table>	TICHTOC	LDA	MVP	BSPD	xxx+xxx	x0x	0x	xxxx	
TICHTOC	LDA	MVP	BSPD						
xxx+xxx	x0x	0x	xxxx						
 or 	Sets the damper position. Hold the keys until the desired damper position appears. Example: D = 2.								
<table border="1" style="border-collapse: collapse; width: 100%;"> <tr> <td style="padding: 2px;">TICHTOC</td> <td style="padding: 2px;">LDA</td> <td style="padding: 2px;">MVP</td> <td style="padding: 2px;">BSPD</td> </tr> <tr> <td style="padding: 2px;">xxx+xxx</td> <td style="padding: 2px;">x2x</td> <td style="padding: 2px;">xxx</td> <td style="padding: 2px;">000</td> </tr> </table>	TICHTOC	LDA	MVP	BSPD	xxx+xxx	x2x	xxx	000	
TICHTOC	LDA	MVP	BSPD						
xxx+xxx	x2x	xxx	000						
 or 	Sets the modulating gas valve (position). Hold the keys until the desired valve position appears. Example: MVP = 255								
<table border="1" style="border-collapse: collapse; width: 100%;"> <tr> <td style="padding: 2px;">TICHTOC</td> <td style="padding: 2px;">LDA</td> <td style="padding: 2px;">MVP</td> <td style="padding: 2px;">BSPD</td> </tr> <tr> <td style="padding: 2px;">xxx+xxx</td> <td style="padding: 2px;">x2x</td> <td style="padding: 2px;">255</td> <td style="padding: 2px;">xxxx</td> </tr> </table>	TICHTOC	LDA	MVP	BSPD	xxx+xxx	x2x	255	xxxx	You can quickly move between minimum fire and maximum fire. The modulating valve position wraps from 000 to 255 and the reverse.
TICHTOC	LDA	MVP	BSPD						
xxx+xxx	x2x	255	xxxx						
	Returns to automatic.								

7. Adjustment Steps

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Refer to [Section 2 : Summary of Steps and Required Values \(Ratio Air\), page 2](#) while you do these procedures. In these steps, mount the manometer vertically and use the high pressure scale, except where stated otherwise.



WARNING: Explosion hazard — Improper maintenance procedures can cause the rapid release of gas.



- ▶ You must be an approved technician.
- ▶ Make sure you can quickly shut off gas at the external valve.
- ▶ Do not open gas taps (test ports) until you are ready with the condition and materials necessary to avoid the hazardous release of gas.



WARNING: Crush and entangle hazard — Moving components can crush and entangle body parts.



- ▶ Use extreme caution when you work near moving components.

7.1. Step 1: Set the starting conditions

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Most of these are temporary adjustments to make sure that you can achieve the subsequent settings

Main gas regulator (RGM in [Figure 1, page 4](#)) Turn the top adjustment screw fully clockwise (fully open). **This is the final adjustment. RGM remains at this setting.**

Ratio regulator (RRM in [Figure 2, page 5](#)) Set the top adjustment screw as stated below.

- 6450TG_ models—turn full counter-clockwise then 7.5 turns clockwise
- 6464TG_ models—turn full counter-clockwise then 2.75 turns clockwise
- 7676TG_ models—turn full counter-clockwise then 24 turns clockwise

Manual butterfly valve (VB in Figure 1, page 4) Release the locking screw (item 4), open the valve fully then tighten the locking screw.

Minimum fire cam (CF) on ratio air actuator (Figure 3, page 6) Set the pointer to 40° open.

Low gas pressure switch (SPGL in Figure 1, page 4) Set the dial to the lowest value.

High gas pressure switch (SPGH in Figure 1, page 4) Set the dial as stated below. **This is the final adjustment. SPGH remains at this setting.**

- 6464TG1_ models, set the dial to 35
- 7676TG1_ models, set the dial to 50

Combustion air pressure switch (SPCA in Figure 2, page 5) Set the dial to the lowest value.

Main air pressure switch (SPMA in Figure 2, page 5) Set the dial to the lowest value.

7.2. Step 2: Set static (incoming) gas pressure

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1. Shut off the gas supply to the machine.
2. See [Figure 1, page 4](#). Attach one side of the manometer to **GGS**. Leave the other side open to the atmosphere.
3. Supply gas to the machine.
4. Adjust the incoming gas (upstream from the dryer) as close as possible to the maximum static gas pressure listed in [Table 3, page 2](#). This pressure is necessary for further adjustments. Pressures higher than specified can damage the regulator.



7.3. Step 3: Set regulated pilot gas pressure

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1. Use SETUP MODE C (see [Section 5 : How to Access Setup Mode A to Test SPCA and Mode C to Ignite the Pilot, page 7](#)) to turn on the **pilot gas valve**. If this is the first time the dryer has been fired, it can be necessary to exit the SETUP MODE and return to SETUP MODE C up to six times before the pilot line fills with gas and the pilot ignites.
2. See [Figure 1, page 4](#). Attach one side of the manometer to **GGP**. Leave the other side open to the atmosphere.
3. Remove the cover screw (2) from **VP**.
4. Turn the set screw (3) counterclockwise until the top of the screw is about 1/8 inch (3 mm) below the top of the valve handle. **Do not allow the set screw to come out of the valve. Gas will escape.**
5. Adjust **RGP** until the manometer displays the value specified in [Table 3, page 2](#).

7.4. Step 4: Set pilot flame gas pressure


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If the flame control trips during this step, press , and  to reset it.

1. Look at [Figure 1, page 4](#). Leave the manometer connected to **GGP** and to the atmosphere.
2. Close **VGT**.
3. Remove the center screw (item 2) from **VP**.
4. Turn the adjustment screw (3) on **VP** clockwise, until the manometer shows the value specified in [Table 3, page 2](#).
5. Replace the cover screw (2) in **VP**.
6. Open **VGT**.

7.5. Step 5: Enable heating

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1. See [Section 6 : How to Manually Control the Main Air Damper and Modulating Gas Valve, page 7](#). Run a drycode.
2. Verify ignition. Watch for the Main Gas status light () to illuminate.
3. Watch the display for the programmed temperature to be achieved.
4. Command minimum fire (MVP = 001) and the main air damper to position 2 (D = 2)



CAUTION: **Risk of over-heating** — Two of the subsequent steps must be performed at maximum fire (MVP = 255). If the dryer is already hot, safety apparatuses can trip and cause the sprinkler to actuate in as little as 15 seconds at maximum fire.



- ▶ Be prepared to return to minimum fire (MVP = 001) and allow the dryer to cool down if you cannot complete the step quickly. See note below.
- ▶ Restart the step several times, if necessary, until you can accomplish it quickly.



NOTE: Technically, minimum fire is the value 000 (MVP = 000). However, this instruction sometimes calls for the value 001, which achieves minimum fire without the risk that the controller will skip to the discharge sequence at the end of the drycode. This happens if the controller detects MVP = 000 in an over-heat condition.

7.6. Step 6: On 7676TG1_ and 8282TG1_ models, check maximum fire differential air pressure

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NOTICE: Skip this step on 6450TG1, 6458TG1, and 6464TG1_ models.

1. See [Figure 2, page 5](#). Connect the manometer between GRL and GRH.
2. See caution statement above. Command maximum fire (MVP = 255) and main air damper fully open (D = 0).
3. Take note of the manometer pressure reading.

4. Return to minimum fire (MVP = 001) and main air damper position 2 (D = 2).
5. Confirm that the pressure is within the range specified in [Table 3, page 2](#). If not, see below notice.



NOTICE: Insufficient combustion air—If you measured insufficient differential pressure, go no further. There is a problem with the combustion air supply, perhaps with the combustion air motor or the ratio air actuator. You will not be able to complete the adjustment steps.

- Troubleshoot then restart the adjustment steps.

7.7. Step 7: Set the maximum fire differential gas pressure

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1. See [Figure 1, page 4](#). Connect the manometer across **GFH** and **GFL**.
2. Loosen the locking screw (item 4) on **VB**.
3. See caution statement above and [Section 6, page 7](#). Command maximum fire (MVP = 255) and main air damper fully open (D = 0).
4. Take note of the manometer pressure reading.
5. Command minimum fire (MVP = 001) and main air damper position 2 (D = 2).
6. In Step 1, you set the manual butterfly valve fully open. On any 64_TG1 model, confirm that the differential pressure is within or above the range given in [Table 3, page 2](#). If not, see below notice. On any 76_TG1 or 82_TG1 model, record the value read on the manometer and continue.
7. On any 64_TG1 model, if the measured pressure is **above** the specified range, command maximum fire (MVP = 255) and main air damper fully open (D = 0). Adjust VB until the differential pressure is within the acceptable range specified in [Table 3, page 2](#).
8. On any 76_TG1 or 82_TG1 model, command maximum fire (MVP = 255) and main air damper fully open (D = 0). Attempt to adjust VB until the differential pressure is within the acceptable range specified in [Table 3, page 2](#). If it is not possible to achieve the acceptable range, see the below notice.
9. Command minimum fire (MVP = 001) and main air damper position 2 (D = 2).
10. Tighten the locking screw (item 4) on **VB**.



NOTICE: Insufficient gas pressure.—If the differential gas pressure is below the range given in [Table 3, page 2](#) with the butterfly valve fully open, go no further. There is a problem with the gas supply. It will not be possible to make the subsequent adjustments.

- On any 64_TG1 model, troubleshoot then restart the adjustment steps. If the differential pressure is close to the required range, you can open the ratio regulator (RR in [Figure 2, page 5](#)) an additional amount, not to exceed 2 additional turns. On any 76_TG1 or 82_TG1 model, contact the Milnor factory for assistance. You may need to provide the value recorded in Step 6, above.

7.8. Step 8: Set the minimum fire temperature

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Minimum fire temperature is the lowest inlet temperature that will sustain a good quality (blue) flame. The rule of thumb is 70° F (21° C) above the ambient temperature in the laundry.

1. Determine the minimum fire temperature for your laundry: ambient temperature + 70° F (21° C).
2. With minimum fire (MVP = 001) commanded, observe the inlet temperature on the display.
3. See [Figure 3, page 6](#). In small increments, adjust the minimum fire cam **CF** on the damper actuator to a higher (hotter) or lower (cooler) number as required. The system will adjust to a lower (cooler) setting. If you set the cam higher (hotter), you must command maximum fire (MVP = 255) for 15 seconds then return to minimum fire (MVP = 001) and let the system settle to the new temperature.
4. With each change, observe the inlet temperature on the display. Allowing time for the temperature to react to the change.

7.9. Step 9: Test the main air pressure switch and set minimum main air pressure

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The Main Air Pressure Switch (SPMA) must extinguish the gas flame when main air pressure falls below the value specified in [Table 3, page 2](#). This should occur when the dial on the switch is set to the this value (in Inches H₂O). However, it is necessary to confirm, with a manometer, that the switch trips at this actual pressure.

1. See [Section 6, page 7](#). Command the main air damper fully open (D = 0).
2. See [Figure 2, page 5](#). Turn the dial on **SPMA** counterclockwise, to the lowest value (____ Inches H₂O).
3. Attach one side of the manometer to **GAM** (the lower pressure). Leave the other side open to the atmosphere (the higher pressure).
4. Open needle valve **VM**, which will divert air pressure away from SPMA, simulating a low main air condition. Adjust **VM** until the manometer displays the value shown in [Table 3, page 2](#). You will likely see the reading fluctuate. Just get the reading to stay as close to the required value as possible.
5. Have a helper observe the main air low light () on the status light panel, which should be off. **Very slowly** turn the dial on **SPMA** clockwise until the light illuminates. Again, because of the fluctuating air pressure, the light will probably start to blink on and off. It is sufficient to stop turning the switch dial at this point.



TIP: Instead of observing the main air low light, you can place a volt meter across the common and normally open terminals of SPMA. When the reading drops from 120VAC to zero (or starts to fluctuate between the two), stop turning the dial.

6. Observe the dial setting on **SPMA**. It must be within 1 Inch H₂O of the value shown in [Section 2, page 2](#). If not, suspect a bad pressure switch.
7. Close **VM** fully.

7.10. Maximum main gas pressure


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High main gas pressure was set on the high gas pressure switch (SPGH) in Step 1. No other action is necessary.

7.11. Step 10: Set minimum main gas pressure



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The Low Gas Pressure Switch (SPGL) must extinguish the gas flame when gas pressure falls below the value specified in [Table 3, page 2](#). This should occur when the dial on the switch is set to the this value (in Inches H₂O). However, it is necessary to confirm, with a manometer, that the switch trips at this actual pressure.

1. See [Section 5, page 7](#) Command minimum fire (MVP = 000).
2. See [Figure 1, page 4](#). Turn the dial on **SPGL** counterclockwise to the lowest value (_____ Inches H₂O).
3. Attach one side of the manometer to **GGL** (main gas pressure low tap). Leave the other side open to the atmosphere.
4. Start with the **external gas shut-off valve** open. Slowly close this valve to simulate a low gas pressure condition. Stop when the manometer displays the value specified in [Table 3, page 2](#).
5. Have a helper observe the gas pressure low light () on the status light panel, which should be off. Slowly turn the dial on **SPGL** clockwise (higher) until the light illuminates.



TIP: Instead of observing the combustion air low light, you can place a volt meter across the common and normally open terminals of SPGL. When the reading drops from 120VAC to zero (or starts to fluctuate between the two), stop turning the dial.


6. Observe the dial setting on **SPGL**. It must be within 1 Inch H₂O of the value shown in [Section 2, page 2](#). If not, suspect a bad pressure switch.
7. Open the external gas shut-off valve fully.
8. The status light illuminates briefly, then blinks. The burner should ignite as soon as pressure is restored. Press  and  to extinguish the status light.

7.12. Step 11: Test the combustion air pressure switch and set the switch

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The Combustion Air Pressure Switch (SPCA) must extinguish the gas flame when combustion air pressure falls below the value specified in [Table 3, page 2](#). This should occur when the dial on the switch is set to the this value (in Inches H₂O). However, it is necessary to confirm, with a manometer, that the switch trips at this actual pressure.

1. Access Setup Mode A (see [Section 5, page 7](#)) on the controller.
2. See [Figure 2, page 5](#). Turn the dial on **SPCA** counterclockwise to the lowest value (2 Inches H₂O).
3. Attach one end of the manometer to **GRC** and the other side to atmosphere (see [Figure 2, page 5](#)).

4. There are two needle valves (**V1** and **V2**) in the line that supplies air pressure to **SPCA**. When you open either or both of these valves, this diverts some of the pressure away from **SPCA** and simulates a low combustion air condition. Open the valve(s) until the manometer displays the value shown in [Section 2 , page 2](#). You will likely see the reading fluctuate. Just get the reading to stay as close to the required value as possible.
5. Have a helper observe the combustion air low light () on the status light panel, which should be off. Slowly turn the dial on **SPCA** clockwise until the light illuminates. Again, because of the fluctuating air pressure, the light will probably start to blink on and off. It is sufficient to stop turning the switch dial at this point.



TIP: Instead of observing the combustion air low light, you can place a volt meter across the common and normally open terminals of **SPCA**. When the reading drops from 120VAC to zero (or starts to fluctuate between the two), stop turning the dial.

6. Observe the dial setting on **SPCA**. It must be within 1 Inch H₂O of the value shown in [Section 2 , page 2](#). If not, suspect a bad pressure switch.
7. Close **V1** and **V2** fully.

7.13. Step 12: Set maximum main air back pressure

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See [Figure 2, page 5](#). The dial on **SPHD** is set at the factory to the value specified in [Table 3, page 2](#). If the maximum back pressure is exceeded, this switch trips. This causes the message "Back pressure high" or "Clean the lint screen" to appear on the controller display to indicate that a lint screen may be blocked. It does not stop dryer operation. It may be necessary to adjust this switch slightly once the machine is connected to the laundry ductwork. Air pressure in the plenum for this dryer may be affected by the ductwork configuration and by adjacent dryers.

It is difficult to adjust **SPHD** with a manometer. Initially, this switch was set with the dial alone (the marks on the dial show the specified value). If the message appears too frequently, turn the dial to a higher value. If the message does not appear when it should (when a lint screen is blocked) turn the dial to a lower value.

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Fire Safety System Operation and Maintenance

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NOTICE: If the fire safety system is in operation (if there is a flow of water from the rear of the dryer)—go to [Section 5 : If Water Flow Occurs, page 5](#).

fire safety system the water nozzles and related equipment that put water in the dryer to stop a fire in the basket.

Water flow will start automatically if the temperature becomes too high, as told in [Section 1 : Fire Safety Functions and Components, page 1](#). You can also start it manually. Pull the operation handle or use the control panel as told in [Section 4 : How to Do a Test of the Fire Safety System, page 4](#). The system will start a flow of water. The water will go into the basket through the perforations. Do a test of this system at the intervals given in the routine maintenance schedule.

1. Fire Safety Functions and Components

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This section gives the fire safety functions and components for 6464_ and 7272_ models. Components and their locations can be different on other dryer models but the functions are the same.

Table 1. Fire Safety Functions for 6464_ and 7272_ Dryer Models

Sensor type	Temperature switch (closes at specified temperature)			Thermocouple (gives continuous temperature data to the controller)		
Sensor name	ST225-1 & 2	ST550A & B	STBB	T3		
Location	Basket/outlet duct (Figure 1, page 2, Figure 3, page 2, Figure 4, page 2)	Inlet duct (Figure 1, page 2, Figure 2, page 2)	At burner (Figure 1, page 2, Figure 5, page 2)	Outlet duct (Figure 3, page 2)		
Safety limit (the temperature or condition that causes the given result)	225° F (107° C)	550° F (288° C)	175° F (79° C)	–Three safety limits in software–		
				5° F increase for 15 seconds or 15° F increase for 5 seconds during min fire*	Higher than 220° F (104° C) for 5 seconds**	240°F (116°C)
Occurs when temperature is too high	Water flows and all dryer actions stop.	Flame goes off. If the flame will not come on, see the line below this one.		Each step before the cooldown is subsequently cancelled while the condition continues.		Water flows and all dryer functions stop.
Display when temperature is too high	THREE WIRE DISABLED error and operator alarm.	Initially none. If the flame will not come on, the CHECK ERROR LIGHTS error and operator alarm occur.		The controller shows “MINF” and puts data in the record of dry cycle details.	The controller shows “>220” and puts data in the record of dry cycle details.	OUTLET TEMP EXCEEDED 240 Df - POWER DOWN error and operator alarm.
Necessary procedure	See Section 5 : If Water Flow Occurs, page 5	If the error given in the line above this one occurs, see “Error Messages” in the operator guide.		See Section 2 : About the Min Fire and Outlet Temperature Exceeded 220° Faults, page 3		See Section 5 : If Water Flow Occurs, page 5
* This does not apply to steam dryers.						
** This does not apply to steam dryers if they do not use modulation.						

Figure 1. Component Locations for 6464_ Models

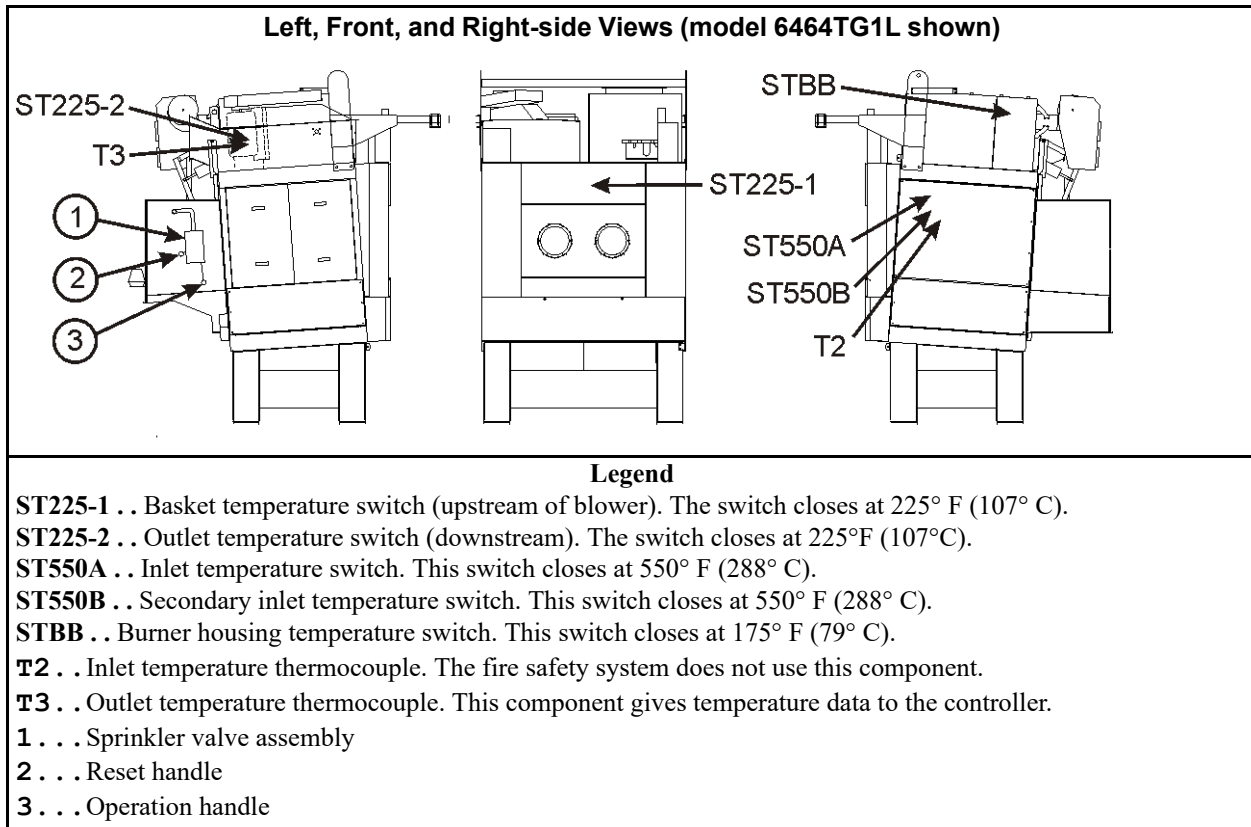


Figure 2. View of ST550A, ST550B and T2

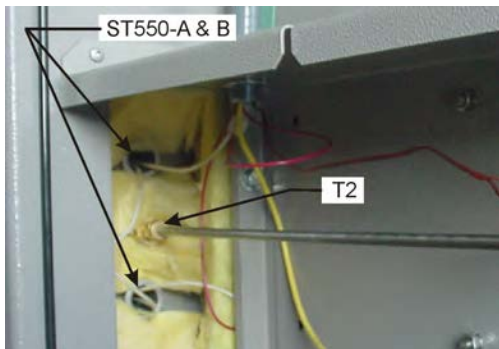


Figure 3. View of ST225-1

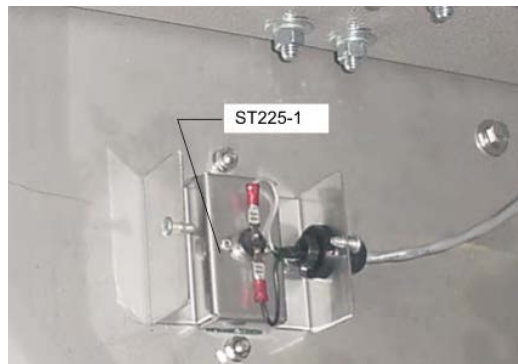


Figure 4. View of ST225-2 and T3

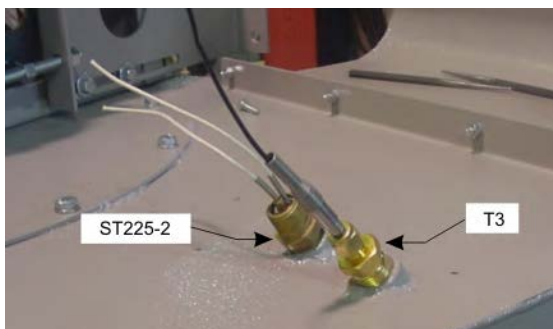


Figure 5. View of STBB



2. About the Min Fire and Outlet Temperature Exceeded 220° Faults

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The function of these faults is to prevent conditions that can cause a fire. The controller does the necessary steps. There are no other steps for the operator to do immediately. But the controller puts data about the fault in the record of dry cycle details. These faults usually cause unsatisfactory operation. To prevent these faults, it can be necessary to change some procedures as told in the subsequent sections. Heat system adjustments and repairs are not routine maintenance. Speak to your dealer or Milnor®.

2.1. Min Fire (MINF)

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This condition applies to dryers that use gas or propane. Minimum fire is when the controller tells the modulating gas valve to go to the position 000. The correct condition is when the gas valve is open a small, stable increment. Under this condition, a **min fire** fault occurs if the controller senses that the outlet temperature increases. This fault usually shows that the goods became too hot and could catch fire. (One more symptom is if the goods have a burned smell.) When this fault occurs, the controller immediately goes to the subsequent cool down step. Some causes of **min fire** faults include:

- **The goods are held against the basket**—The correct condition is that the goods tumble in the basket. If the basket speed is too high, centrifugal force can hold the goods against the basket. Then the part of the goods that is against the basket can become too hot.
- **The gas valve does not operate correctly**—For example, the valve throttle cannot move down fully because it is damaged. This can prevent the min fire position.
- **Min fire is set too high**—The min fire position must be adjusted correctly when the gas and air as told in the procedure to set the heat system. Damage to components can cause this adjustment to change.

2.2. Outlet Temperature Exceeded 220° (degrees Fahrenheit)

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This fault applies to all dryers except those with steam valves that do not modulate. The value 220° F (104° C) is 5° F (3° C) below the temperature that will close the outlet temperature switches (Fenwal switches) and start water flow. It cancels each subsequent heat step if the outlet temperature is higher than 220° F (104° C) for five seconds or more at the start of the step. This fault can also occur if the goods are held against the cylinder or the gas valve is damaged. The function of this fault is to make water flow not necessary, if the goods are not on fire. But if the goods catch fire, the temperature switches will quickly close to start water flow.

3. How to Prevent Water Flow When No Fire Occurs

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If water flow occurs when there is no fire, two possible causes are:

- **A temperature switch is damaged.** This is the usual cause. For example, material can hit a temperature probe and bend it. This can be a piece of goods that goes through a space where



seals are worn. It is necessary to replace a damaged probe. The probe can also give an incorrect value if it has plastic contamination. It is necessary to remove the contamination.

- **Temperatures are not in the correct range.** The conditions described in [Section 2.1 : Min Fire \(MINF\), page 3](#) can cause water flow if they are severe enough.

If water flow occurs when there is no fire, correct the cause. **Do not remove the fire safety system from operation.** If a fire occurs, this system is your first and best protection against a fire that is out of control.

4. How to Do a Test of the Fire Safety System

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1. **Prevent a new load:** Set the **Load Allowed/ Not Allowed** () switch to **Not Allowed** () to prevent a new load.
2. **Let the dryer empty:** Let the dryer operate until it releases the load it has.
3. **Close the manual water valve:** Close the valve to prevent water flow. This valve is on the sprinkler assembly. The assembly is usually on the side of the dryer discharge shroud.
4. **Start a test of sprinkler AUTOMATIC operation:**
 - If there is a controller on the dryer, see “Manual Mode Menu Functions” in the reference manual.
 - If this dryer is part of a Dryer/Shuttle (Drynet™) system, do the steps listed below at the Drynet™ controller:
 - a. Select **Admin Logon** and enter the administrator password.
 - b. Select (click) the display for the dryer you will do the test on.
 - c. Select (click) **Manual** mode.
 - d. Go to **Sprinkler Functions** on the right side of the screen and select (click) **Sprinkler [Off]** to release the sprinkler valve. This is a toggle. The display shows **Sprinkler [On]**.
5. Examine the automatic sprinkler valve.



CAUTION: Sluggish valve operation — can interfere with fire suppression.



- ▶ Remove any build-up of foreign matter on components.
- ▶ Make sure components move freely.

6. **Let the water flow for a short while:** Open the manual valve on the sprinkler assembly. Make sure that water flows from the rear of the dryer. Close the valve for the subsequent part of the test.
7. **Set the system again:** Pull the sprinkler reset handle down fully. It must latch.
8. **Start a test of sprinkler MANUAL operation:** Select a dry code and run it manually.



CAUTION: The manual water valve must be closed to prevent water flow during this test.

9. **Operate the fire safety system manually:** When the heat source starts to make heat, pull down the sprinkler operation handle.
10. **Make sure that a shutdown occurs:**
 - The automatic valve opens (the reset handle releases).
 - The THREE WIRE DISABLED message appears.
 - The operator alarm sounds.
 - All dryer functions stop.
11. **Stop the dry code.**
12. **Set the system again:** Pull the sprinkler reset handle down fully. It must latch.
13. **Open the manual valve.**



WARNING: A closed manual valve — will prevent water flow in an emergency.



▶ Make sure the manual valve is open and remains open during operation.

14. **Put the dryer in operation again.**

This concludes the fire safety system test.

5. If Water Flow Occurs

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A serviceable fire safety system will operate if a fire in the basket occurs. But it can also operate for other causes. Temperature switches (Fenwal switches) in the outlet duct operate the system at 225° F (107° C). If the Fenwal switches are not serviceable, the dryer software operates the system at 240° F (116° C).

1. **Examine the dryer condition:** If there is a fire, let water flow continue until the fire is extinguished.



CAUTION: Use extreme care if you must look through the door glass or get near a part of the machine.

2. **Set the system again when it is safe:**






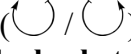
- a. Turn the Master switch off (⊗), then on (⊙) again. If the software caused the fire safety system to operate, this is necessary to remove the "Desires Sprinkler" output signal.
- b. Pull the sprinkler reset handle down fully. It must latch.

This step helps to keep water damage to a minimum and allows you to use the manual controls.

3. **Did a fire occur?**

- **NO:** Put the dryer in operation again.
- **YES:** Continue these steps.

4. **Do a test of basket movement:**

- a. Set the **Load Allowed/Not Allowed** () switch to **Not Allowed** () to prevent a new load.
- b. Press **Start** (). The operator alarm stops and the display shows WAITING FOR LOAD. LOADING NOT ALLOWED.
- c. Set the **Automatic/Manual Rotation** switch () to **Manual Rotation** ()
- d. Hold the **Jog Direction** switch () in one of the two directions **no longer than necessary to make sure that the basket turns.**

5. **Did the basket turn?**

- **NO:** Stop. Repairs are necessary. Consult your dealer or the Milnor® factory.
- **YES:** Continue these steps.

6. **Carefully remove the goods:** Use the manual controls to release the goods.



WARNING: Hot goods — can catch fire spontaneously,



- ▶ Keep fire equipment available.
- ▶ Stay away from the goods.


7. **Remove power. Look for damage.** With power removed from the machine, examine the full machine for damage.

Look carefully at the air seals, support rollers, primary blower, and electrical cables on top of the machine. Also examine electrical components for moisture.

8. **Connect power. Examine dryer functions:** In the manual mode, operate all outputs. For example, the gas valve, lint removal.

9. **Damage?**

- **YES:** Stop. Repairs are necessary. Consult your dealer or the Milnor® factory.
- **NO:** Continue.

10. **Put the dryer in operation again:** Put all manual controls in the automatic position () again.

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BIPD6M03 (Published) Book specs- Dates: 20100326 / 20100326 / 20100326 Lang: ENG01 Applic: PD6 PDJ PDP

Felt Seal Inspection and Maintenance

Milnor® 5040xxxx, 6458xxxx, and 7272xxxx dryers in current production use two felt seals and a Nomex® flap seal where the rotating basket front ring meets the stationary shell front. These seals help to retain heat and prevent goods from squeezing between the basket and the shell front.

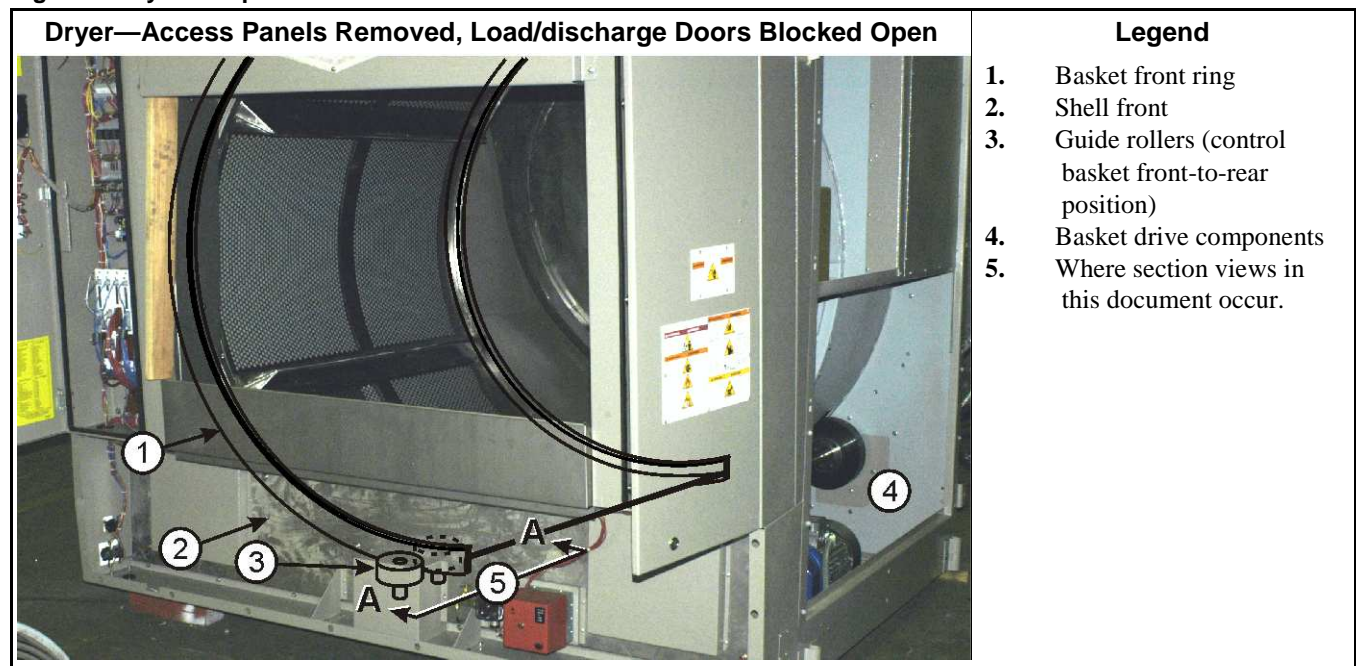


WARNING 1: Explosion hazard—If the basket seals deteriorate or spread apart, goods can become caught between the basket and shell front or get sucked into the blower wheel causing blower to fail and expel metal fragments at high speed. Bystanders can be struck.

- Ensure seals are functioning properly through regular inspection and maintenance.
- Do not indiscriminately change the basket tracking adjustment.

Various drawings showing the seals and how to work with them are provided. These drawings are longitudinal sections through the bottom of the basket, at the location indicated in [Figure 1](#).

Figure 1: Dryer Components Pertinent To This Work



1. Inspecting the Seals and Selecting Replacement Seals



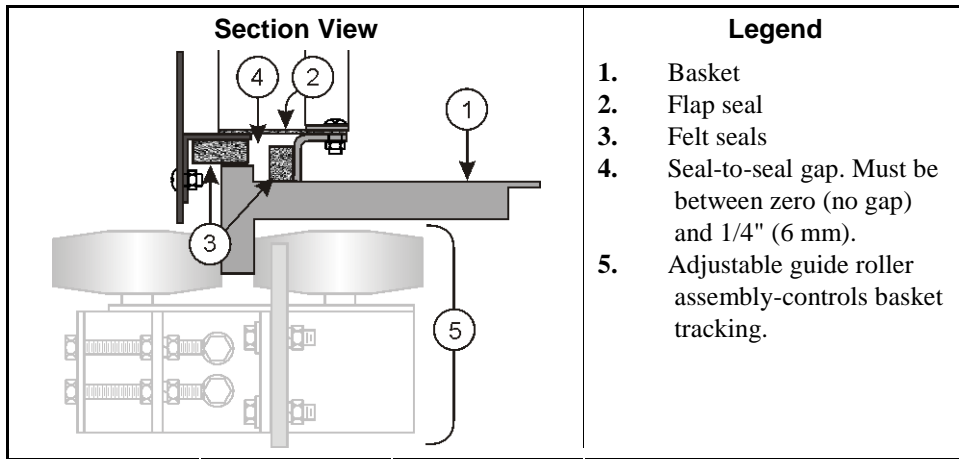
WARNING 2: Burn and Crush hazards—Hot goods and machine surfaces within a recently operated dryer can cause serious burns on contact. The turning basket or shifting goods can crush body parts. The machine can start unexpectedly if not externally disconnected from power. The weight of goods or a person can cause the basket to turn.

- Do not service machine unless qualified and authorized.
- Unload goods, lockout/tagout power at the external disconnect switch, block the doors open, mechanically restrain the drive chain to prevent basket rotation, ventilate and illuminate the dryer interior before entering the basket.
- Lockout/tagout power at the external disconnect before accessing guide rollers.
- Never place fingers in the basket-to-shell front gap. Use only tools.

1. With the dryer empty of goods, prepare for safe entry as follows:

- a. Use Manual mode to open both doors then use wood blocking to block the doors open.
 - b. Lockout/tagout power at the external disconnect switch.
 - c. Mechanically restrain the drive chain (as with wood blocking and c-clamps).
 - d. Ventilate and illuminate the basket interior as needed.
2. Once all appropriate precautions are observed (see [warning statement 2](#)), enter the basket.
 3. Referring to [Figure 2](#), lift the flap seal and inspect the felt seals.
 - If the seals are deteriorated, replace them as explained in [Section 2 “Seal Replacement”](#).
 - If the the seals are in good condition, but the seal-to-seal gap exceeds 1/4" (25 mm), add felt, as explained in [Section 3 “How To Close a Front Seal Gap”](#).
 - Otherwise, return the dryer to service.

Figure 2: Inspecting Seals



2. Seal Replacement

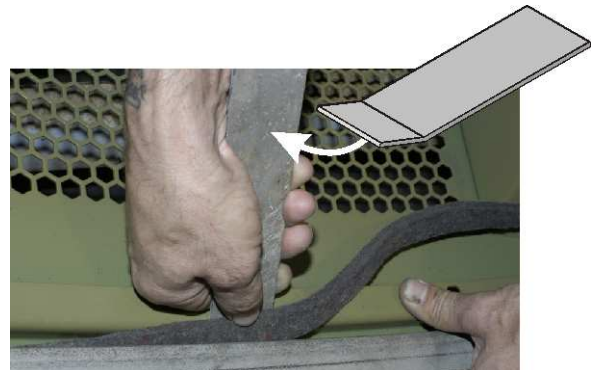
Refer to your "Cylinder Installation" parts document for seal and related component part identification. If you order the silicone rubber flap seal used on older models, you will receive the newer Nomex® seal, which should be used instead. 3M Rubber and Gasket Adhesive #1300, used to glue the felt seals in place is available from Milnor in one pint cans (Milnor P/N 20C044).

1. If replacing the front-most seal, fabricate the tools shown in [Figure 3](#) and [Figure 4](#).

Figure 3: Adhesive applicator—1" paint brush, bristles held at an angle with tape



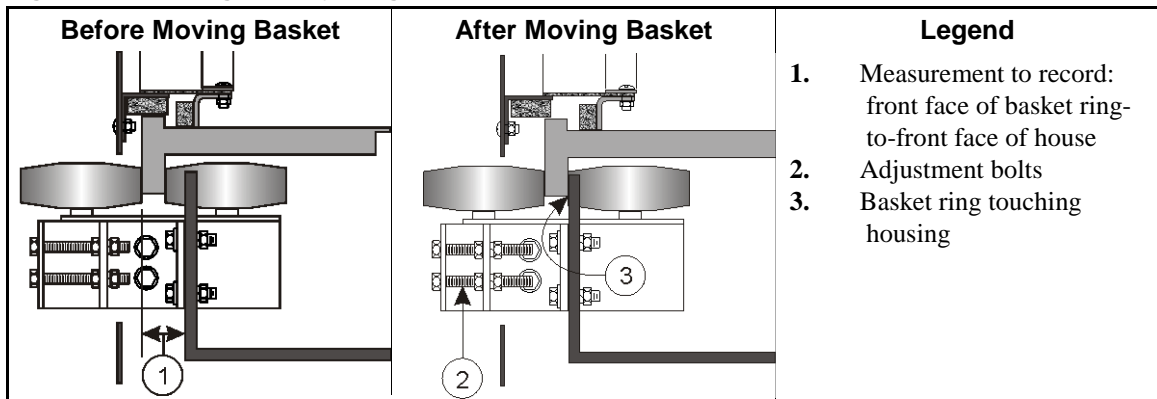
Figure 4: Seal installation tool—2" x 8" (5 x 20 cm) x 12 gauge steel plate, bent up on one end



2. To provide more working room, widen the gap between the basket and shell front as follows:

- a. Remove covers as needed to gain access to the guide roller assembly (see [Figure 1](#)).
- b. Measure and record the face of house-to-face of basket dimension ([Figure 5](#), item 1).
When returning the dryer to operable condition, restore this dimension.
- c. Use the guide roller adjustment bolts ([Figure 5](#), item 2) to move the basket rearward until it is **lightly** touching the house (see [Figure 5](#), item 3).

Figure 5: Recording and Adjusting Basket Position (Section Views)



3. Prepare the dryer for safe entry, including lockout/tagout.
4. Once all appropriate precautions are observed, enter the basket.
5. Unbolt and remove the flap seal holder and the flap seal (see [Figure 2](#)).
6. Using blades that you can work into the recesses, scrape out one, or both felt seals, as needed. Clean out any remaining felt seal material and adhesive with solvent.
7. Cut length(s) of felt material long enough to fit around the circumference of the basket.
8. Apply 3M Rubber & Gasket Adhesive 1300 or similar to one side of felt and let dry.
9. Apply a coat of adhesive to a small section of mating surface on the machine. For the front-most seal, use the previously prepared brush as shown in [Figure 3](#) and [Figure 6](#).
10. Hold the seal in contact with the adhesive for about 30 seconds. For the front-most seal, use the installation tool as shown in [Figure 4](#) and [Figure 7](#).

Figure 6: Section View: Applying Adhesive

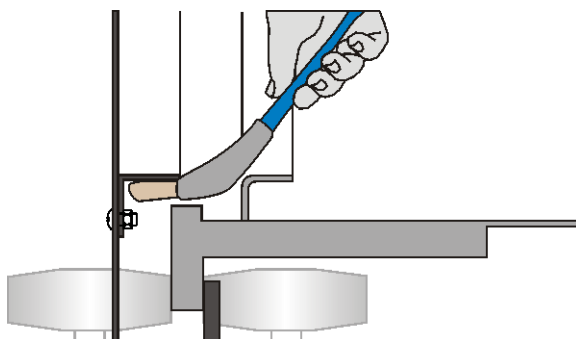
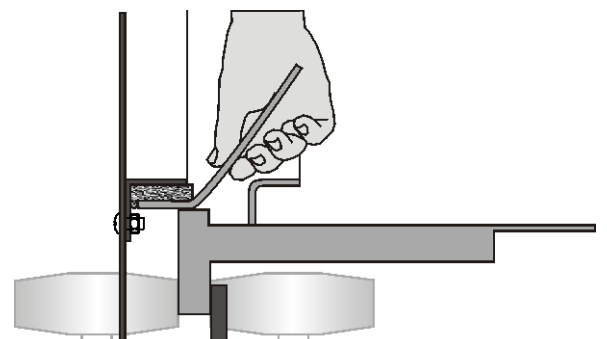


Figure 7: Section View: Setting Felt Seal



11. Continue this process in small sections, until the seal is completely installed. Cut off excess material and butt the felt seal ends together.
12. When seal installation is complete, return the dryer to operable condition by reversing the actions taken in steps 5, 3, and 2. **Before re-installing the flap seal, make sure there are no sharp edges (glue or sharp metal) that could cut the flap seal as it rides against the ring. Use a sander to smooth these down as needed.**

3. How To Close a Front Seal Gap [Document BIPD6M04]

This instruction applies to Milnor dryer models 5040xxxx, 6458xxxx and 7272xxxx.

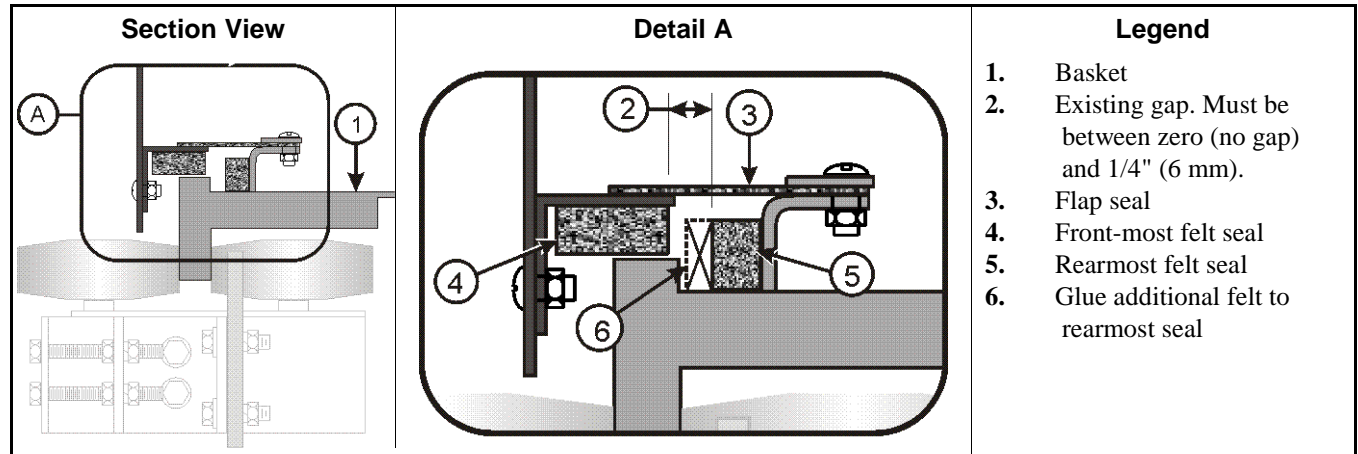
The gap between the two felt seals at the front of the basket must not exceed 1/4" (6 mm). These seals help to retain heat and prevent goods from squeezing between the basket and shell front. If this gap widens (due to wear or a change in basket position), it can be closed by gluing additional felt to the rearmost felt seal, as shown in Figure 8. It is not necessary to replace the existing seals unless they are deteriorated (see document BIPD6M03 "Felt Seal Inspection and Maintenance").

Table 1: Materials Available from Milnor for Closing Seal Gap

P/N	Description -- sizes in inch" and (mm)	Purpose
20C044	3M Rubber and Gasket Adhesive #1300 - pint	Glue seals
27A688	Felt, 1/8" (3) thick x 3/4" (19) *	Add to rearmost seal, if needed
27A689	Felt, 1/4" (6) thick x 3/4" (19) *	Add to rearmost seal, if needed
27A687	Felt, 1/2" (13) s 1 1/2" (38) *	Longer front-most seal, if needed

* Sold by the foot. Felt must fit around basket circumference. 50040 models = 14' (427 cm); 6458 models = 18' (549 cm); 7272 models = 20' (610 cm).

Figure 8: Adding Felt to Existing Seal



1. Prepare the dryer for safe entry including lockout/tagout.
2. Once all appropriate precautions are observed, enter the basket.
3. Lift the flap seal and measure the felt seal gap. If the gap is greater than 1/4" (6 mm), add thickness (see Table 1) to the rearmost felt seal as follows:
 - a. Cut length to fit around the circumference of the basket.
 - b. Apply adhesive (see Table 1) to one side and edge of felt and let dry.
 - c. Apply adhesive to a small section of the mating surfaces on the dryer.
 - d. Press the new material against the existing seal and basket. Hold for about 30 seconds.
 - e. Continue in small sections until the seal material is completely installed. Cut off excess material and butt the ends together.

— End of BIPD6M03 —

Torque Requirements for Fasteners



This document uses Simplified Technical English. Learn more at <http://www.asd-ste100.org>.

The document about the assembly gives the torque requirements for other fasteners. **If fastener torque specifications or threadlocker requirements in an assembly document are different from this document, use the assembly document.**

Figure 1: The Bolts in Milnor® Equipment

The Marks on Bolt Heads	Legend
	<p>A. SAE Grades 1 and 2, ASTM A307, and stainless steel</p> <p>B. Grade BC, ASTM A354</p> <p>C. SAE Grade 5, ASTM A449</p> <p>D. SAE Grade 8 and ASTM A354 BD</p>

1. Torque Values

These tables give the standard dimension, grade, threadlocker, and torque requirements for fasteners frequently used on Milnor® equipment.

Note 1: Data from the Pellerin Milnor® Corporation “Bolt Torque Specification” (bolt_torque_milnor.xls/2002096).

1.1. Fasteners Made of Carbon Steel

1.1.1. Without a Threadlocker

Table 1: Torque Values for Standard Fasteners with Maximum 5/16-inch Diameters and No Lubricant

Dimension	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
	Pound-Inches	N-m	Pound-Inches	N-m	Pound-Inches	N-m	Pound-Inches	N-m
1/4 x 20	66	7	101	11	143	16	126	14
1/4 x 28	76	9	116	13	163	18	--	--
5/16 x 18	136	15	209	24	295	33	258	29
5/16 x 24	150	17	232	26	325	37	--	--

Torque Requirements for Fasteners

Table 2: Torque Values for Standard Fasteners Larger Than 5/16-inch Diameters and No Lubricant

Dimension	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m
3/8 x 16	20	27	31	42	44	59	38	52
3/8 x 24	23	31	35	47	50	68	--	--
7/16 x 14	32	43	49	66	70	95	61	83
7/16 x 20	36	49	55	75	78	105	--	--
1/2 x 13	49	66	75	102	107	145	93	126
1/2 x 20	55	75	85	115	120	163	--	--
9/16 x 12	70	95	109	148	154	209	134	182
9/16 x 18	78	106	121	164	171	232	--	--
5/8 x 11	97	131	150	203	212	287	186	252
5/8 x 18	110	149	170	231	240	325	--	--
3/4 x 10	172	233	266	361	376	510	329	446
3/4 x 16	192	261	297	403	420	569	--	--
7/8 x 9	167	226	429	582	606	821	531	719
7/8 x 14	184	249	473	641	668	906	--	--
1 x 8	250	339	644	873	909	1232	796	1079
1 x 12	274	371	704	954	994	1348	--	--
1 x 14	281	381	723	980	1020	1383	--	--
1 1/8 x 7	354	480	794	1077	1287	1745	1126	1527
1 1/8 x 12	397	538	891	1208	1444	1958	--	--
1 1/4 x 7	500	678	1120	1519	1817	2464	1590	2155
1 1/4 x 12	553	750	1241	1682	2012	2728	--	--
1 3/8 x 6	655	888	1469	1992	2382	3230	2085	2827
1 3/8 x 12	746	1011	1672	2267	2712	3677	--	--
1 1/2 x 6	869	1178	1949	2642	3161	4286	2767	3751
1 1/2 x 12	979	1327	2194	2974	3557	4822	--	--

Table 3: Torque Values for Plated Fasteners with Maximum 5/16-inch Diameters and No Lubricant

Dimension	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
	Pound-Inches	N-m	Pound-Inches	N-m	Pound-Inches	N-m	Pound-Inches	N-m
1/4 x 20	49	6	76	9	107	12	95	11
1/4 x 28	56	6	88	10	122	14	--	--
5/16 x 18	102	12	156	18	222	25	193	22
5/16 x 24	113	13	174	20	245	28	--	--

Table 4: Torque Values for Plated Fasteners Larger Than 5/16-inch Diameters and No Lubricant

Dimension	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m
3/8 x 16	15	20	23	31	33	44	29	38
3/8 x 24	17	23	26	35	37	49	--	--
7/16 x 14	24	32	37	50	52	71	46	61
7/16 x 20	27	36	41	55	58	78	--	--
1/2 x 13	37	49	56	76	80	106	70	93
1/2 x 20	41	55	64	85	90	120	--	--
9/16 x 12	53	70	81	110	115	153	101	134
9/16 x 18	59	79	91	122	128	174	--	--
5/8 x 11	73	97	113	150	159	212	139	186
5/8 x 18	83	110	127	172	180	240	--	--
3/4 x 10	129	173	200	266	282	376	246	329
3/4 x 16	144	192	223	297	315	420	--	--
7/8 x 9	125	166	322	430	455	606	398	531
7/8 x 14	138	184	355	474	501	668	--	--
1 x 8	188	250	483	644	682	909	597	796
1 x 12	205	274	528	716	746	995	--	--
1 x 14	210	280	542	735	765	1037	--	--
1 1/8 x 7	266	354	595	807	966	1288	845	1126
1 1/8 x 12	298	404	668	890	1083	1444	--	--
1 1/4 x 7	375	500	840	1120	1363	1817	1192	1590
1 1/4 x 12	415	553	930	1261	1509	2013	--	--
1 3/8 x 6	491	655	1102	1470	1787	2382	1564	2085
1 3/8 x 12	559	758	1254	1672	2034	2712	--	--
1 1/2 x 6	652	870	1462	1982	2371	3161	2075	2767
1 1/2 x 12	733	994	1645	2194	2668	3557	--	--

1.1.2. With a Threadlocker

Table 5: Threadlocker by the Diameter of the Bolt (see Note 2)

LocTite Product	Dimension			
	1/4-inch	1/4- to 5/8-inch	5/8- to 7/8-inch	1-inch +
LocTite 222	OK			
LocTite 242		OK		
LocTite 262			OK	
LocTite 272			High temperature	
LocTite 277				OK

Note 2: The acceptable bolt size ranges for various LocTite® threadlocking products is the LocTite manufacturer's **general** recommendation. Specific applications sometime require that a LocTite product is applied to a bolt size outside the ranges shown here. For example, Milnor specifies LocTite 242 for use on certain 1" bolt applications and has confirmed this usage with the LocTite manufacturer. You may see variances such as this in the documentation for specific machine assemblies.

Torque Requirements for Fasteners

Table 6: Torque Values if You Apply LocTite 222

Dimension	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
	Pound-inches	N-m	Pound-inches	N-m	Pound-inches	N-m	Pound-inches	N-m
1/4 x 20	60	7	96	11	132	15	108	12
1/4 x 28	72	8	108	12	144	16	--	--

Table 7: Torque Values if You Apply LocTite 242

Dimension	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m
5/16 x 18	11	15	17	23	25	34	22	30
5/16 x 24	13	18	19	26	27	37	27	37
3/8 x 16	20	27	31	42	44	60	38	52
3/8 x 24	23	31	35	47	50	68	--	--
7/16 x 14	32	43	49	66	70	95	61	83
7/16 x 20	36	49	55	75	78	106	--	--
1/2 x 13	49	66	75	102	107	145	93	126
1/2 x 20	55	75	85	115	120	163	--	--
9/16 x 12	70	95	109	148	154	209	134	182
9/16 x 18	78	106	121	164	171	232	--	--
5/8 x 11	97	132	150	203	212	287	186	252
5/8 x 18	110	149	170	230	240	325	--	--

Table 8: Torque Values if You Apply LocTite 262

Dimension	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m
3/4 x 10	155	210	240	325	338	458	296	401
3/4 x 16	173	235	267	362	378	512	--	--
7/8 x 9	150	203	386	523	546	740	477	647
7/8 x 14	165	224	426	578	601	815	--	--

Table 9: Torque Values if You Apply LocTite 272 (High-Temperature)

Dimension	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m
1 x 8	350	475	901	1222	1272	1725	1114	1510
1 x 12	383	519	986	1337	1392	1887	--	--
1 x 14	393	533	1012	1372	1428	1936	--	--
1-1/8 x 7	496	672	1111	1506	1802	2443	1577	2138
1-1/8 x 12	556	754	1247	1691	2022	2741	--	--
1-1/4 x 7	700	949	1568	2126	2544	3449	2226	3018
1-1/4 x 12	774	1049	1737	2355	2816	3818	--	--
1-3/8 x 6	917	1243	2056	2788	3335	4522	2919	3958
1-3/8 x 12	1044	1415	2341	3174	3797	5148	--	--
1-1/2 x 6	1217	1650	2729	3700	4426	6001	3873	5251
1-1/2 x 12	1369	1856	3071	4164	4980	6752	--	--

Table 10: Torque Values if You Apply LocTite 277

Dimension	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m
1 x 8	325	441	837	1135	1181	1601	1034	1402
1 x 12	356	483	916	1242	1293	1753	--	--
1 x 14	365	495	939	1273	1326	1798	--	--
1-1/8 x 7	461	625	1032	1399	1674	2270	1464	1985
1-1/8 x 12	516	700	1158	1570	1877	2545	--	--
1-1/4 x 7	650	881	1456	1974	2362	3202	2067	2802
1-1/4 x 12	719	975	1613	2187	2615	3545	--	--
1-3/8 x 6	851	1154	1909	2588	3097	4199	2710	3674
1-3/8 x 12	970	1315	2174	2948	3526	4781	--	--
1-1/2 x 6	1130	1532	2534	3436	4110	5572	3597	4877
1-1/2 x 12	1271	1723	2852	3867	4624	6269	--	--

1.2. Stainless Steel Fasteners

Table 11: Torque Values for Stainless Steel Fasteners 5/16-inch and Smaller

Dimension	316 Stainless		18-8 Stainless		18-8 Stainless with Loctite 767	
	Pound-Inches	N-m	Pound-Inches	N-m	Pound-Inches	N-m
1/4 x 20	79	9	76	9	45	5
1/4 x 28	100	11	94	11	56	6
5/16 x 18	138	16	132	15	79	9
5/16 x 24	148	17	142	16	85	10

Table 12: Torque Values for Stainless Steel Fasteners Larger Than 5/16-inch

Dimension	316 Stainless		18-8 Stainless		18-8 Stainless with Loctite 767	
	Pound-feet	N-m	Pound-feet	N-m	Pound-feet	N-m
3/8 x 16	21	28	20	27	12	16
3/8 x 24	23	31	22	29	13	18
7/16 x 14	33	44	31	42	19	25
7/16 x 20	35	47	33	45	20	27
1/2 x 13	45	61	43	58	26	35
1/2 x 20	47	64	45	61	27	37
9/16 x 12	59	81	57	77	34	46
9/16 x 18	66	89	63	85	38	51
5/8 x 11	97	131	93	125	56	75
5/8 x 18	108	150	104	141	62	84
3/4 x 10	132	179	128	173	77	104
3/4 x 16	130	176	124	168	75	101
7/8 x 9	203	275	194	263	116	158
7/8 x 14	202	273	193	262	116	157
1 x 8	300	406	287	389	172	233
1 x 14	271	367	259	351	156	211
1-1/8 x 7	432	586	413	560	248	336
1-1/8 x 12	408	553	390	529	234	317
1-1/4 x 7	546	740	523	709	314	425
1-1/4 x 12	504	683	480	651	288	390
1-1/2 x 6	930	1261	888	1204	533	722
1-1/2 x 12	732	992	703	953	422	572

2. Preparation



WARNING 2: Fire Hazard—Some solvents and primers are flammable.

- Use threadlocker and primers with sufficient airflow.
 - Do not use flammable material near ignition sources.
1. Clean all threads with a wire brush or a different tool.
 2. Remove the grease from the fasteners and the mating threads with solvent. Make the parts dry.

Note 3: Loctite 7649 Primer™ or standard solvents will remove grease from parts.

3. Apply a spray of Loctite 7649 Primer™ or equal on the fasteners and the mating threads. Let the primer dry for one minute minimum.

3. How to Apply a Threadlocker

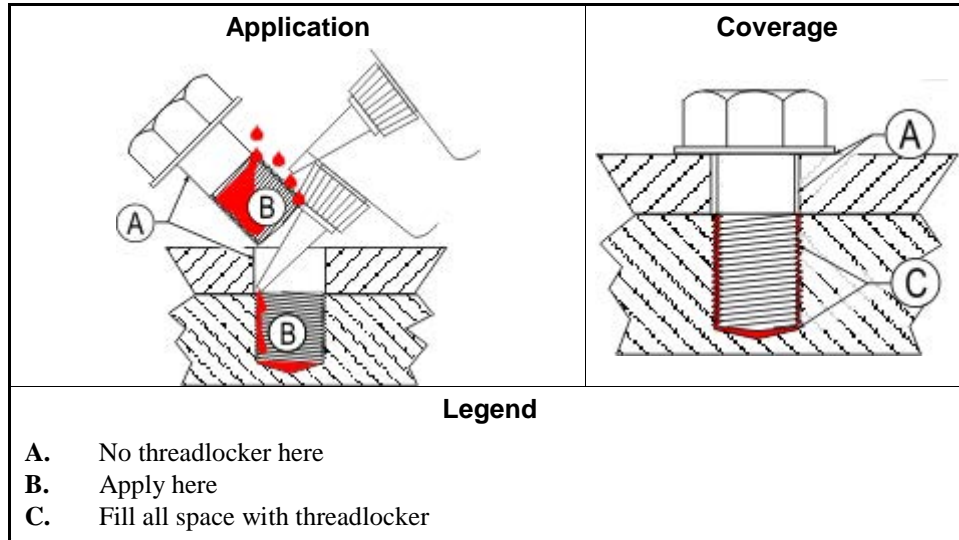


CAUTION 3: Malfunction Hazard—Heat, vibration, or mechanical shocks can let the fasteners loosen if you do not apply the threadlocker correctly. Loose fasteners can cause malfunctions of the equipment.

- Read the threadlocker manufacturer's instructions and warnings. Obey these instructions.

Apply the threadlocker only to the areas where the fastener threads and the mating threads engage.

Figure 2: Blind Hole



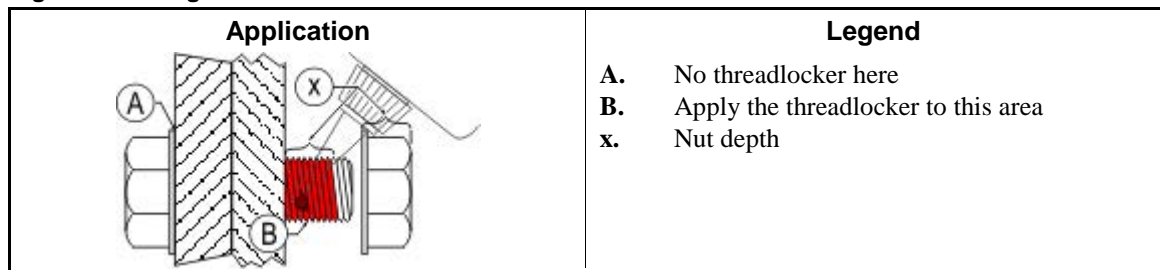
3.1. Blind Holes

1. Apply the threadlocker down the threads to the bottom of the hole.
2. Apply the threadlocker to the bolt.
3. Tighten the bolt to the value shown in the correct table ([Table 5](#) to [Table 11](#)).

3.2. Through Holes

1. Put the bolt through the assembly.
2. Apply the threadlocker only to the bolt thread area that will engage the nut.
3. Tighten the bolt to the value shown in the correct table ([Table 5](#) to [Table 11](#)).

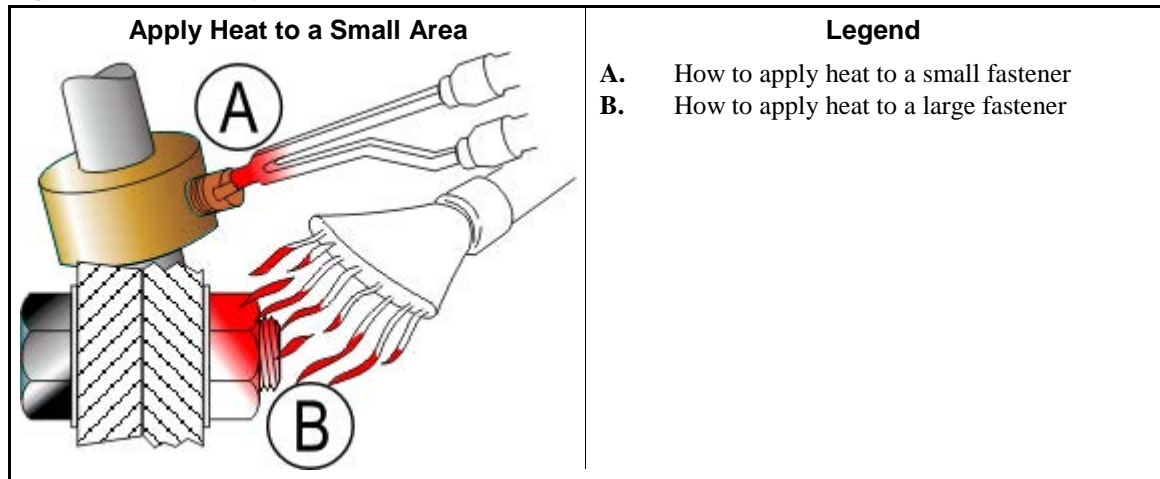
Figure 3: Through Hole



- 3.3. Disassembly**—For high-strength threadlocker, apply heat for five minutes. Disassemble with hand tools while the parts are hot.

For low-strength and moderate-strength threadlocker, disassemble with hand tools.

Figure 4: Disassembly



— End of BIUUM04 —

Covers and Shipping Brackets

3

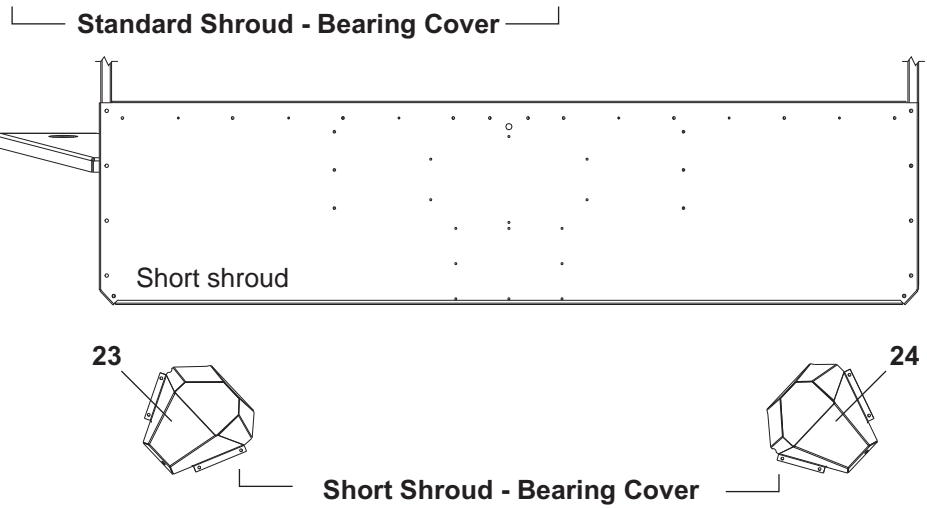
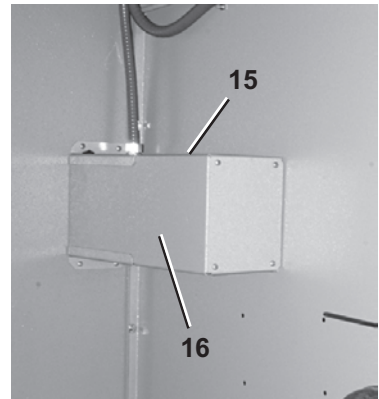
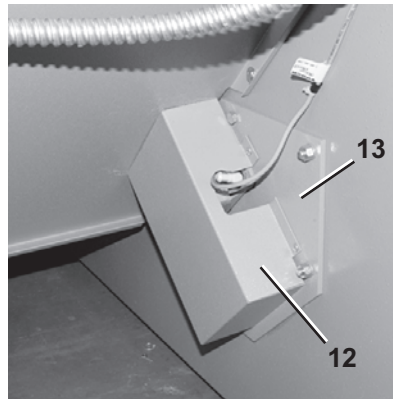
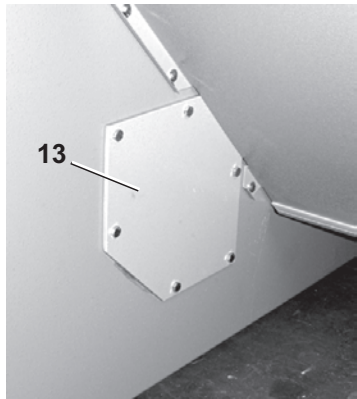
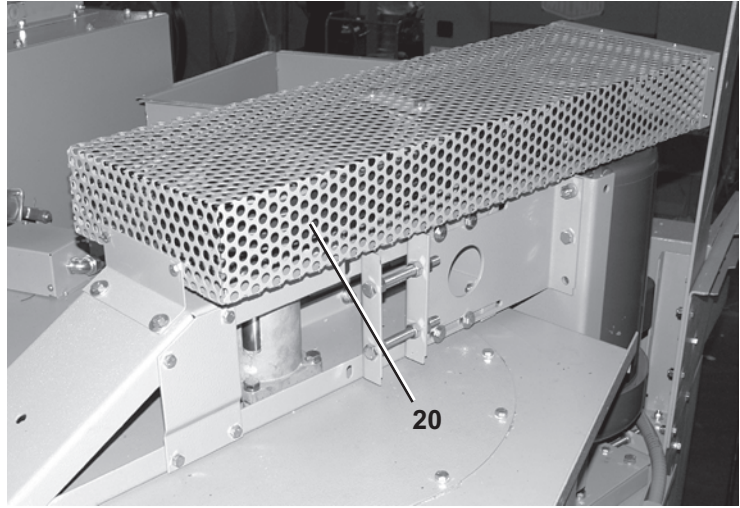
Guards & Covers

6450, 6458, 6464, 7272, 7676, 8282 Dryers



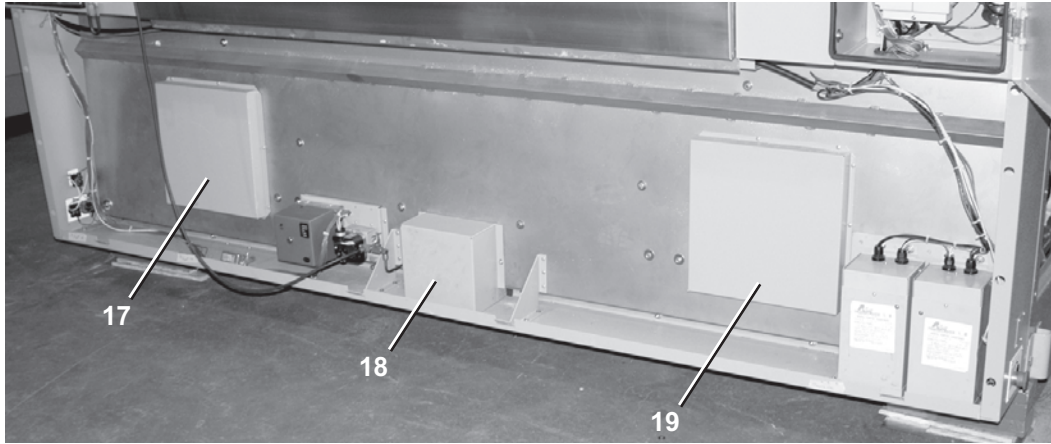
Guards & Covers

6450, 6458, 6464, 7272, 7676, 8282 Dryers



Guards & Covers

6458, 6450, 6464, 7272, 7676, 8282 Dryers



Parts List—Guards & Covers

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
-----REFERENCE ASSEMBLIES-----				
	A			6450 Dryers
	B			6458 Dryers
	C			6464 Dryers
	D			7272 Dryers
	E			7676 Dryers
	F			8282 Dryers
-----COMPONENTS-----				
B	3	A77SC001	6458 LOWER SIDE COVER ASSY	
C	3	A77SC010	6464 LOWER SIDE COVER ASSY	
DE	3	A79SC001	7272 LOW CVR BLOWER SIDE	
B	4	07 71397	6458 HOUSE SIDE PLATE UPPER	
AC	4	07 72029	6464 HOUSE SIDE PLATE UPPER	
D	4	07 81398	7272 HOUSE SIDE PLATE UPPER	
E	4	07 85397	7676 HOUSE SIDE PLATE	
F	4	07 88073	8282 HOUSE SIDE PANEL	
B	5	07 71435	6458 LINT SIDE LOWER COVER	
AC	5	07 72028	6464 LOWER SIDE COVER	
D	5	07 81435	7272 BLOW SIDE LOWER COVER	
E	5	07 85397	7676 HOUSE SIDE PLATE	
F	5	07 88073	8282 HOUSE SIDE PANEL	
ABC	6	W7 71205A	64" DRYER FRONT COSMETIC LOWER DOOR WELD	
D	6	07 81205	7272 FRONT COSM-LOWER DOOR	

Guards & Covers

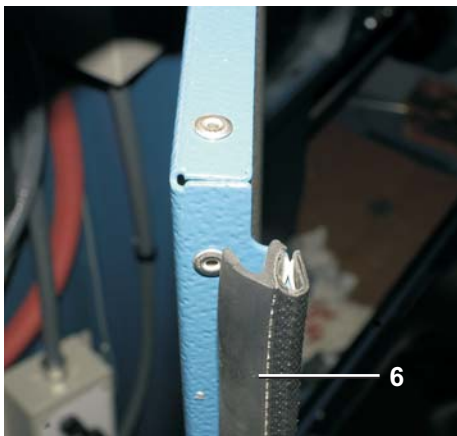
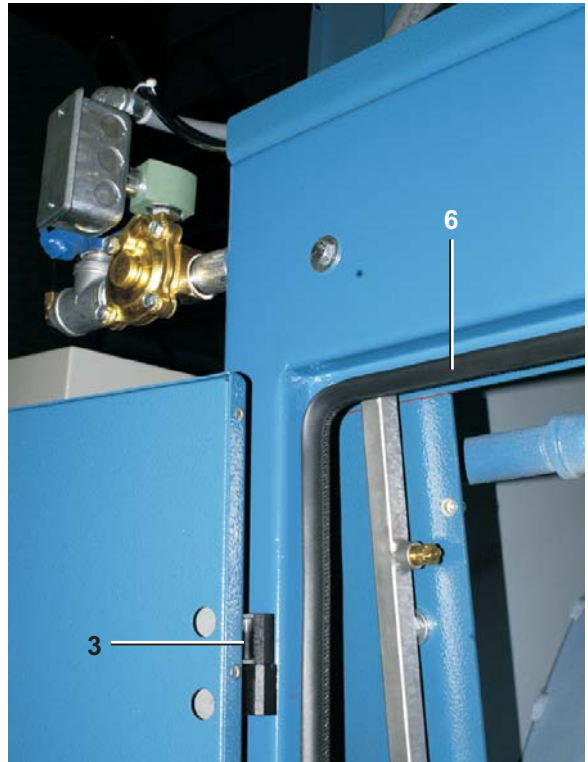
6458, 6450, 6464, 7272, 7676, 8282 Dryers

Parts List—Guards & Covers				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
E	6	W7 85205	7676 FRONT COSMETIC LOWER DOOR HINGED WLMT	
F	6	W7 88102	8282 FRONT COSMETIC LOWER DOOR HINGED WLMT	
all	7	W3 D1356L	WELD:DOOR 6458TG1 DRYER LF LV	
A	8	07 71201A	6464 FRONT COSM UPPER	
BC	8	07 71201W	6458 FRONT COSM UPPER	
D	8	07 81201	7272 COS-UPPER MID COVER	
E	8	07 85201	7676 COSMETIC UPPER MID COVER	
F	8	W7 88111	8282 FRONT COSMETIC UPPER MID COVER WLMT	
all	9	03 D1356R	DOOR: 6458TG1L DRYER HV	
ABC	10	07 71204W	6458 COSM LOWER THRESHOLD	
DEF	10	07 81204	7272 FRONT COS THRESHOLD	
all	11	07 50428	SPRINKLER VALVE COVER DRYER	
ABC	12	07 71317	6458 REAR BEARING COVER	STANDARDS SHROUD
DE	12	07 81317	7272 REAR BEARING COVER	STANDARDS SHROUD
F	12	07 88125	8282 REAR BEARING COVER	STANDARDS SHROUD
all	13	07 81280	7272 SUPPORT BEAR MTG PLT	
all	15	07 71306	6458 TEMP PROBE BOX	
all	16	07 71307	6458 TEMP PROBE BOX COVER	
ABCDE	17	07 71231	COVER BRG NO HOLE LF END	
F	17	07 88110	8282 FRONT BEARING COVER	
ABCDE	18	W7 50129	64" DRYER GUIDE ROLLER COVER	
F	18	07 88117	8282 GUIDE ROLLER COVER	
all	19	07 71231A	COVER BRG NO HOLE RT END	
A	20	A7 50268C	6450 LF BLWR BELT GUARD ASMBLY - ANGLED	LEFT
A	20	A7 50268CA	6450 RT BLWR BELT GUARD ASMBLY - ANGLED	RIGHT
BC	20	A77BA002	64" DRYER BLOWER BELT GUARD ASSY	
DEF	20	A79BA002	72/76/82" DRYER BLOWER BELT GUARD ASSY	
all	21	27A108A	HINGE LIFTOFF LH EMKA#1056-U62 BLACK	
all	22	27A108B	HINGE LIFTOFF RH EMKA#1056-U63 BLACK	
DE	23	W7 71317B	6458 BRNG CVR SHORT-LEFT	SHORT SHROUD
F	23	A82BC001	8282 BRNG COVER SHORT ASSEMBLY	SHORT SHROUD
DE	24	W7 71317D	6458 BRNG CVR SHORT-RIGHT	SHORT SHROUD
F	23	A82BC001	8282 BRNG COVER SHORT ASSEMBLY	SHORT SHROUD
all	25	60A114	SELF-GRIP GASKET EMKA 1011-17	

Side Doors

5050, 6450, 6458, 6464, 7676, 8282 Dryers

Side Doors used on Dryers since 2014



Side Doors

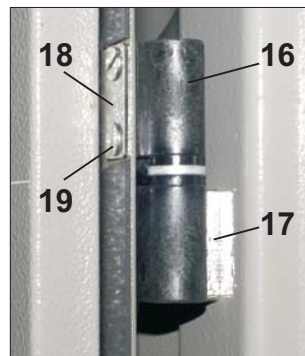
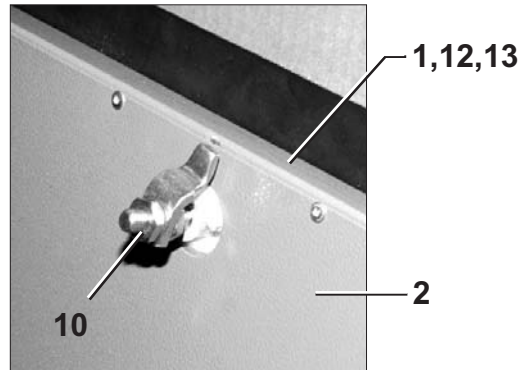
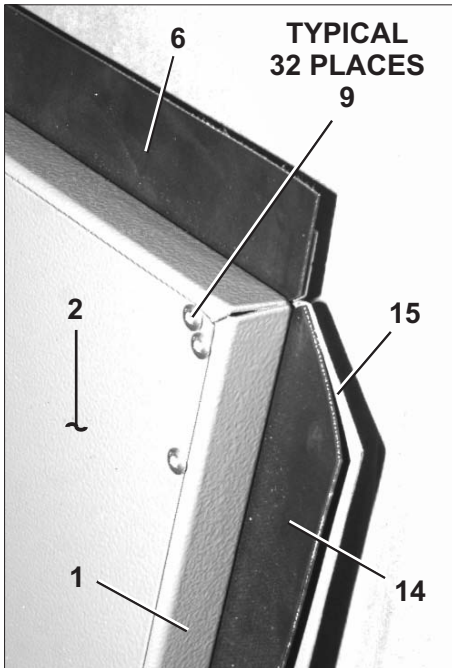
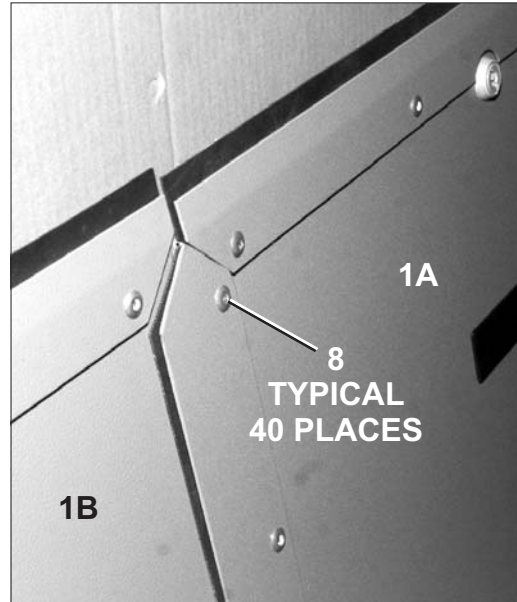
5050, 6450, 6458, 6464, 7676, 8282 Dryers

Parts List—Side Doors				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	REFERENCE	5050 DRYERS	
	B	REFERENCE	6450 DRYERS	
	C	REFERENCE	6458 DRYERS	
	D	REFERENCE	6464 DRYERS	
	E	REFERENCE	7676 DRYERS	
	F	REFERENCE	8282 DRYERS	
-----COMPONENTS-----				
A	1	A74SD018A	5050 DOOR ASSY W/O LOCK	
B	1	A77SD030A	6450 SIDE DOOR ASSY W/O LOCK	
C	1	A77SD017A	6458 HINGED SIDE DOOR ASSY W/O LOCK	
D	1	A77SD023A	6464 HINGED SIDE-DOOR ASSY W/O LOCK	
E	1	A79SD022	7676 HINGED SIDE-DOOR W/O LOCK ASSY	
F	1	A82SD001A	8282 SIDE DOOR W/O LOCK	
A	2	A74SD018	5050 DOOR ASSEMBLY W/LOCK	
B	2	A77SD030	6450 SIDE DOOR ASSY W/LOCK	
C	2	A77SD017	6458 HINGED SIDE DOOR ASSY W/LOCK	
D	2	A77SD023	6464 HINGED SIDE-DOOR ASSY W/LOCK	
E	2	A79SD023	7676 HINGED SIDE-DOOR W/LOCK ASSY	
F	2	A82SD001	8282 SIDE DOOR W/LOCK	
all	3	27A108A	HINGE LIFTOFF LH EMKA#1056-U62 BLACK	
all	4	27A108B	HINGE LIFTOFF RH EMKA#1056-U63 BLACK	
all	5	27A102M	WISE-ACT.DBBIT.LATCH#E3-12-27	
all	6	60A114	SELF-GRIP GASKET EMKA 1011-17	

Side Doors

6458 & 6464 Dryers

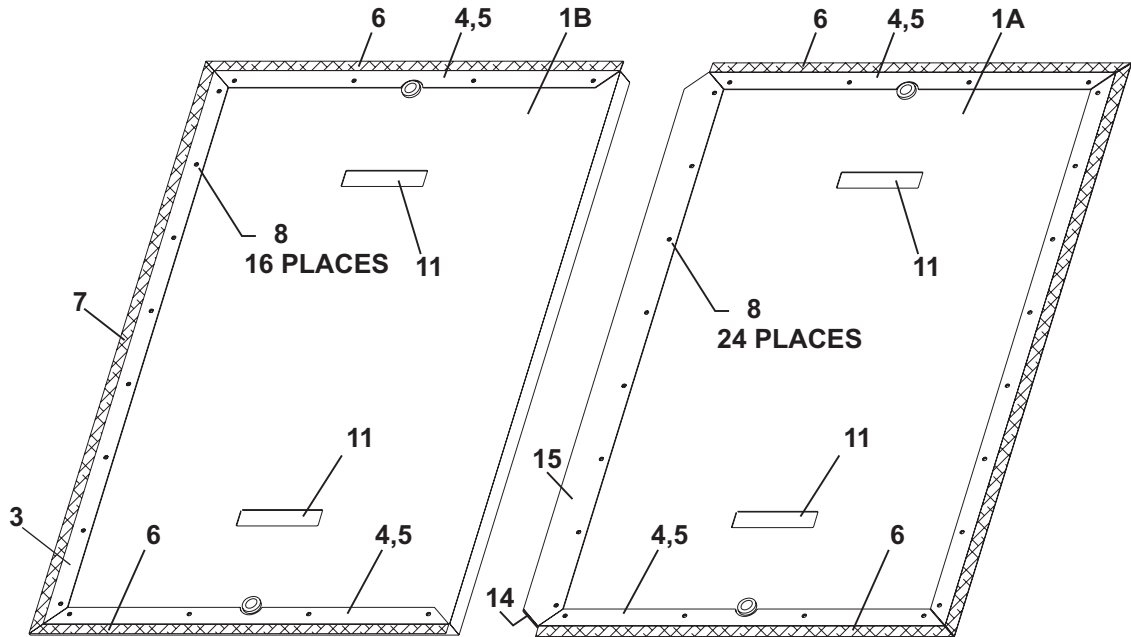
Side Doors used on 6458 & 6464 Dryers Prior to 2014



Side Doors

6458 & 6464 Dryers

Side Doors used on 6458 & 6464 Dryers Prior to 2014



Parts List—Side Doors

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	A77SD015	6458 SIDE DOOR ASSY WITH CVR	6458TG1R/L,TS1R/L
	B	A77SD015A	6458 SIDE DOOR ASSY NO CVR	6458TG1R/L,TS1R/L
	C	A77SD020	ASST=6464 SIDE DOOR W/ FLAP	6464TG1R/L,TS1R/L
	D	A77SD020A	ASSY=6464 SIDE DOOR W/O FLAP	6464TG1R/L,TS1R/L
-----COMPONENTS-----				
AB	1	07 71427A	6458 SIDE DOOR OUTER=LIFT OFF	
C	1	07 72030	6464 SIDE DOOR OUTER W/ FLAP	
D	1	07 72031	6464 SIDE DOOR OUTER W/O FLAP	
AB	2	07 71428A	6458 SIDE DOOR INNER=LIFT OFF	
CD	2	07 72032	6464 SIDE DOOR INNER	
all	3	07 71440	6458 SIDE DOOR VERT RET-ANG	
all	4	07 71441	6458 SIDE DOOR HORZ RET-ONE	
all	5	07 71441A	6458 SIDE DOOR HORZ RET-TWO	
AB	6	07 71444	6458 SIDE DOOR SEAL TOP&BOT	
CD	6	07 72033	6464 SIDE DOOR SEAL TOP&BOTTOM	

Side Doors

6458 & 6464 Dryers

Parts List—Side Doors

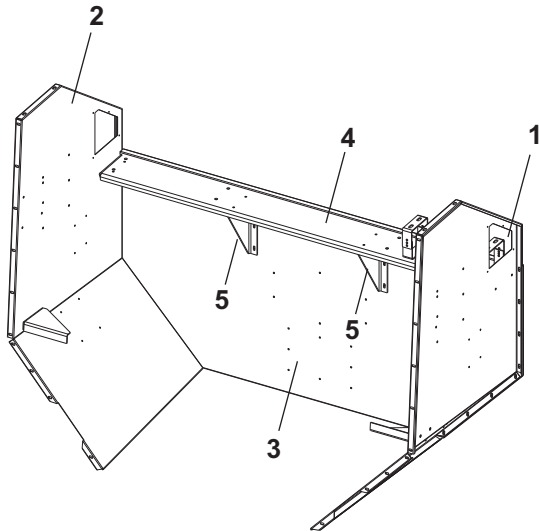
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
all	7	07 71445	6458 SIDE DOOR SEAL OUTER	
all	8	15J021B	1/4 X .50 ALUM RIVET	
AB	9	15J065	POPRIVET 5/32 DIA X.425L AL/ST	
CD	9	15J069	POPRIVET 3/16 DIA X.450L S/S-64	
all	10	27A102M	WISE-ACT.DBBIT.LATCH#E3-12-27	
all	11	27A118	POCKET PULL FLUSH HDLE #P2-52	
all	12	98P030	INSUL.FIBRGLS.24X48X1+1/2E=1SH	
AB	13	07 71443	6458 SIDE DOOR STIFFENER	
CD	13	07 71443A	SIDE DOOR STIFFENER	
all	14	07 71446	6458 SIDE DOOR SEAL INNER	
all	15	07 71442	6458 SIDE DOOR VERT RET-FLAT	
all	16	27A115	OFFSET HINGE RGTHD FREESWING	
all	17	07 71483	SIDE DOOR HINGE BACKUP PLATE	
all	18	07 71482	SIDE DOOR HINGE MNT PLATE	
all	19	15N176	FLATMACSCR 1/4-20NCX3/4SS18-8	

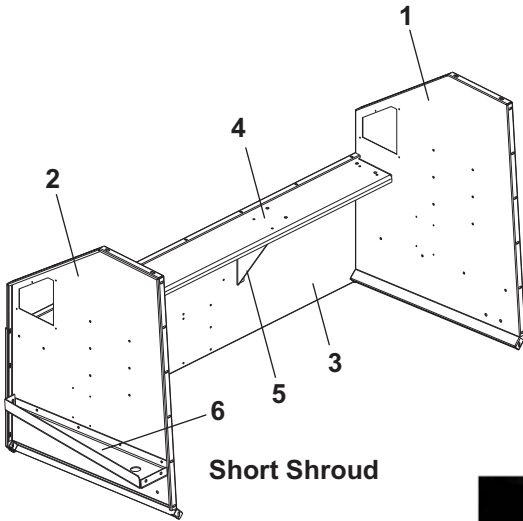
Unload Shrouds

6458TG1L/R, TS1L/R 6464TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R

6458TG1L/R, TS1L/R
6464TG1L/R, TS1L/R

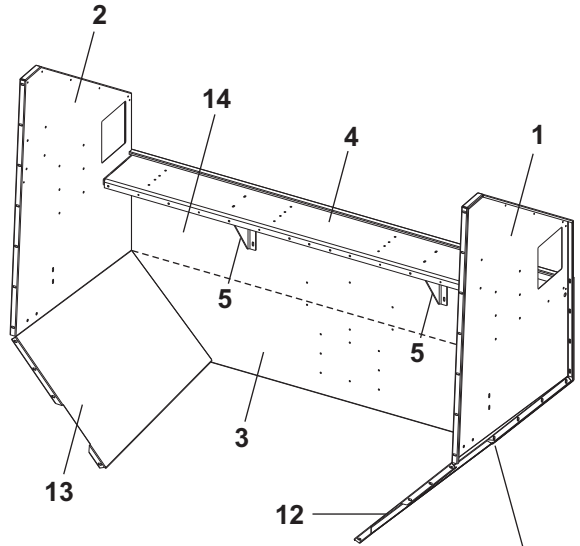


Standard Shroud



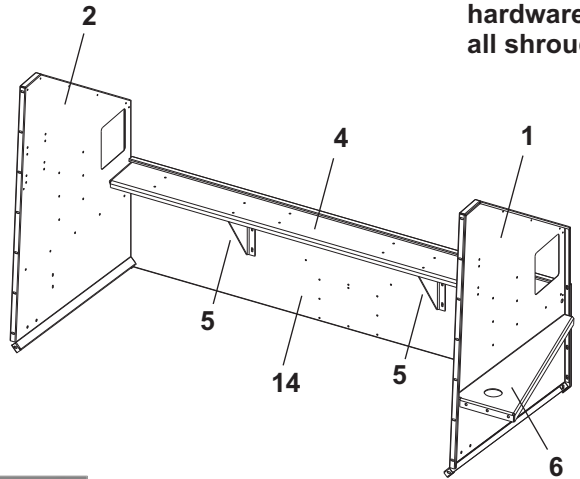
Short Shroud

7676TG1L/R
8282TG1L/R

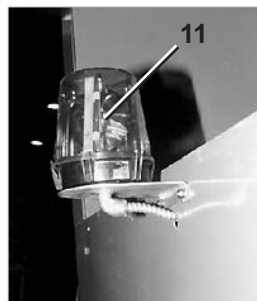


Standard Shroud

7,8,9,10
typical
hardware
all shrouds



Short Shroud



Unload Shrouds

6458TG1L/R,TS1L/R 6464TG1L/R,TS1L/R 7676TG1L/R 8282TG1IL/TG1R

Parts List—Discharge Shroud				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A			6458/6464
	B			STANDARD SHROUD
	C			7676
	D			STANDARD SHROUD
	E			6458/6464
	F			SHORT SHROUD
				7676
				SHORT SHROUD
				8282
				STANDARD SHROUD
				8282
				SHORT SHROUD
-----COMPONENTS-----				
A	1	07 71150A	6458 UNLOAD SHROUD RIGHT	
B	1	07 71505C	6458 SHROUD SHORT CHAMFER - RT	
C	1	07 85150	7676 UNLOAD SHROUD RIGHT	
D	1	07 81505	7272 UNLOAD SHROUD RT SHORT	
EF	1	07 88123	8282 SHROUD SHORT CHAMFER-RT	
A	2	07 71150B	6458 UNLOAD SHROUD LEFT	
B	2	07 71505D	6458 SHROUD SHORT CHAMFER-LF	
C	2	07 85151	7676 UNLOAD SHROUD LEFT	
D	2	07 81505A	7272 UNLOAD SHROUD LF SHORT	
EF	2	07 88123A	8282 SHROUD SHORT CHAMFER-LT	
A	3	07 71152	6458 UNLOAD SHROUD BACK PLT	
B	3	07 71506	6458 UNLOAD SHROUD BACK =SHT	
C	3	07 85152	7676 UNLOAD SHROUD BACK PLT	
D	3	07 85152A	7676 UNLD SHROUD BACK-SHORT	
EF	3	07 88121	8282 UNLOAD SHROUD EXTENSION BACK	
AB	4	07 71154	6458 GAS PIPE SUPP PLT	
CB	4	07 85154	7676 SHROUD GAS PIPE SUPPORT PLATE	
EF	4	07 88122	8282 GAS PIPE SUPP PLT	
all	5	07 71156	6458 PIPE SUPP GUSSET BKT	
AB	6	W7 71507	6458 SHORT SHROUD GUSSET LFT	
CD	6	W7 81507	7272 SHORT SHROUD GUSSET LF	
EF	6	07 88126	8282 SHORT SHROUD GUSSET	
all	7	15K037	HEXCAPSCR 1/4-20UNC2AX5/8 GR5	
all	8	15U180	LOCKWASHER MEDIUM 1/4 ZINCPL	
all	9	15U185	FLATWASHER(USS STD) 1/4" ZNC P	
all	10	15G165	HXNUT 1/4-20UNC2B SAE ZC GR2	
all	11	09H026V37	BEACON ROTARY 90MM AMBER CE	
E	12	07 88120	8282 UNLOAD SHROUD EXTENSION RIGHT	
E	13	07 88120A	8282 UNLOAD SHROUD EXTENSION LEFT	
EF	14	07 88124	8282 UNLOAD SHROUD BACK PLT	

Lifting Brackets

5040TG2L/R, TS2L/R, 5050TG1L/R, TS1L/R, 6450TG1L/R
6458TG1L/R, TS1L/R, 6464TG1L/R, TS1L/R, 7272TG1L/R, TS1L/R, 7676TG1L/R 8282TG1L/R

Figure 1: 5040, 5050, 6450, 6458, 6464, 7272, 7676, and 8282 Dryers (7676 Shown)

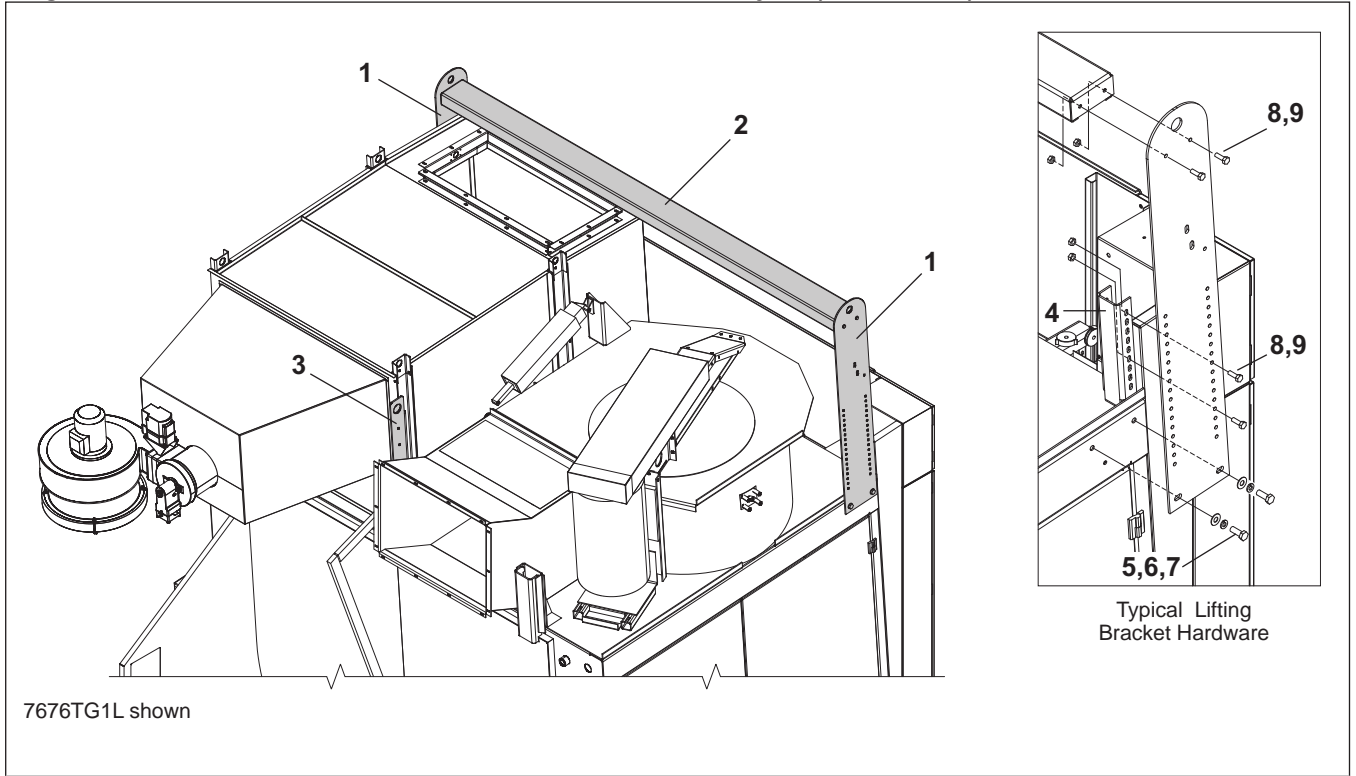
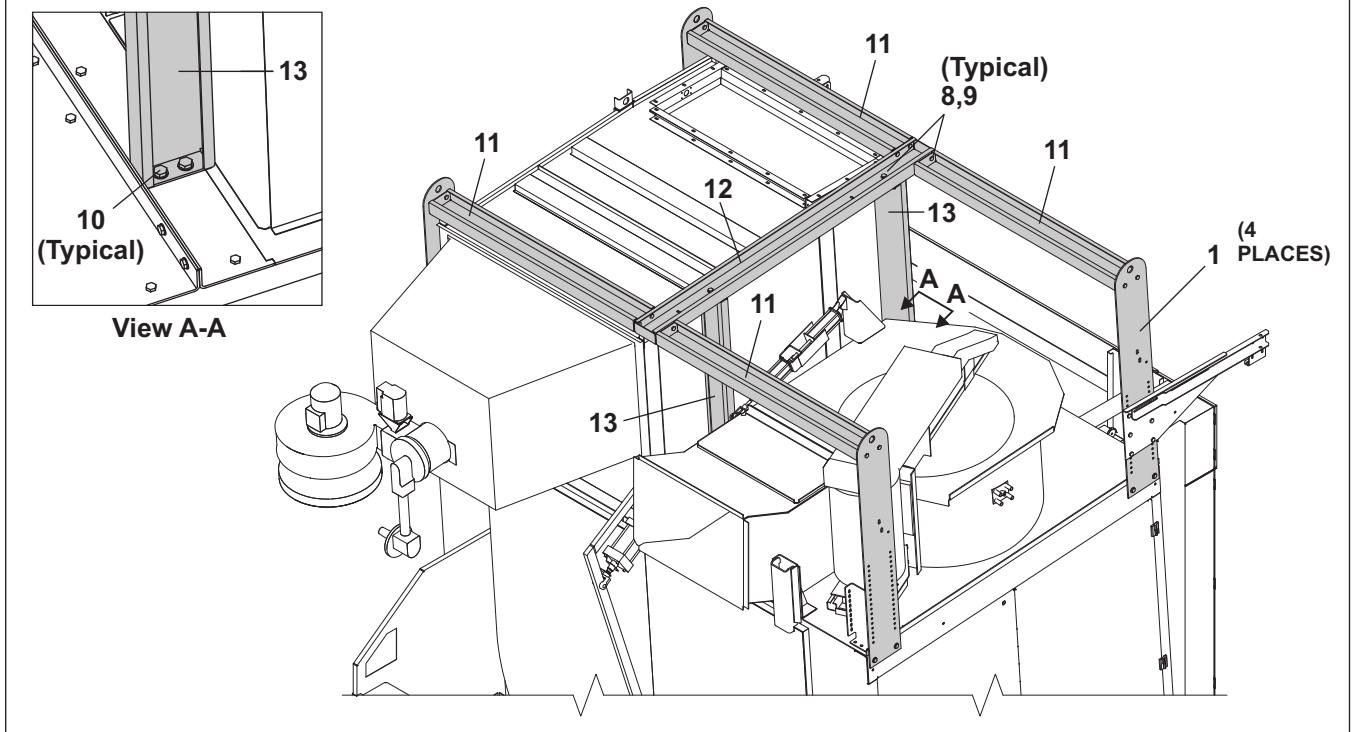


Figure 2: 8282 Dryers



Lifting Brackets

5040TG2L/R,TS2L/R, 5050TG1L/R,TS1L/R, 6450TG1L/R

6458TG1L/R,TS1L/R, 6464TG1L/R,TS1L/R, 7272TG1L/R,TS1L/R, 7676TG1L/R 8282TG1L/R

Parts List—Lifting Brackets

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

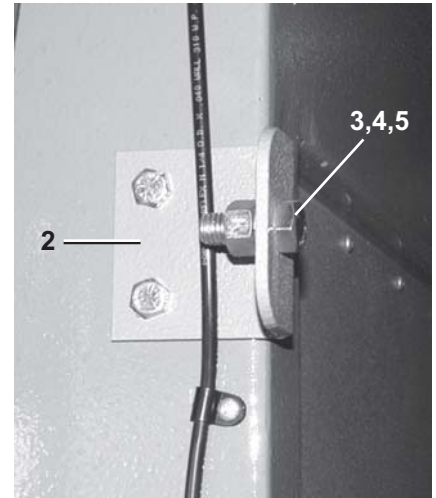
Used In	Item	Part Number	Description	Comments
-----REFERENCE ASSEMBLIES-----				
A			5040 DRYERS	
B			5050 DRYERS	
C			6450 DRYERS	
D			6458 DRYERS	
E			6464 DRYERS	
F			7272 DRYERS	
G			7676 DRYERS	
H			8282 DRYERS	
-----COMPONENTS-----				
ABDE	1	07 71315	DRYER LIFT BRKT STANDARD=41.50	
C	1	07 71315B	6450 DRYER LIFT BRKT=44.50	
FG	1	07 85315A	DRYER LIFT BRKT TALL=51.50	
H	1	07 88092	8282 DRYER LIFT BRKT	
AB	2	07 44075	5040 LIFT BRKT LONG SPREADER	
C	2	07 71316	6458 LIFT BRKT LONG SPREADER	
DE	2	07 81316	7272 LIFT BRKT LONG SPREADER	
H	2	07 88093	8282 SPREADER BAR CENTER STIFF	
AB	3	07 44076	5040 REAR LIFTING BRACKET	
CDEF	3	07 71183A	6458A REAR LIFTING BRACKET	
FG	3	07 71183B	DRYER REAR CHANNEL LIFTING BRACKET	
H	3	07 88096	8282 VT LIFTING BRKT	
A-F	4	07 71439	6458 RAILSUPP CORNER BRKT	
all	5	15K173A	HXCAPSCR 1/2-13UNC2AX1.75 GR5	
all	6	15U280	FL+WASHER(USS STD)1/2 ZNC PL+D	
all	7	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	8	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	9	15G198	HXFLGNUT 3/8-16 ZINC	

Dryer to Dryer Mounting Parts

5040, 5050, 6450, 6458, 6464, 7272, 7676, 8282 Dryers



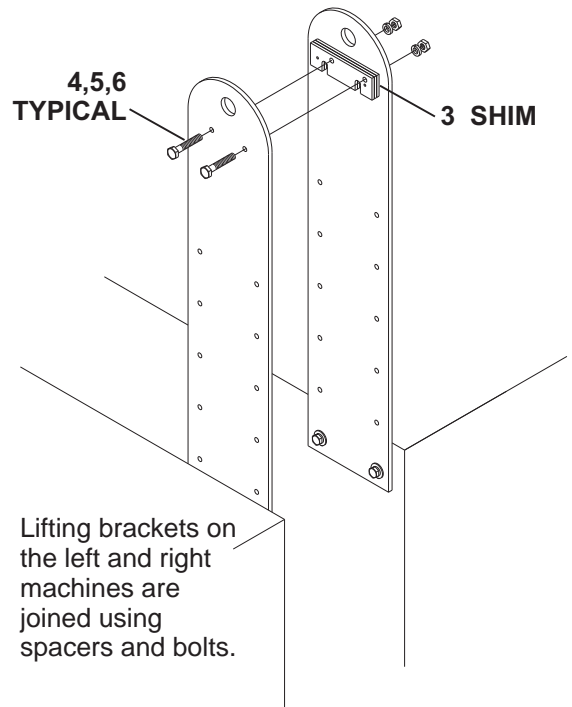
Sealing foam is applied to the right side of the left machine of the pair only. The dashed line shows where to apply the foam.
 ("right machine" shown in photo)



Mounting brackets are used to join left and right machines on the rear of the house and to join the pedestal legs.



Covers for nameplate and emergency stop replacement.



Lifting brackets on the left and right machines are joined using spacers and bolts.

See Instruction, "Dryer Installation" BIPD6I02.

Dryer to Dryer Mounting Parts

5040, 5050, 6450, 6458, 6464, 7272, 7676, 8282 Dryers

Parts List—Dryer to Dryer Mounting Parts				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----COMPONENTS-----				
All	1	60A008A	1" X 1" NEO SPONGE/ADH.	
all	2	07 71309	6458 DRYER TO DRYER MNT BKT	
all	3	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	4	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	5	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	6	15K125	HEXCAPSCR 3/8-16UNC2AX2.5 GR5-	
all	7	07 71310	6458 DRYER TO DRYER MNT SHIM	
all	8	03 CC2X2	COVER PLT:DRYER NPLT REPLCMNT	
all	9	03 CC3X4	COVER PLT:DRYER E-STOP RPLCMNT	

Pedestal Base

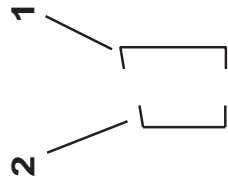
6458TG1LR, TS1LR 6464TG1LR, TS1LR



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(Sheet 1 of 3)

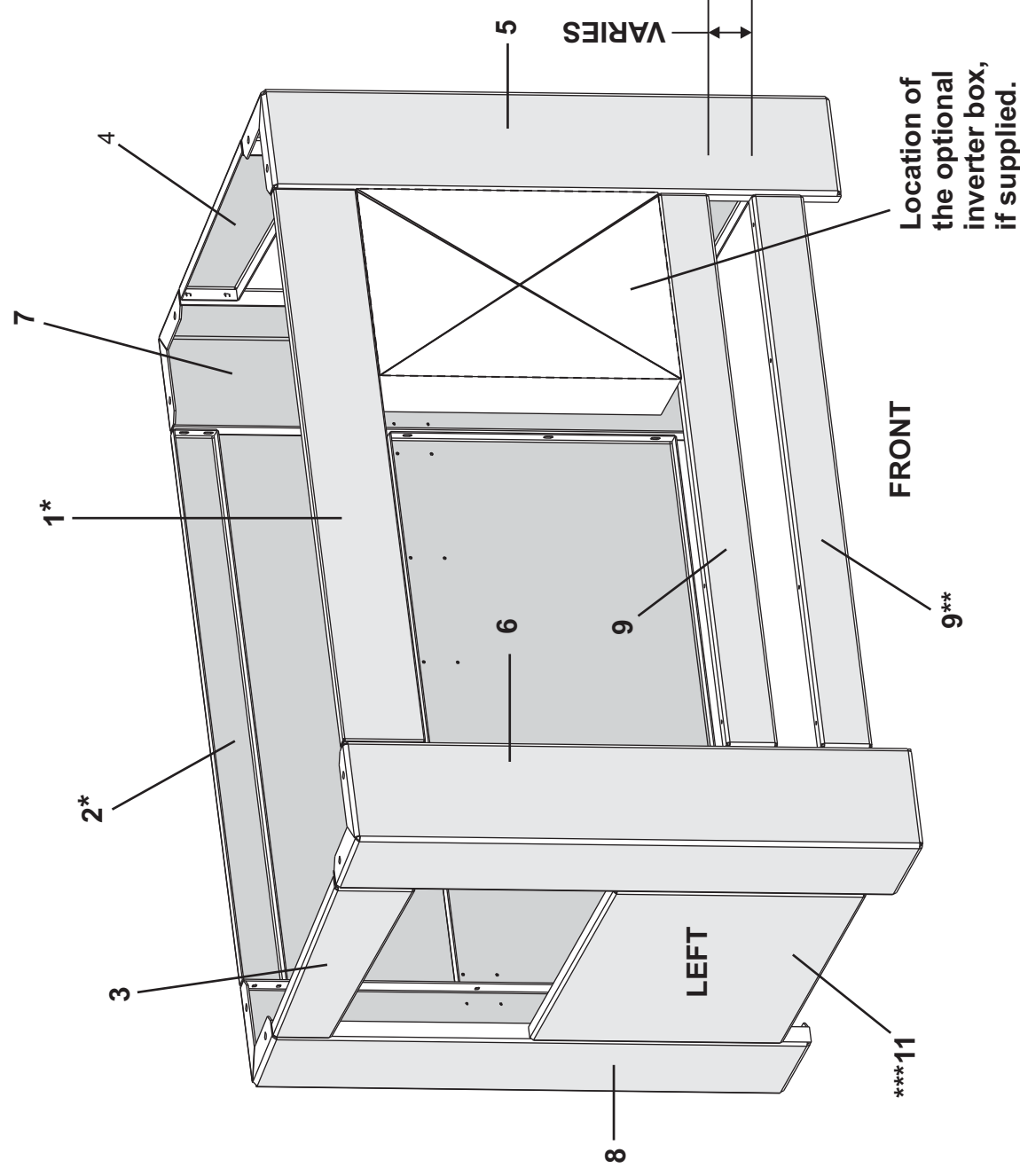
Litho in U.S.A.



**REAR / FRONT
CROSS BRACE**

Note*:

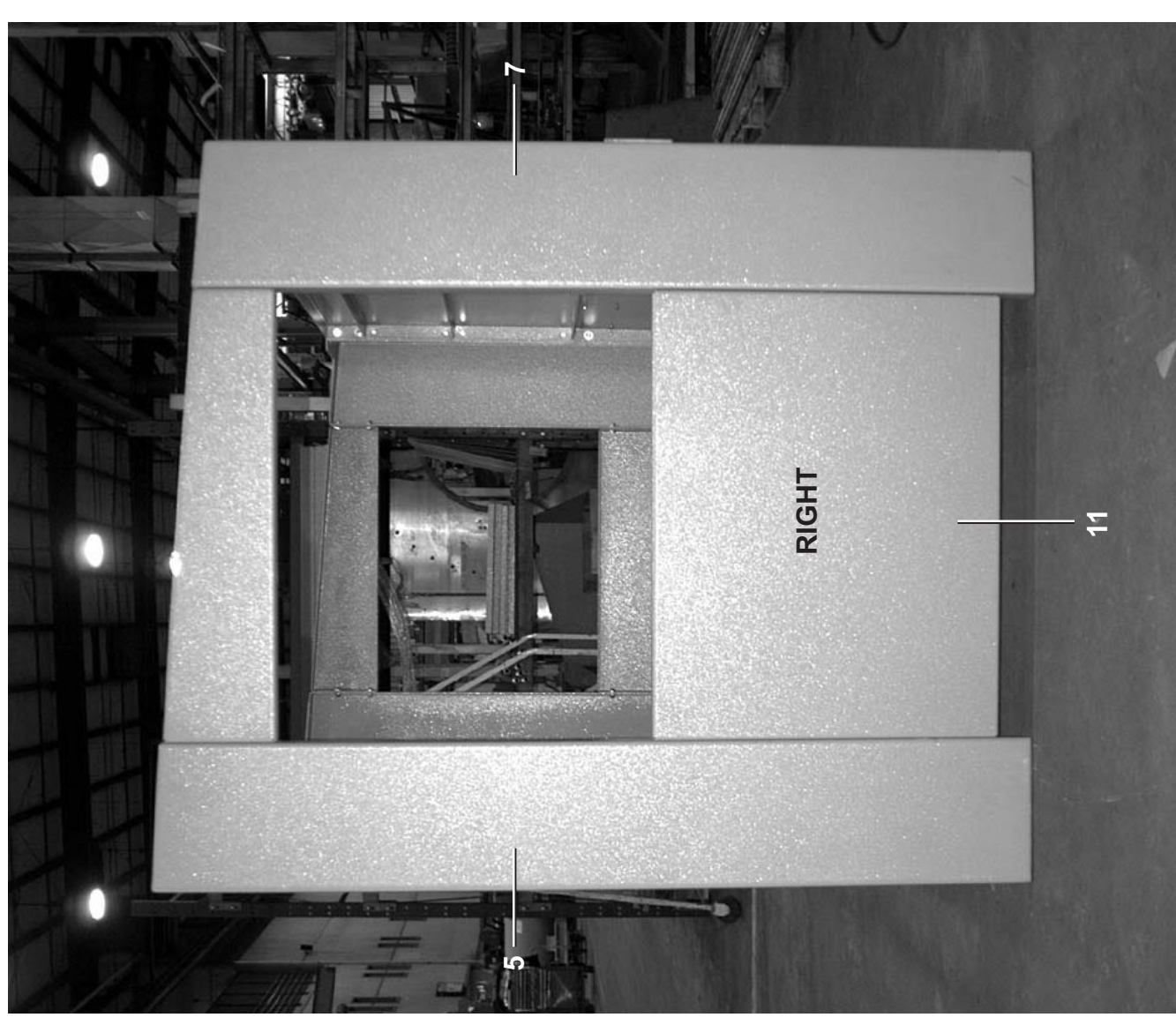
The upper front and upper rear cross braces are angled to match the angle of the pedestal legs. This angle may not be immediately apparent, you may need to use a level to identify the parts. Swapping these parts when assembling will cause the top flange to stick up above the rest of the pedestal and cause the dryer to sit incorrectly.



FOR MACHINES BUILT BEFORE 05/23/08, THE FRONT PANELS WERE 26" [660MM] TALL. SEE BMP030058.

Note**
Two Item 9** are used only in pedestals where the front leg heights are 58" [1473MM] or taller.

Note***
Item 11 is only supplied with pedestals where the front leg heights are 46-1/4" [1174MM] or taller.



Pedestal Base

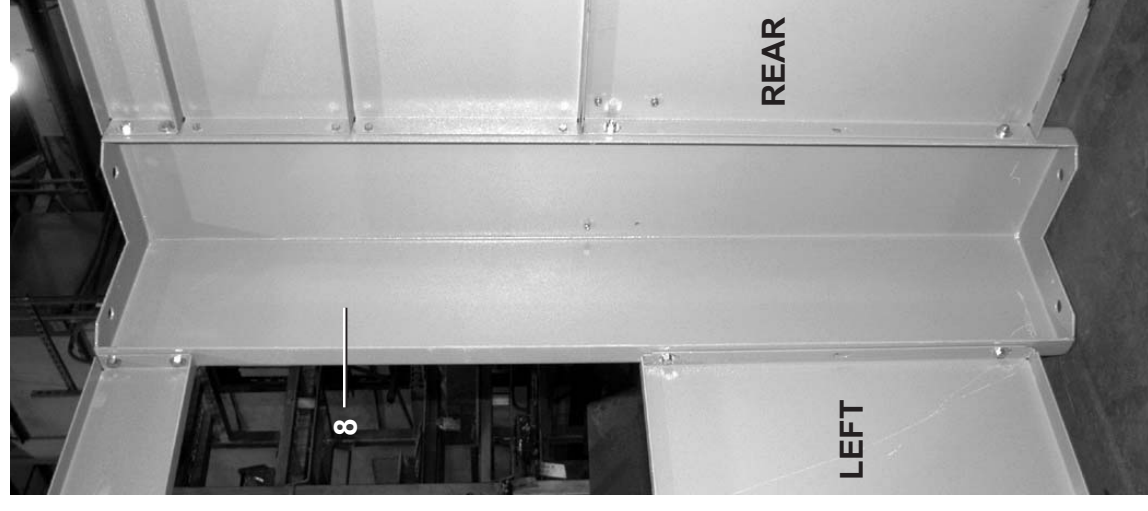
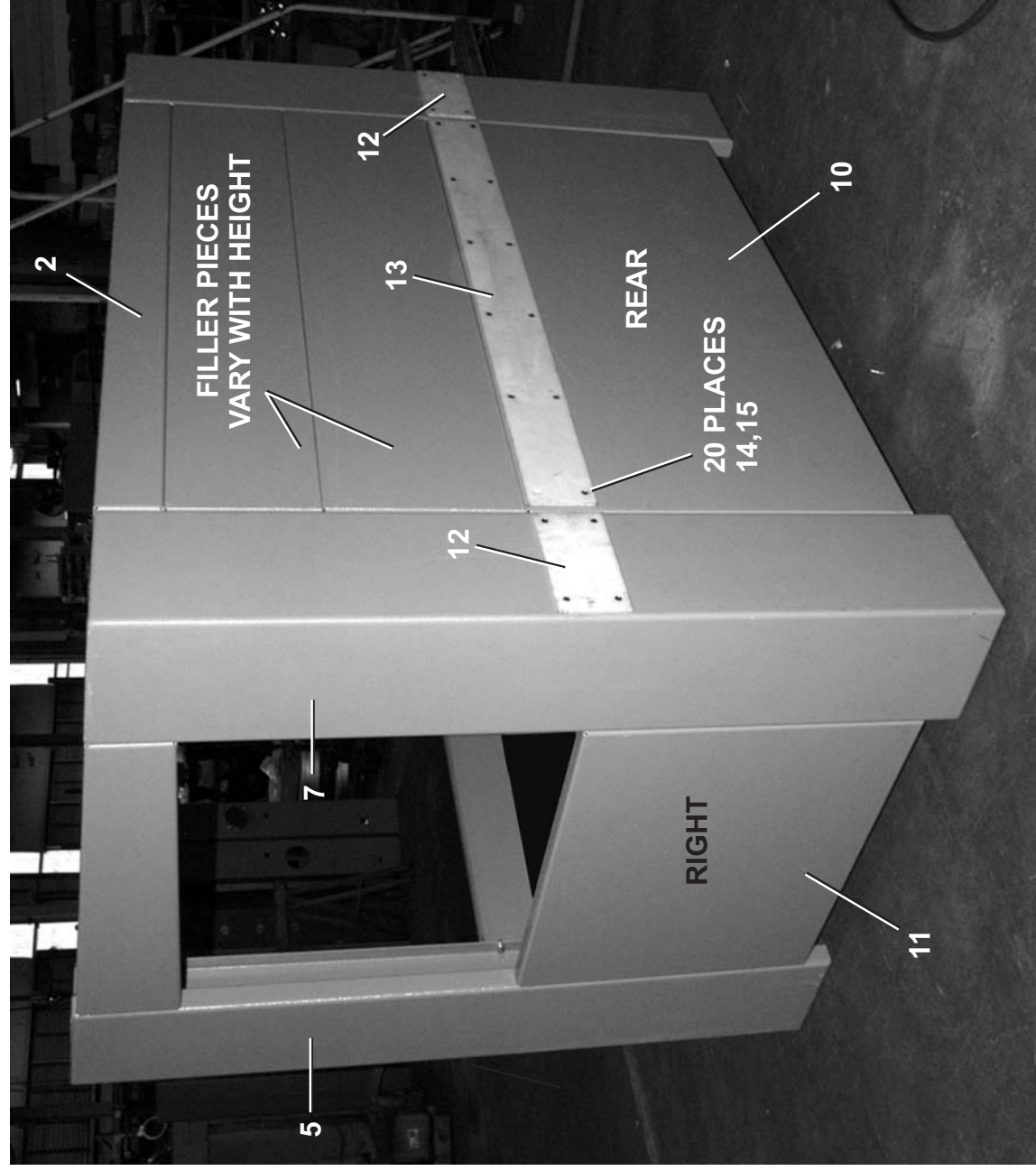
6458TG1L/R ,TS1L/R 6464TG1L/R ,TS1L/R



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(Sheet 2 of 3)

Litho in U.S.A.



FRONT LEGS:

ITEM 5	PART NUMBER	07-71320	07-71322	07-71324	07-71326	07-71328	07-71330	07-71332	07-71334	07-71336	07-71338	07-71340	07-71342	07-71344	07-71346	07-71348	07-71350	07-71352	07-71354	07-71356	07-71358	07-71360	07-71362	07-71300
ITEM 6	PART NUMBER	07-71320A	07-71322A	07-71324A	07-71326A	07-71328A	07-71330A	07-71332A	07-71334A	07-71336A	07-71338A	07-71340A	07-71342A	07-71344A	07-71346A	07-71348A	07-71350A	07-71352A	07-71354A	07-71356A	07-71358A	07-71360A	07-71362A	07-71300A
	PEDESTAL ORDER HEIGHT (IN.)	0.0	1.75	3.5	5.25	7.0	8.75	10.5	12.25	14.0	15.75	17.5	19.25	21.0	22.75	24.5	26.25	28.0	29.75	33.25	35.00	36.75	38.50	31.50
	LEG LENGTH (ITEMS 5&6) (IN.)	40.988	42.718	44.468	46.218	47.968	49.718	51.468	53.218	54.968	56.718	58.468	60.218	61.968	63.718	65.468	67.218	68.968	70.718	74.218	75.968	77.718	79.468	72.468

REAR LEGS:

ITEM 7	PART NUMBER	07-71321	07-71323	07-71325	07-71327	07-71329	07-71331	07-71333	07-71335	07-71337	07-71339	07-71341	07-71343	07-71345	07-71347	07-71349	07-71351	07-71353	07-71355	07-71357	07-71359	07-71361	07-71363	07-71301
ITEM 8	PART NUMBER	07-71321A	07-71323A	07-71325A	07-71327A	07-71329A	07-71331A	07-71333A	07-71335A	07-71337A	07-71339A	07-71341A	07-71343A	07-71345A	07-71347A	07-71349A	07-71351A	07-71353A	07-71355A	07-71357A	07-71359A	07-71361A	07-71363A	07-71301A
	PEDESTAL ORDER HEIGHT (IN.)	0.0	1.75	3.5	5.25	7.0	8.75	10.5	12.25	14.0	15.75	17.5	19.25	21.0	22.75	24.5	26.25	28.0	29.75	33.25	35.00	36.75	38.50	31.50
	LEG LENGTH (ITEMS 7&8) (IN.)	37.8	39.55	41.3	43.05	44.8	46.55	48.3	50.05	51.8	53.55	55.3	57.05	58.8	60.55	62.3	64.05	65.8	67.55	71.05	72.80	74.55	76.30	69.300

CHART CONTINUED >

Pedestal Base

6458TG1LR, TS1LR 6464TG1LR, TS1LR

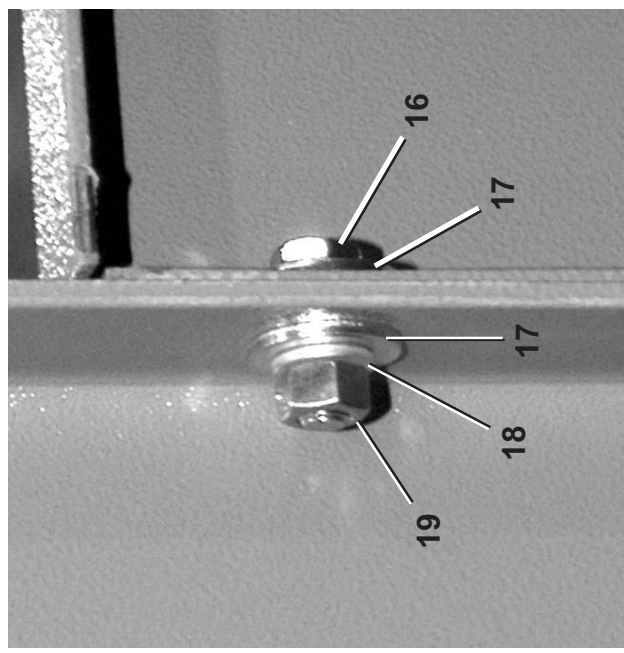


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(Sheet 3 of 3)

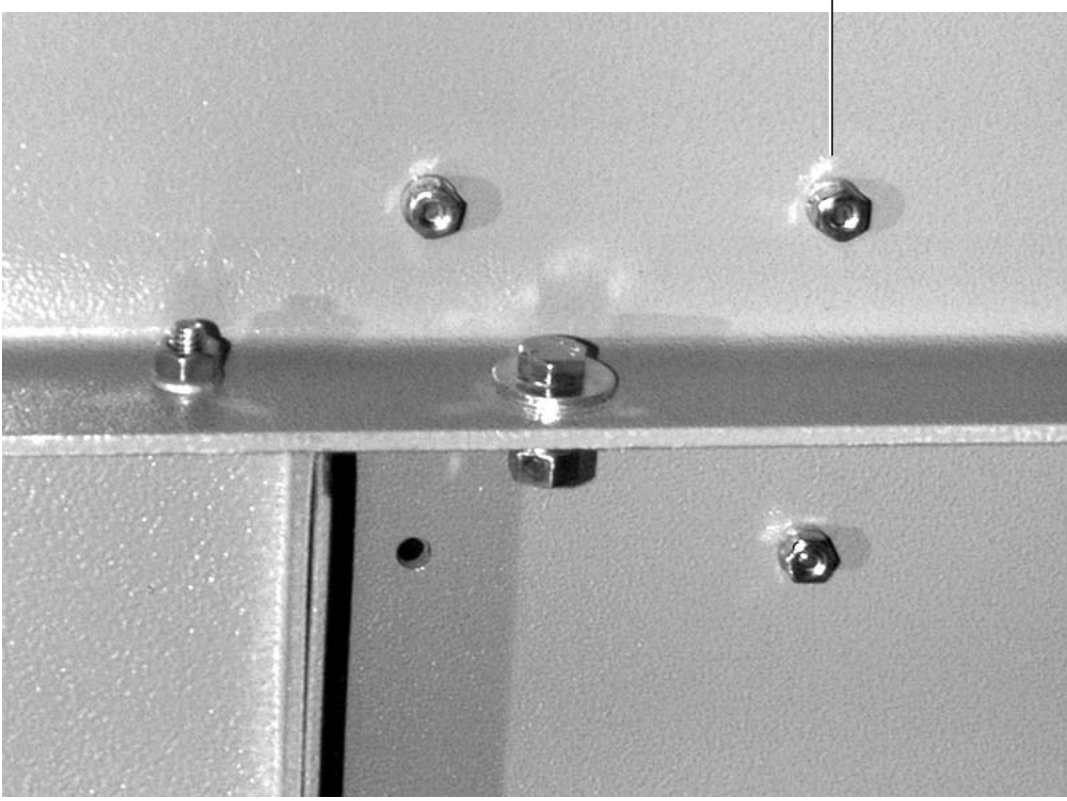
Litho in U.S.A.

Parts List—Pedestal Base Assembly
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.



TYPICAL 3/8" BOLTS

**BUMPER GUARD BOLTS (20 PLACES)
14, 15**



ADDITIONAL PEDESTAL HEIGHTS

FRONT LEGS:

ITEM 5	PART NUMBER	07 71389B	07 71389
ITEM 6	PART NUMBER	07 71389C	07 71389A
	PEDESTAL ORDER HEIGHT (IN.)	-3.5	-7
	LEG LENGTH (ITEMS 5&6) (IN.)	34	30.5

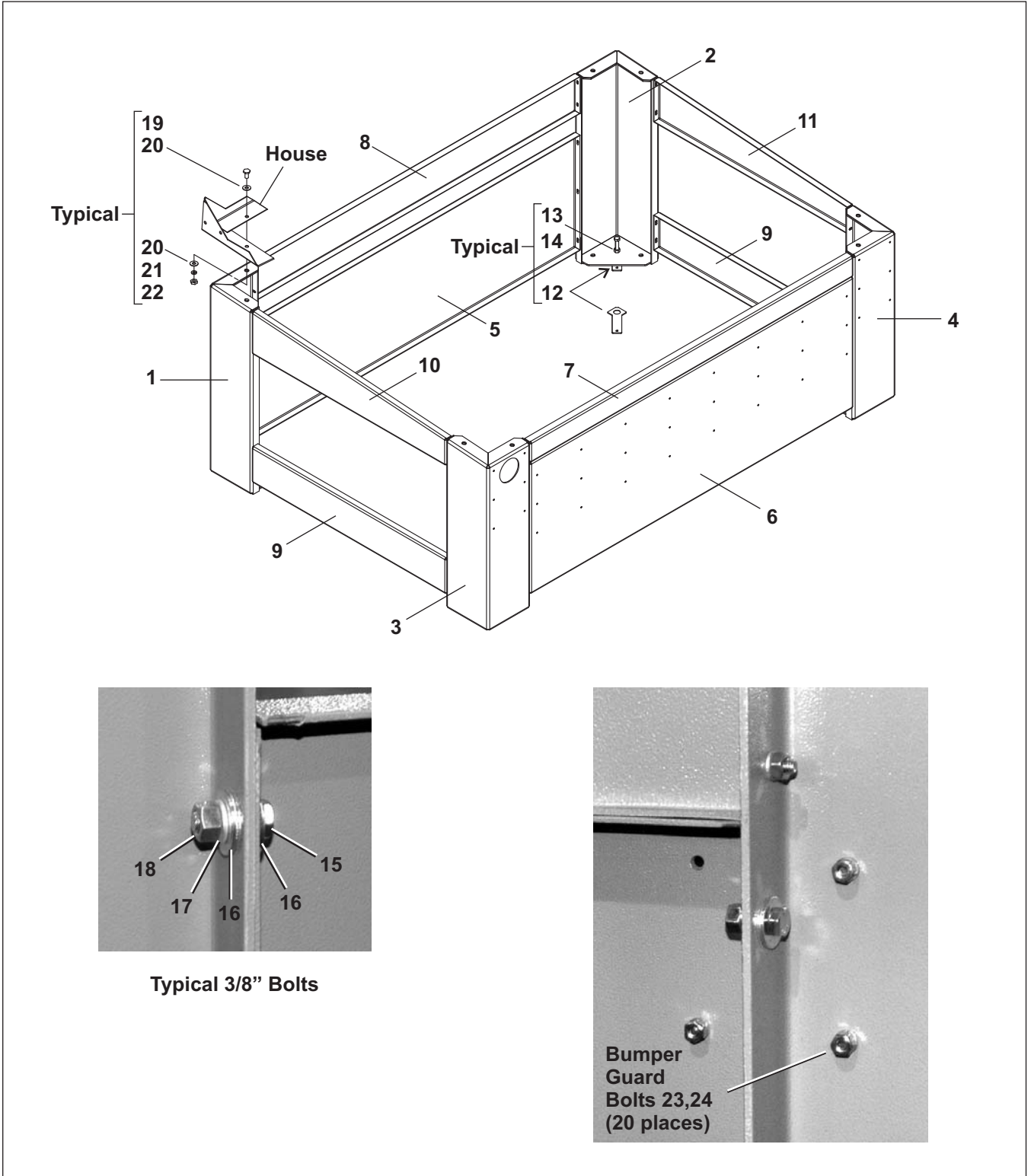
REAR LEGS:

ITEM 7	PART NUMBER	07 71390B	07 71390
ITEM 8	PART NUMBER	07 71390C	07 71390A
	PEDESTAL ORDER HEIGHT (IN.)	-3.5	-7
	LEG LENGTH (ITEMS 7&8) (IN.)	30.8	27.3

Used In	Item	Part Number	Description	Comments
			ASSEMBLIES	
			none	
			COMPONENTS	
all	1	07 71391	6458 DRYER BASE FILLER TOP FT	6458 DRYERS
all	2	07 71392	6458 DRYER BASE FILLER TOP RR	6464 DRYERS
all	3	07 71395	6458 DRYER BASE FILL DRV RITE	6458 DRYERS
all	3	07 72041	6464 DRYER BASE FILL DRV RIGHT	6464 DRYERS
all	4	07 71395A	6458 DRYER BASE FILL DRV LEFT	6458 DRYERS
all	4	07 72041A	6464 DRYER BASE FILL DRV LEFT	6464 DRYERS
all	5	07 71300	6458 = 31.5" PED FRONT RIGHT	
all	6	07 71300A	6458=31.5" PED FRONT LEFT	
all	7	07 71301	6458=31.5" PED REAR RIGHT	
all	8	07 71301A	6458=31.5" PED REAR LEFT	(2) USED FOR 17.5" PEDESTALS & HIGHER
all	9	07 71418	6458 DRYER FILLER INVERTER BOX	
all	10	07 71402	6458 DRYER BASE FILLER-REAR	
all	11	07 71396	6458 DRYER BASE FILL DRV LOW	
all	11	07 72042	6464 DRYER BASE FILL DRV LOW	
all	12	07 71404	6458 BUMPER PAD-5"WX10"LG	
all	13	07 71403	6458 BUMPER PAD-5"WX60"LG	
all	14	15G164NE	HEXLOK NUT NYL 1/4-20 UNC2A SS.	
all	15	15N176	FLATMACSCR 1/4-20NCX3/4SS18-8	
all	16	15K095	HXCPCSCR 3/8-16UNC2AX1 GR5 ZINC	
all	17	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	18	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	19	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	20	15K162	HXCAPSCR 1/2-13UNC2AX1.5 GR5 P	
all	21	15U490	FLAWASH 1+1/2X17/32X1/4ZINC	
all	22	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	23	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	24	15U280	FL+WASHER(USS STD)1/2 ZNC PL+D	

Pedestal Base

7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R



Pedestal Base

7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R

Parts List—Pedestal Base

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
-----COMPONENTS-----				
A	1	W7 81369	7272 NEG 3.5" PED FRONT RIGHT WELD	
B	1	W7 71320	7272=NO PED FRONT RIGHT WELD	
C	1	W7 71322	7272=3.5 PED FRONT RT WELD	
D	1	W7 71336	7272=14.00" PED FRONT RIGHT	
E	1	W7 71340	7272=17.5" PED FRONT RT WELD	
F	1	W7 71362	7272=24.5" PED FRONT RT WELD	
G	1	W7 71352	7272=28" PED FRONT RT WELD	
H	1	W7 85050	WLMT=7676 FRONT RIGHT STD PED	
J	1	W7 85054	WLMT=7676 FRONT RIGHT 17.50 PED	
K	1	W7 85052	WLMT=7676 FRONT RIGHT 21" PED	
L	1	W7 88201	8282 FRONT RIGHT STD PEDESTAL	
A	2	W7 81369A	7272 NEG 3.5" PED FRONT LEFT WELD	
B	2	W7 71320A	Q272=NO PED FRONT LEFT WELD	
C	2	W7 71322A	7272=3.5" PED FRONT LF WELD	
D	2	W7 71336A	7272=14.00" PED FRONT LEFT	
E	2	W7 71340A	7272=17.5" PED FRONT LF WELD	
F	2	W7 71362A	7272=24.5" PED FRONT LF WELD	
G	2	W7 71352A	7272=28" PED FRONT LF WELD	
H	2	W7 85050A	WLMT=7676 FRONT LEFT STD PED	
J	2	W7 85054A	WLMT=7676 FORNT LEFT 17.50 PED	
K	2	W7 85052A	WLMT=7676 FRONT LEFT 21" PED	
L	2	W7 88201A	8282 FRONT LEFT STD PEDESTAL	
A	3	W7 81379	7272 NEG 3.5" PED REAR RIGHT WELD	
B	3	W7 71321	7272=NO PED REAR RIGHT WELD	
C	3	W7 71323	7272=3.5" PED REAR RT WELD	
D	3	W7 71337	7272=14.00" PED REAR RIGHT	
E	3	W7 71341	7272=17.5" PED REAR RT WELD	
F	3	W7 71363	7272=24.5"PED REAR RT WELD	
G	3	W7 71353	7272=28" PED REAR RT WELD	
H	3	W7 85056	WLMT=7676 STD PED REAR RIGHT	
J	3	W7 85055	WLMT=7676 REAR RIGHT 17.50 PED	
K	3	W7 85051	WLMT=7676 REAR RIGHT 21" PED	
L	3	W7 88211	8282 STD PED REAR RIGHT WLMT	
A	4	W7 81379A	7272 NEG 3.5" PED REAR LEFT WELD	
B	4	W7 71321A	7272=NO PED REAR LEFT WELD	
C	4	W7 71323A	7272=3.5" PED REAR LF WELD	
D	4	W7 71337A	7272=14.00" PED REAR LEFT	
E	4	W7 71341A	7272=17.5" PED REAR LF WELD	
F	4	W7 71363A	7272=24.5" PED REAR LF WELD	
G	4	W7 71353A	7272=28" PED REAR LF WELD	
H	4	W7 85056A	WLMT=7676 STD PED REAR LEFT	
J	4	W7 85055A	WLMT=7676 REAR LEFT 17.50 PED	
K	4	W7 85051A	WLMT=7676 REAR LEFT 21" PED	
L	4	W7 88211A	8282 STD PED REAR LEFT WLMT	
A-K	5	07 81393	7272 DRYER BASE FILLER FNT+R	
L	5	07 88206	8282 DRYER FILLER INVERTER BOX	
A-K	6	07 81402	7272 DRYER BASE FILLER-REAR	
L	6	07 88208	8282 DRYER BASE FILLER-REAR	
A-K	7	07 81392	7272 DRYER BASE FILLER TOP R	

Pedestal Base

7272TG1L/R,TS1L/R 7676TG1L/R 8282TG1L/R

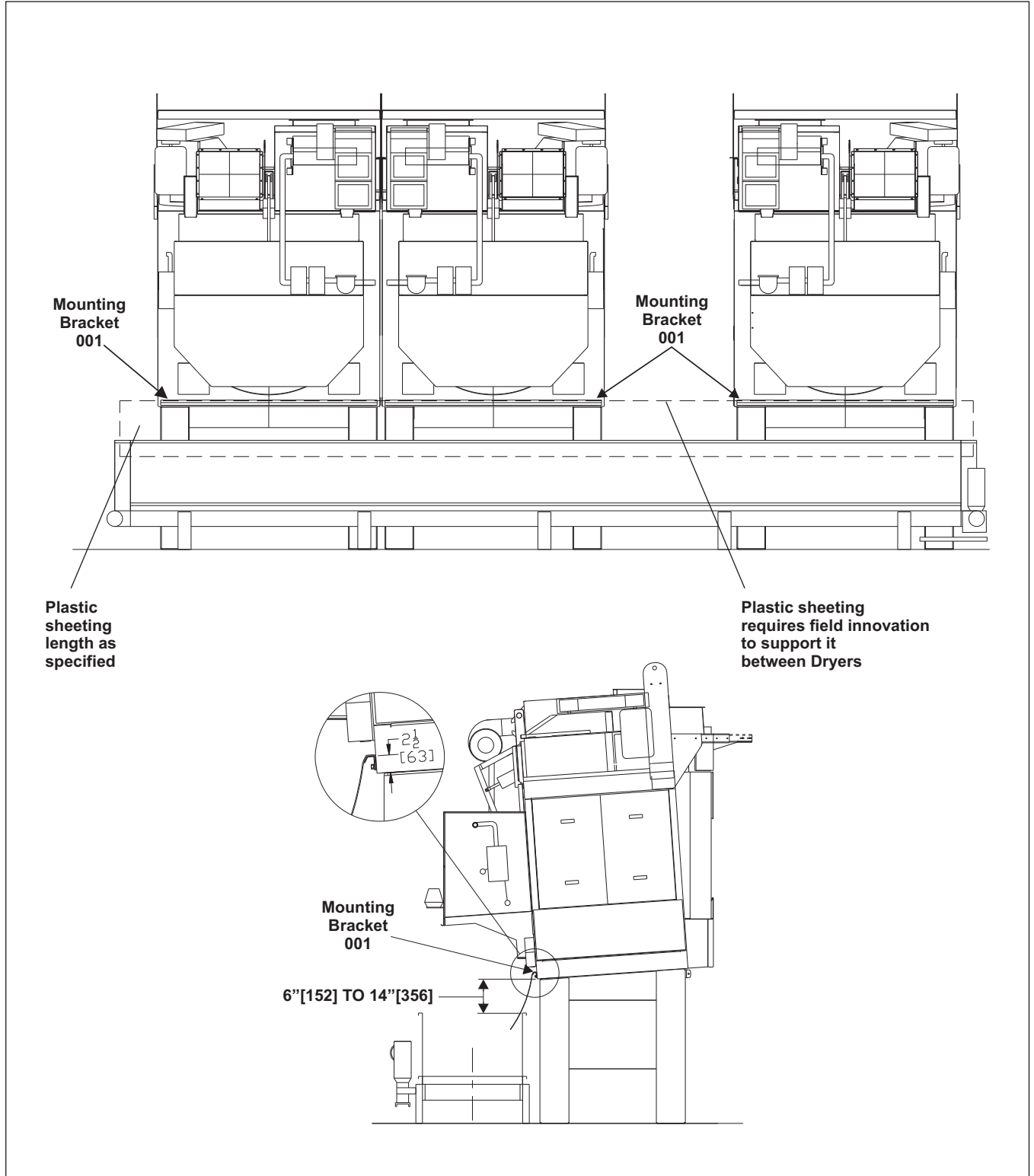
Parts List—Pedestal Base

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
L	7	07 88207	8282 DRYER BASE FILLER TOP RR	
A-K	8	07 81391	7272 DRYER BASE FILLER TOP F	
L	8	07 88205A	8282 PED TOP FRNT PLATE	
A-G	9	07 81396	7272 DRYER BASE FILL DVR LOW	
H-K	9	07 85096	7676 DRYER BASE FILLDVR LOW	
L	9	07 88209	8282 DRYER BASE FILL DVR LOW	
A-K	10	07 85049	7676 DRYER BASE FILL UPPER RIGHT	
L	10	07 88210	8282 DRYER BASE FILL UPPER RIGHT	
A-K	11	07 85049A	7676 DRYER BASE FILL UPPER LEFT	
L	11	07 88210A	8282 DRYER BASE FILL UPPER LEFT	
all	12	07 71579	DRYER JACKING BOLT WASHER	
all	13	15K226	HXTAPSCR 5/8-11UNC2AX3 GR5 ZIN	
all	14	15G238N	HXLOCKNUT NYL 5/8-11UNC STL/	
all	15	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	16	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	17	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	18	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	19	15K190A	HEXTAPSCR 1/2-13X2.5 ZINC GR5F	
all	20	15U490	FLTWASH 1+1/2X17/32X1/4 ZINC	
all	21	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	22	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	23	15N176	FLATMACSCR 1/4-20NCX3/4SS18-8	
all	24	15G164NE	HEXLOKNUT NYL 1/4-20 UNC2A SS.	

Unload Bridge Installation

5040, 5050, 6450, 6458, 6464, 7272, 7676, & 8282 Dryers



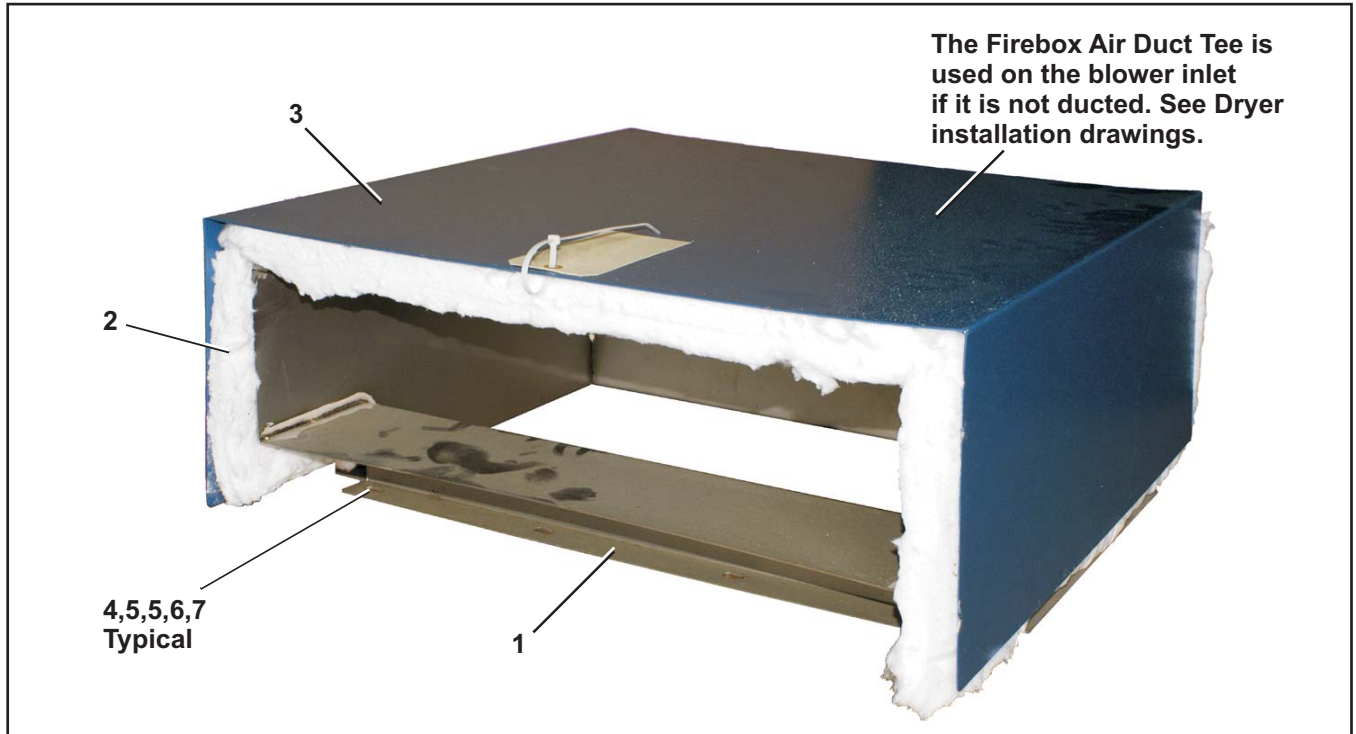
Unload Bridge Installation

5040, 5050, 6450, 6458, 6464, 7272, 7676, & 8282 Dryers

Parts List—Unload Bridge Installation				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----REFERENCE-----				
	A			5040 DRYERS
	B			5050 DRYERS
	C			6450, 6458 DRYERS
	D			6464 DRYERS
	E			7272 DRYERS
	F			7676 DRYERS
	G			8282 DRYERS
-----COMPONENTS-----				
AB	1	07 44230	5040 UNLOAD BRIDGE TO CONV	
CD	1	07 71568	6458 UNLOAD BRIDGE TO CONV	
EF	1	07 71569	7272 UNLOAD BRIDGE TO CONV	
G	1	07 88094	8282 UNLOAD BRIDGE TO CONV	

Firebox Air Duct Tee

5040TG1L/R, 5050TG1L/R, 6450TG1L/R, 6458TG1L/R 6464TG1L/R 7272TG1L/R 7676TG1L/R 8282TG1L/R



Parts List—Firebox Air Duct Tee

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

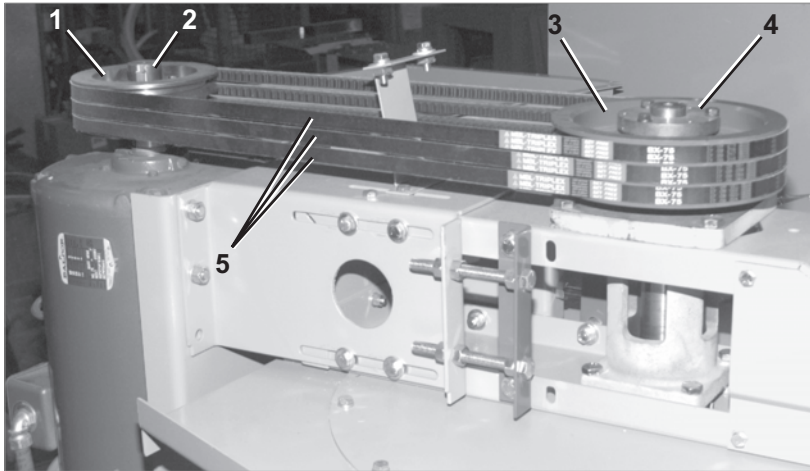
Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	A74AD001	5050 FB AIR DUCT TEE	5040, 5050
	B	A77AD001	6458 FB AIR DUCT TEE	6450, 6458, 6464
	C	A79AD001	7676 FB AIR DUCT TEE	7272, 7676
	D	A82AD001	8282 FB AIR DUCT TEE	8282
-----COMPONENTS-----				
A	1	W7 44394	5050 FB AIR DUCT TEE WLMT	
B	1	W7 72197	6458 FB AIR DUCT TEE WLMT	
C	1	W7 85194	7676 FB AIR DUCT TEE	
D	1	W7 88230	8282 FB AIR DUCT TEE	
all	2	98P031	INSUL 1-1/2"X48"X12-1/2' 6LB DURABLANKET 2300F	
A	3	07 44400	5050 FB AIR DUCT TEE COVER	
B	3	07 72213	6458 FB AIR DUCT TEE COVER	
C	3	07 85198	7676 FB AIR DUCT TEE COVER	
D	3	07 88233	8282 FB AIR DUCT TEE COVER	
all	4	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	5	15U201	FLATWASH 7/80DX3/8IDX.062THK S	
all	6	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	7	15G198	HXFLGNUT 3/8-16 ZINC	

Drive Assemblies

4

Drive Chart

6450, 6458, 6464 Dryers

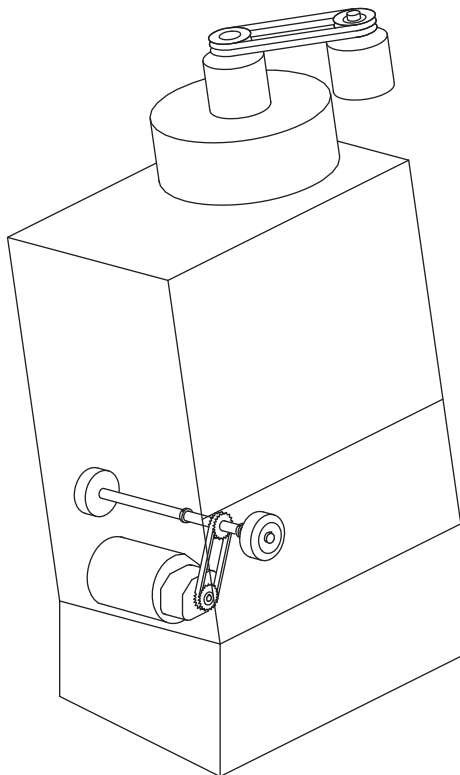


BLOWER DRIVE

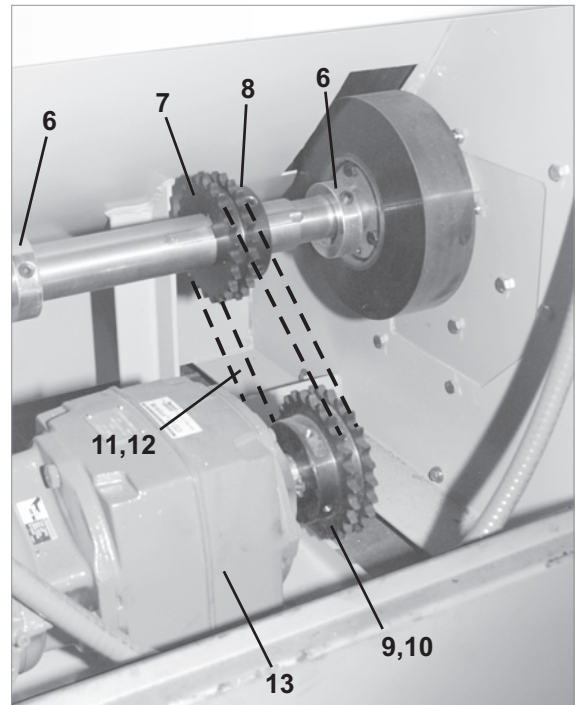
NOTE:

Effective 1/10/08 the cylinder drive gear reducer and sprocket were changed on all 6458 Dryers as reflected on this drawing's parts list. The new gear reducer (item 13) is usable to repair all 6458 Dryers.

For Dryers produced before 1/10/08, the new drive sprocket and bushing (items 9 & 10) must also be ordered.

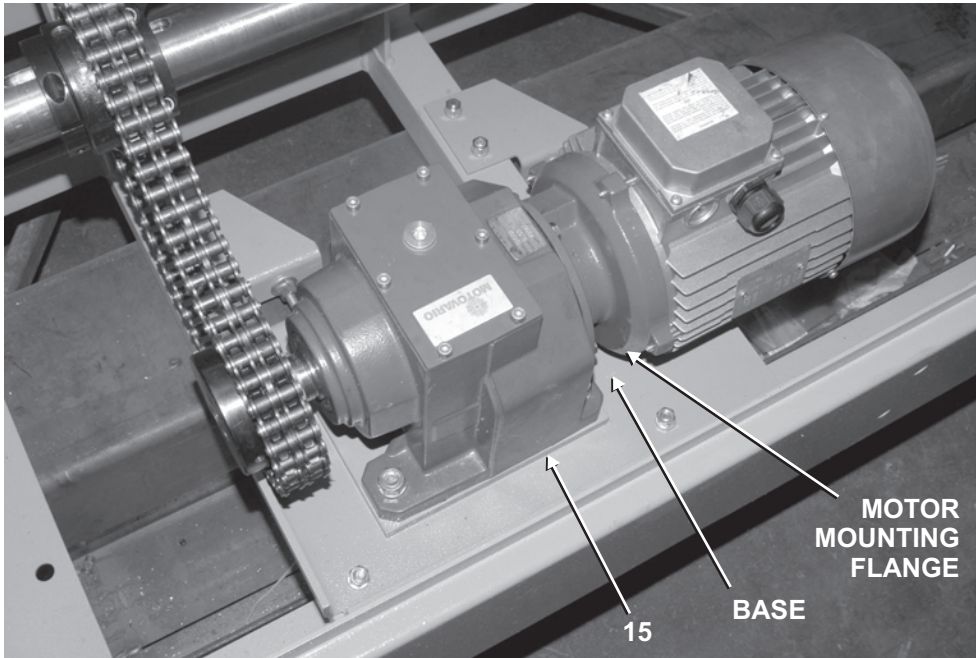


CYLINDER DRIVE



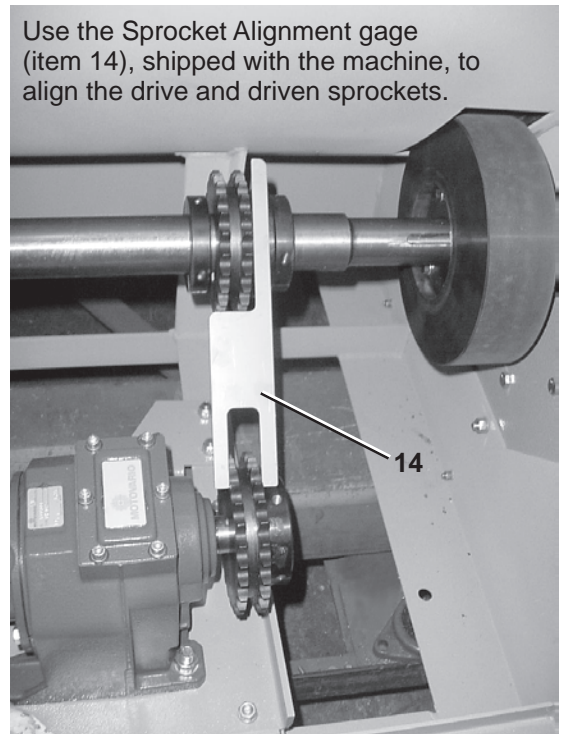
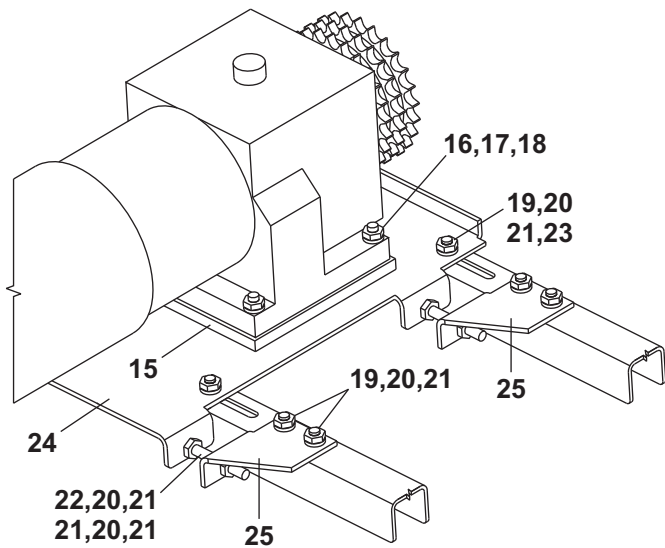
Drive Chart

6450, 6458, 6464 Dryers



Spacer (item 15) must be installed to provide sufficient clearance between the motor mounting flange and base.

Use the Sprocket Alignment gage (item 14), shipped with the machine, to align the drive and driven sprockets.



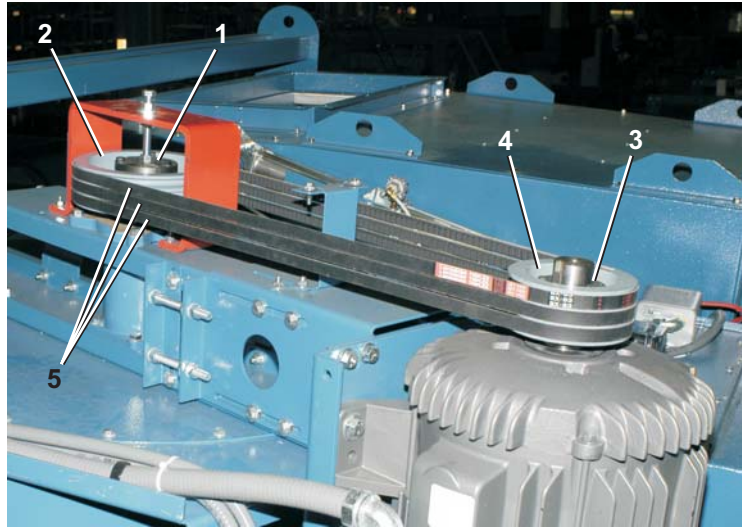
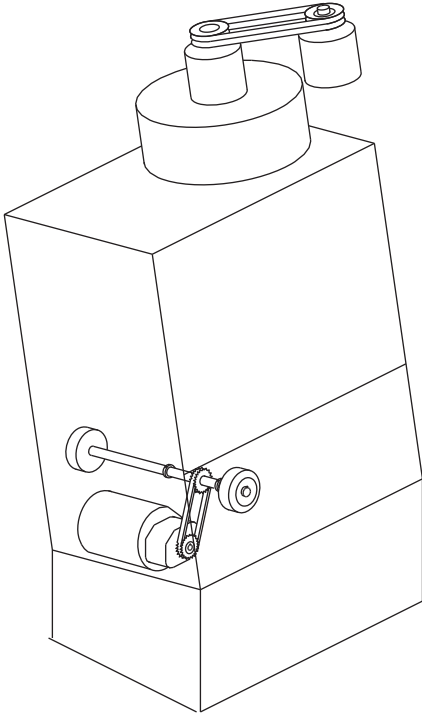
Drive Chart

6450, 6458, 6464 Dryers

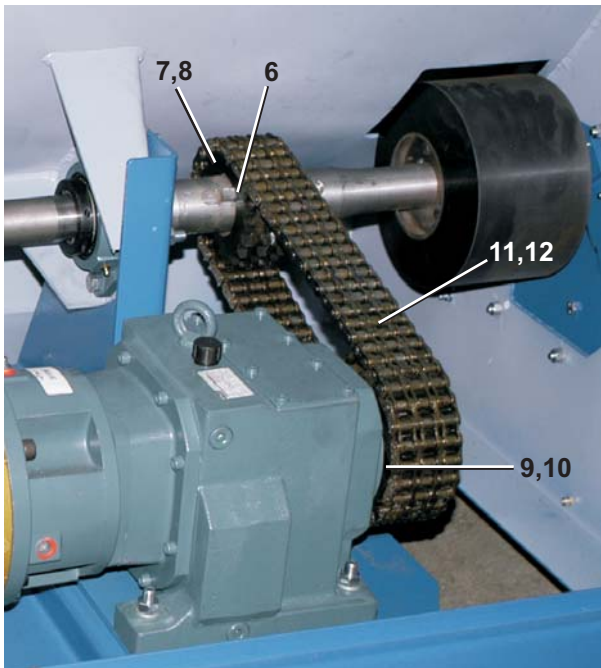
Parts List—Drive Chart				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----REFERENCE ASSEMBLIES-----				
	A	D77 00350	DRIVE CHART 6450DRYER 50 CYC	6450 50 CYC
	B	D77 00360	DRIVE CHART 6450DRYER 60 CYC	6450 60 CYC
	C	D77 00250	DRIVE CHART 6458DRYER 50 CYC	6458, 6464 50 CYC
	D	D77 00260	DRIVE CHART 6458DRYER 60 CYC	6458, 6464 60 CYC
-----COMPONENTS-----				
A	1	56062B3SD	VPUL 3B6.2/A5.8 (SD) TYPE QD	
B	1	56048B3SD	VPUL 3B4.8 (SD) TYPE QD	
C	1	56080B3SK	VPUL 3B8.0/A7.6 (SK) TYPE QD	
D	1	56066B3SD	VPUL 3B6.6/A6.2 (SD) TYPE QD	
all	2	56Q1MSD	1+5/8" BUSH QD TYPE SD=MUST HAVE KEY	
all	3	56086B3SK	VPUL 3B8.6/A8.2 (SK) TYPE QD	
all	4	56Q1GSK	1+3/8" BUSH VPUL QD TYPE SK	
AC	5	56VB078X	VBELT BX78 RAWEDGE COG	3 REQUIRED
B	5	56VB073XM2	VBELT BX73 EA=1BELT	3 REQUIRED
D	5	56VB075XM3	VBELT BX75 EA=1BELT	3 REQUIRED
all	6	54JH22000C	SHFTCOLL 2"ID DBLSPLT CARSTL	
all	7	54N060B21A	SPRKT D60BTB21H 1+15/16TPRBORE (WT=4LBS)	
all	8	56Q1TB1	1+15/16 BUSH, MARTIN #2517 1+15/16	
all	9	54N060B25	SPRKT D60BTB25H-TPRLK (2517) (WT.=8 LBS)	
all	10	56Q1ETB	1+1/4" TAPRLOCKBUSH (2517)	
all	11	54G060SP3F	SOLID BUSH CHN 60-2DBL 39"LG 52 PITCHES	REPLACEMENT CHAIN FOR ALL 6450, 6458, 6464
all	12	20H011CG	GADUS S2 HIGH SPEED #550027655 EA=1 TUBE	
all	13	39F1923BN	3HP GEARMTR 230+3P60 CH052	
all	14	07 71752	SPROCKET ALIGNMENT GAGE-6458	
all	15	07 71464	6458 GEAR REDUCER SPACER	
all	16	15K191	HXCAPSCR 1/2-13UNC2AX2.5 GR5 Z	
all	17	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	18	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	19	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	20	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	21	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	22	15B110	HXTAPBOLT 3/8-16UNC2X5 FULTHD	
all	23	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	24	07 71165A	64" DRYER RT GEAR MTR SUPP PLATE	
all	25	07 71166A	50&64" DRYER RT MTR MNT ADJ BOLT BKT	

Drive Chart

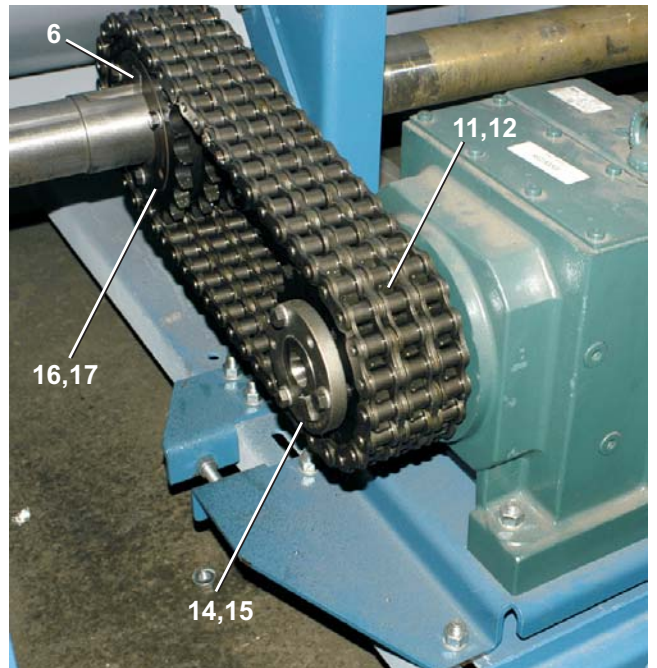
7676TG1L/R 8282TG1L/R



Blower Drive



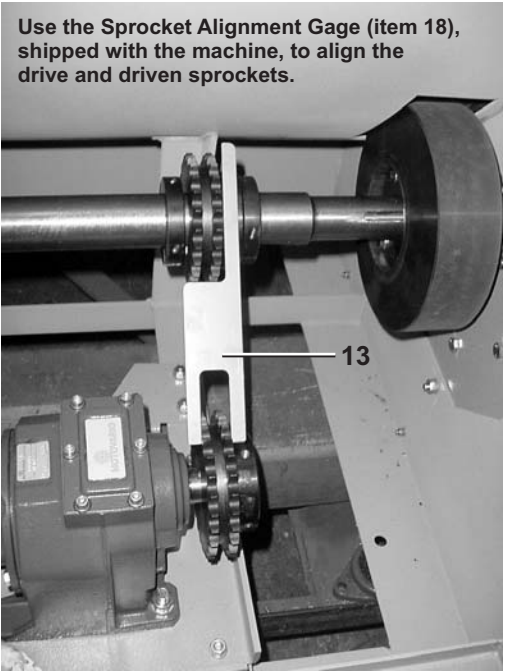
**Cylinder Drive
7676**



**Cylinder Drive
8282**

Drive Chart

7676TG1L/R 8282TG1L/R



Use the Sprocket Alignment Gage (item 18), shipped with the machine, to align the drive and driven sprockets.

Parts List—Drive Chart

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	D79 00160B	DRIVE CHART 7676DRYER 60 CYC CHAIN	76076TG1L, 76076TG1R
	B	D82 00160	DRIVE CHART 8282 DRYER 60 CYC	82082TG1L, 82082TG1R
-----COMPONENTS-----				
all	1	56Q1GSK	1+3/8" BUSH VPUL QD TYPE SK	
all	2	56086B3SK	VPUL 3B8.6/A8.2 (SK) TYPE QD	
all	3	56Q1RSD	1+7/8" BUSH VPUL QD TYPE SD	
all	4	56052B3SD	VPUL 3B5.2/A4.8 (SD) TYPE QD	
all	5	56VB083X	VBELT BX83 RAWEDGE COG	
A	6	15E238	7676 DRIVE STEP KEY	
B	6	15E239	3/4" X 3/4" X 5.00" KEY	
A	7	54N060E21	SPRKT E60Q21H TRIPLE STYLE MST Q1 BUSHING	
A	8	56Q2EB2	BUSH, MARTIN Q1 2+3/8 DUCTILE	
A	9	54N060E26	SPRKT E60Q26H TRIPLE STYLE MST Q1 BUSHING	
A	10	56Q1MB2	1+5/8 BUSH, MARTIN Q1 SINTERED METAL	
A	11	54G060SP3	SOLID BUSH TRIPLE CHN 60-3 = 3.875FT (46.5")	
B	11	54G080SP3	SOLID BUSH TRIPLE CHN 80-3 = 50" LONG	

Drive Chart

7676TG1L/R 8282TG1L/R

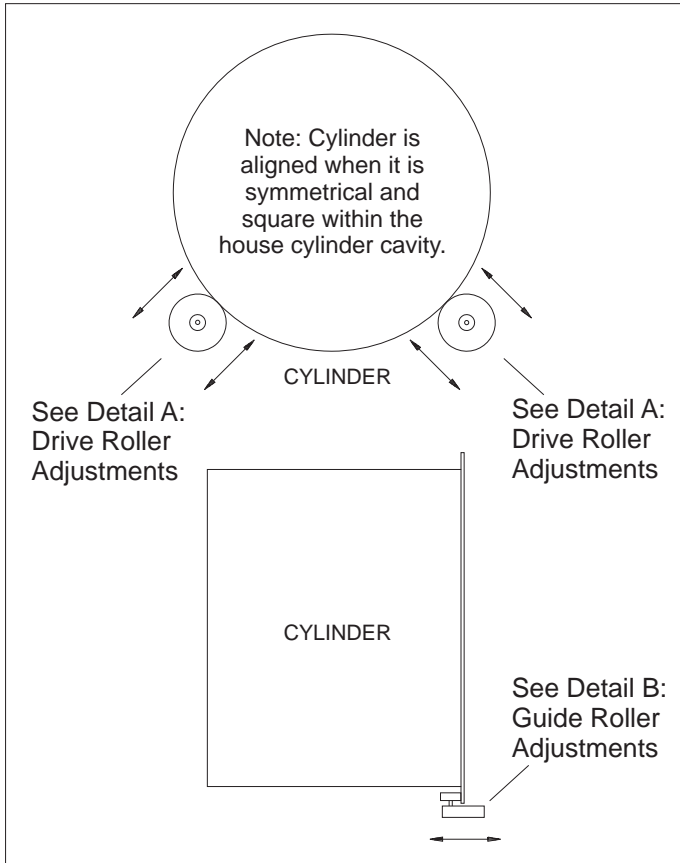
Parts List—Drive Chart

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

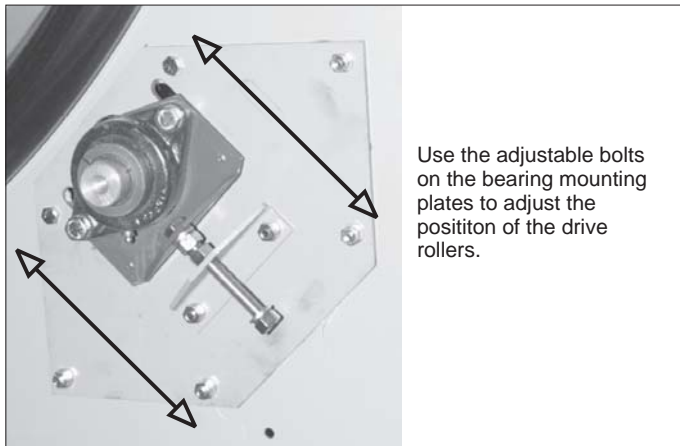
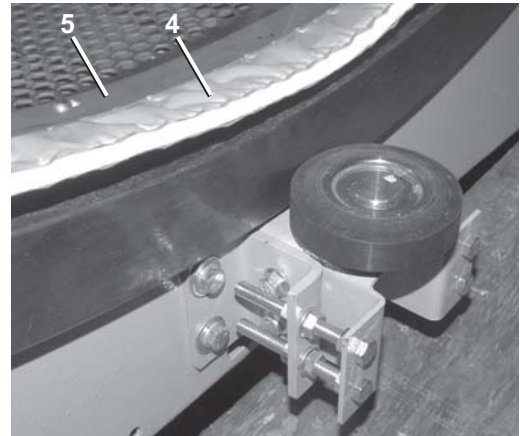
Used In	Item	Part Number	Description	Comments
all	12	20H011CG	ALVANIA CG1 GREASE EA=1 TUBE	
all	13	07 71753	SPROCKET ALIGNMENT GAGE-7272	
B	14	54N080E23	SPRKT E80R23H TRIPLE STYLE MST R1 BUSHING	
B	15	56Q2TR1A	2+15/16" BUSHING MST TYPE R1	
B	16	54N080E19	SPRKT E80Q19H TRIPLE STYLE MST Q2 BUSHING	
B	17	56Q2CQ2	2+1/8" BUSHING MST TYPE Q2	

Cylinder Installation

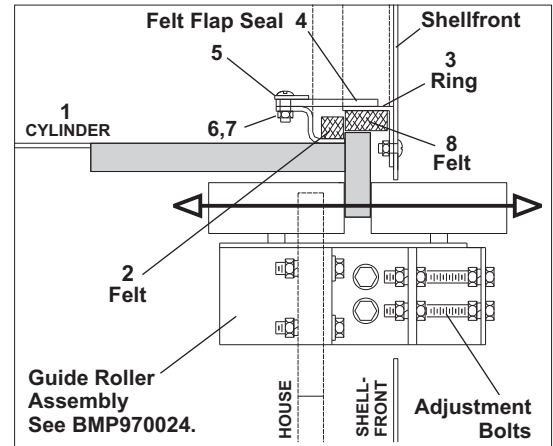
6450TG1L/R, TS1L/R, 6458TG1L/R, TS1L/R 6464TG1L/R, TS1L/R
 7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R



Cylinder Alignment Adjustments



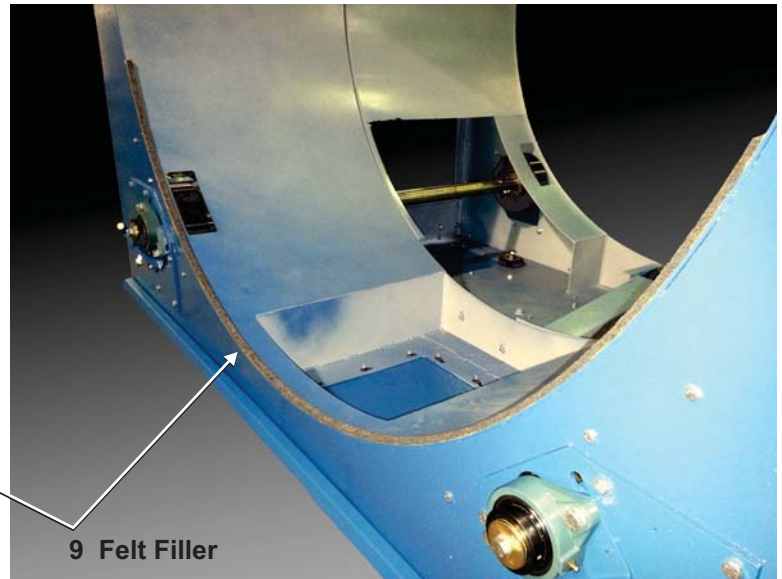
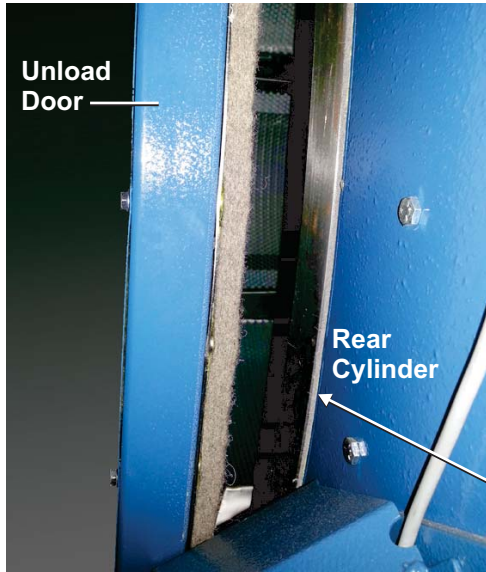
Detail A: Drive & Support Roller Adjustments



Detail B: Guide Roller Adjustments
 (Adjusts Front/Rear Position of Cylinder)

Cylinder Installation

6450TG1L/R,TS1L/R, 6458TG1L/R,TS1L/R 6464TG1L/R,TS1L/R
 7272TG1L/R,TS1L/R 7676TG1L/R 8282TG1L/R



Side View: Unload Door

Parts List—Cylinder Installation

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
-----REFERENCE ASSEMBLIES-----				
	A	A77FS001	6458 FRONT FLAP SEAL ASSY	6458, 6464 Dryers
	B	A79FS001	7272 FRONT FLAP SEAL ASSY	7272 Dryers
	C	G79FS020	7676 FRONT FLAP SEAL INSTALL	7676 Dryers
	D	G82FS001	8282 FRONT FLAP SEAL INSTALL	8282 Dryers
-----COMPONENTS-----				
	1	A77CA031	6450 BASKET STANDARD	6450
	1	A77CA032	6450 BASKET TEFLON COAT	6450
	1	A77CA033	6450 BASKET HI-TEMP COAT	6450
	1	A77CA011	6458 BASKET STANDARD	6458
	1	A77CA012	6458 DRYER BASKET TEFLON COAT	6458
	1	A77CA014	6458 HITEMCO COATED BASKET	6458
	1	A77CA021	6464 DRYER BASKET STANDARD	6464
	1	A77CA022	6464 DRYER BASKET TEFLON COAT	6464
	1	A77CA023	6464 DRYER BASKET HITEMP COATING	6464
	1	A79CA002	7272TG1L+R=BASKET FINAL WELD/MACH	7272
	1	A79CA003	7272 DRYER BASKET TEFLON COAT	7272

Cylinder Installation

6450TG1L/R,TS1L/R, 6458TG1L/R,TS1L/R, 6464TG1L/R,TS1L/R
 7272TG1L/R,TS1L/R, 7676TG1L/R, 8282TG1L/R

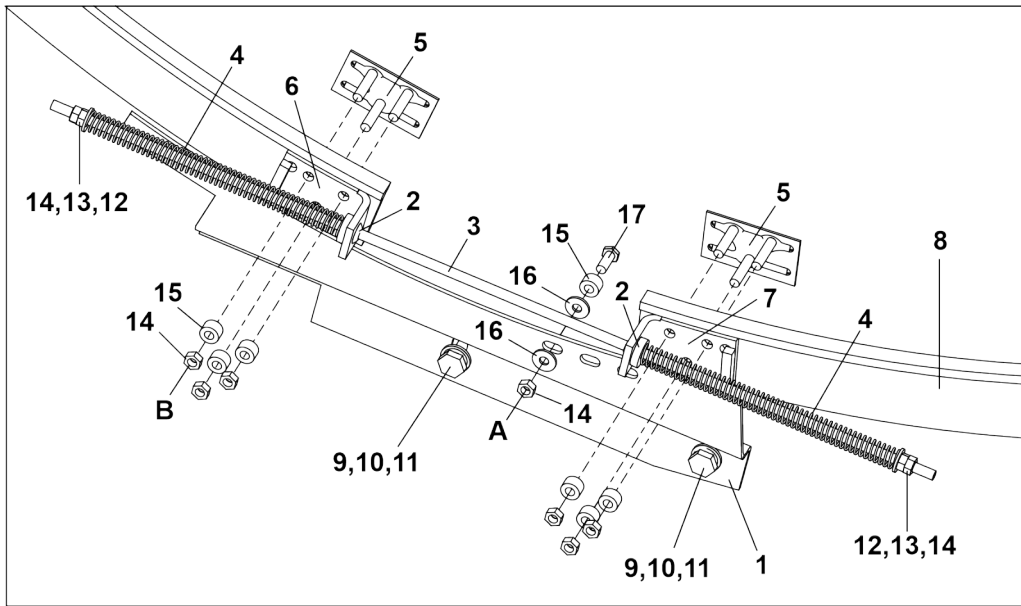
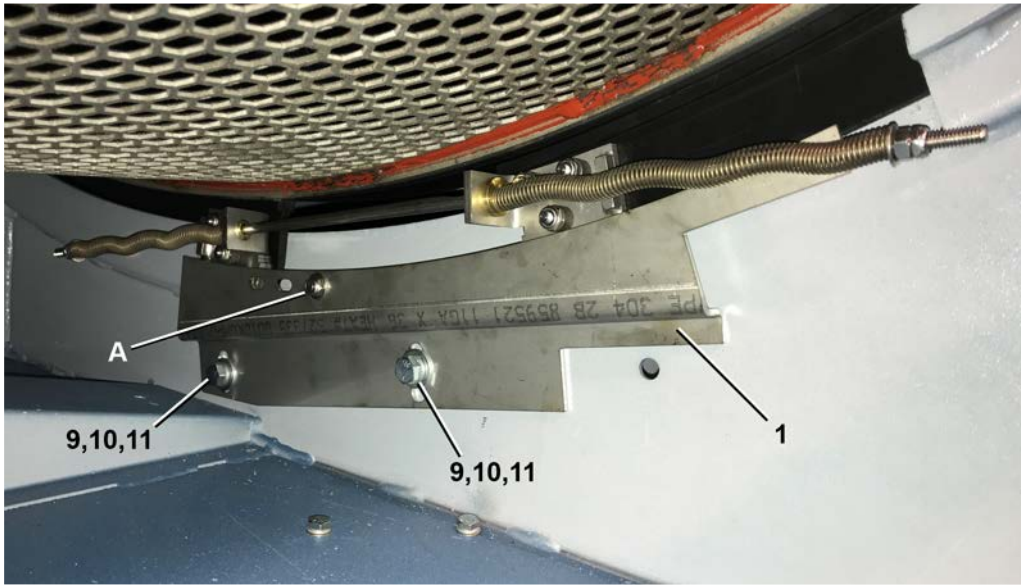
Parts List—Cylinder Installation

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
	1	A79CA021	7676TG1L+R=BASKET FINAL MACH/WELD	7676
	1	A79CA023	7676TG1L+R=BASKET TEFLON COAT	7676
	1	A82CA001	8282 BASKET STANDARD	8282
AD	2	27A686	FELT 3/4"THKX1/2"W F7=0.67	
BC	2	27A686A	FELT 3/4"THKX3/4"W	
A	3	07 71212	FRONT SEAL COSMETIC RING	
B	3	07 81212	7272 FRONT SEAL COSM RING	
C	3	W7 85212	7676 FRONT SEAL COSM RING WELD	
D	3	W7 88104	8282 FRONT SEAL COSMETIC RING WELD	
A	4	07 71226A	6458 FRONT SEAL/FELT/NOMEX	
B	4	07 81226A	7272 FRONT SEAL/FELT/NOMEX	
C	4	07 85226	7676 FRONT SEAL/FELT/NOMEX	
D	4	07 88071	8282 FRONT SEAL/FELT/NOMEX	
A	5	07 71117	6458 CYL SEAL RETAINER STRIP	
B	5	07 81117	7272 CYL SEAL RETAINER STRIP	
C	5	07 85117	7676 CYL SEAL RETAINER STRIP	
D	5	07 88070	8282 FRONT SEAL RETAINER STRIP	
all	6	15K033	BUTSOKCAPSCR 1/4-20X5/8 SS18-8	
all	7	15G164NE	HEXLOKNUT NYL 1/4-20 UNC2A SS.	
All	8	27A685	FELT 1/2"THK X 1+1/4"W SAE F-7	
All	9	27A679	FELT 1/4"THK X 1/2"W F6	

T-Seal Assembly

6450TG1L/R, 6458TG1L/R, 6464TG1L/R, 7272TG1L/R, 7676TG1L/R, 8282TG1L/R



Legend

A . . . Mechanical Stop Bolt

B . . . 6 instances

T-Seal Assembly

6450TG1L/R, 6458TG1L/R, 6464TG1L/R, 7272TG1L/R, 7676TG1L/R, 8282TG1L/R

Table 1. Parts List—T-Seal Assembly

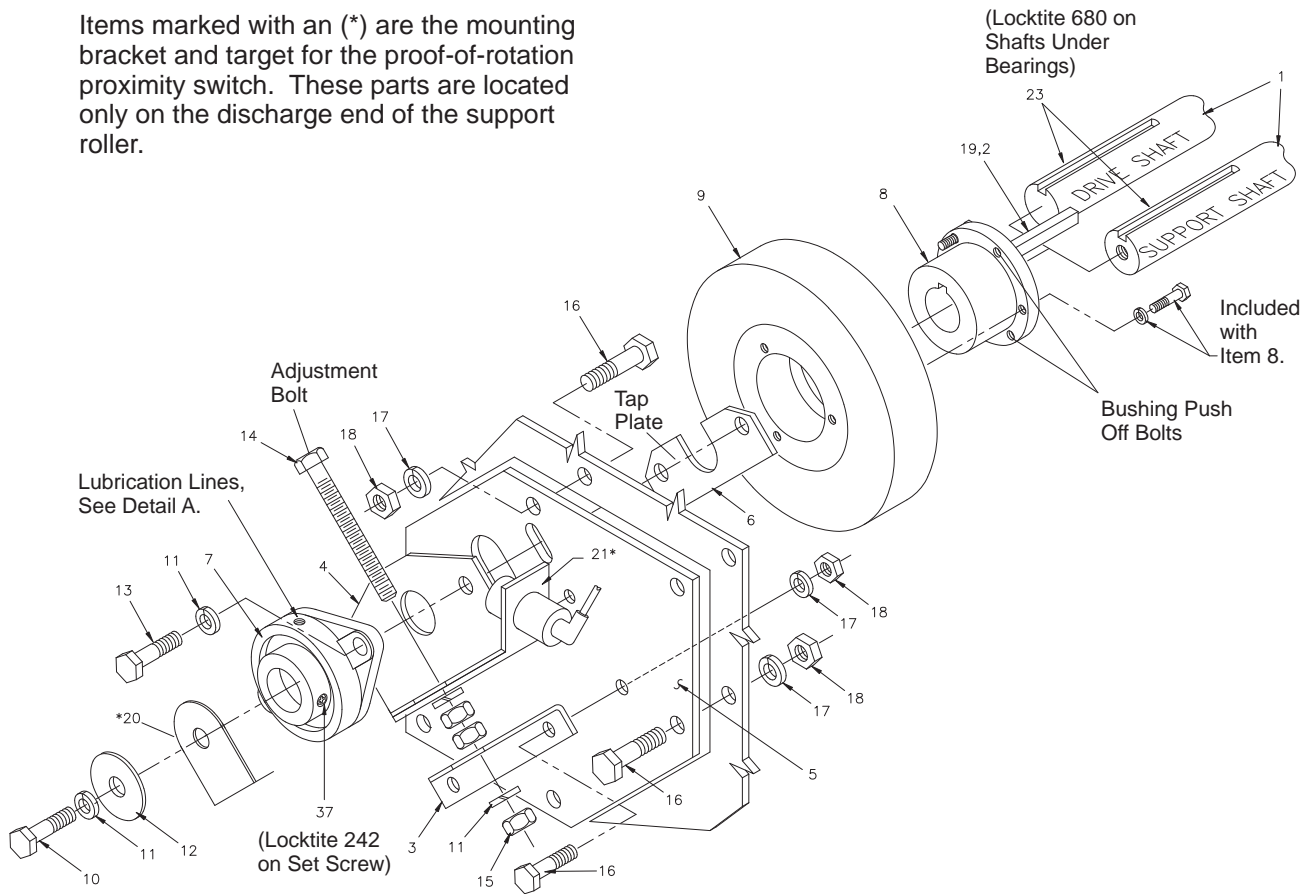
Find the assembly for your machine and the letter shown in the "Item" column. The components for your machine will show this letter or the word "all" in the "Used In" column. The numbers shown in the "Item" column are those shown in the illustrations.				
Used In	Item	Part Number	Description/Nomenclature	Comments
Reference Assemblies				
	A	G77TS001	64"DRYER "T"-SEAL INSTALL LINT LF	64050, 64064,64058 Dryers
	B	G77TS001A	64"DRYER "T"-SEAL INSTALL LINT RT	72072 Dryers
	C	G79TS020	7676 "T"-SEAL INSTALL LINT LT	76076 Dryers
	D	G82TS001	8282 LT "T"-SEAL INSTALL	82082 Dryers
Components				
ABC	1	07 71509	6458 "T" SEAL RETAINER BKT	
ABC	1	07 71509A	6458A "T" SEAL RETAINER BKT	
D	1	07 88242	8282 T-SEAL RETAINER BRKT LT	
D	1	07 88242A	8282 T-SEAL RETAINER BRKT RT	
all	2	07 50469	YOKE=T-SEAL ROD ADJUSTMENT	
all	3	07 50471	ROD=SPRING TENSION T-SEAL	
all	4	07 50472	SPRING=DRYER T-SEAL TENSION	
all	5	07 50498	RIBPLATE=STUD HOLDER T-SEAL	
all	6	W7 50466A	*WLMT=SEAL/YOKE LF SIDE 3BOLT	
all	7	W7 50467A	*WLMT=SEAL/YOKE RT SIDE 3BOLT	
A	8	X7 71124	6458 T-SEAL NOTCH & DRILL	
B	8	X7 80202	T-SEAL NOTCH+DRILL- 72"	
C	8	X7 85202	T-SEAL NOTCH+ DRILL- 76"	
D	8	X7 88067	8282 T-SEAL EXTRUSION MACH'D	
all	9	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	10	15U200	FLATWASHER(USS STD) 5/16"ZNC P	
all	11	15U120	LOCKWASHER MEDIUM #8 ZINCPL	
all	12	15U205	LOCKWASHER MEDIUM 5/16" 18-8SS	
all	13	15G170	HEXNUT 1/4-20UNC2 SS18-8	
all	14	15G164	HX THIN LOCKNUT NYL1/4-20 SS	
all	15	54J004H	COLLAR=HEAT TREAT 45-55 RC	
all	16	15U188	FLTWASH 1/4 STD COMM SS18-8	
all	17	15N176A	TRUSSCR 1/4-20UNCX3/4 SS18-8	

Drive & Support Rollers

6450, 6458, 6464 Dryers

Figure 1: Bearing Support Plates and Bearings

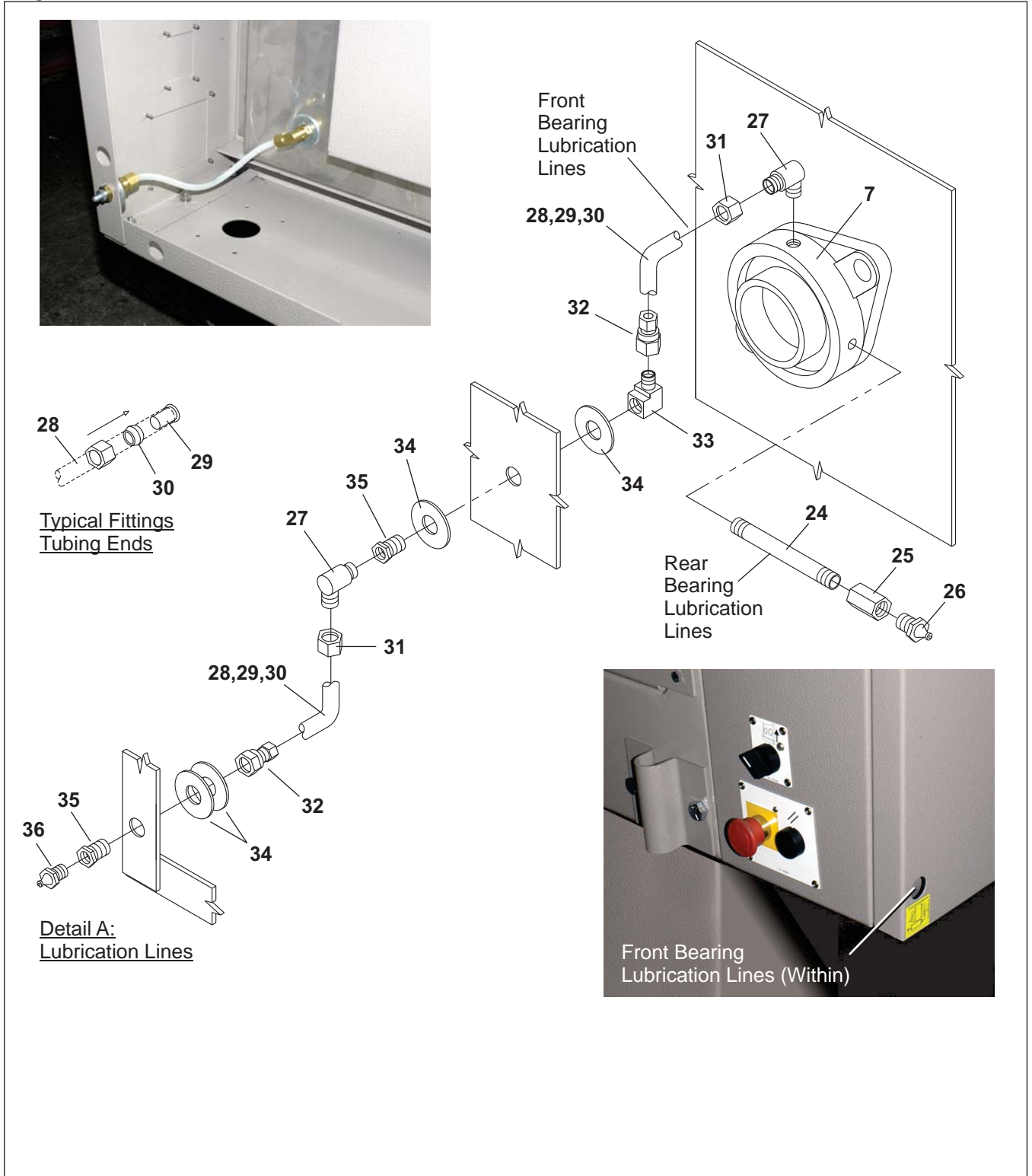
Items marked with an (*) are the mounting bracket and target for the proof-of-rotation proximity switch. These parts are located only on the discharge end of the support roller.



Drive & Support Rollers

6450, 6458, 6464 Dryers

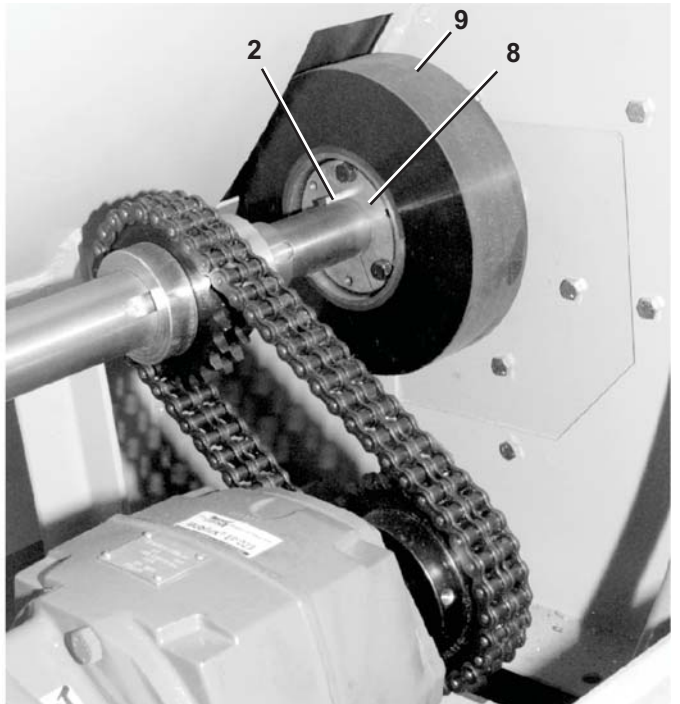
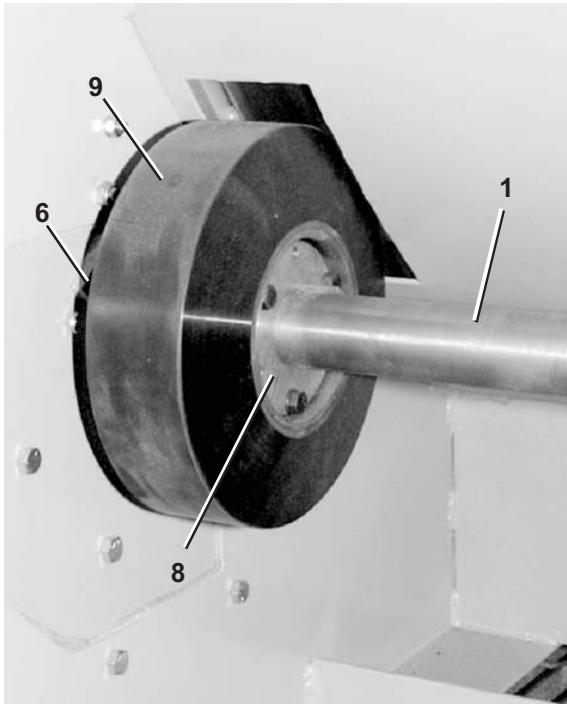
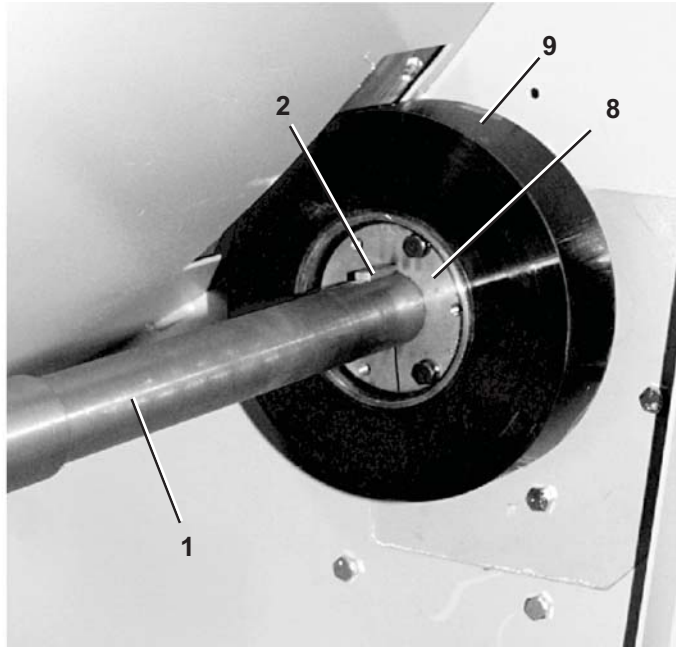
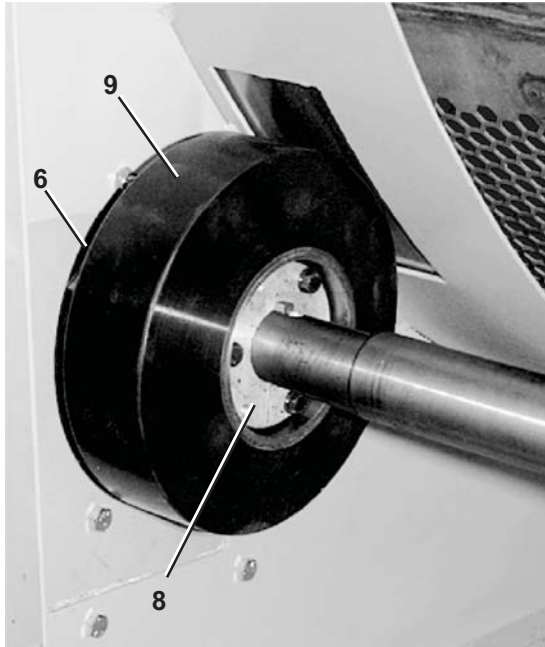
Figure 2: Lubrication Lines



Drive & Support Rollers

6450, 6458, 6464 Dryers

Figure 3: Rollers, Shafts, Bushings



Drive & Support Rollers

6450, 6458, 6464 Dryers

Parts List—Drive & Support Rollers				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----REFERENCE ASSEMBLIES-----				
	A	A77DB010	6458 CYLINDER DRIVE ASSY LF	FOR MODELS PRODUCED BEFORE 5/14/08
	B	A77DB012	6458 CYLINDER SUPP ASSY	FOR MODELS 6458TG1L/R.AAX AND LATER PRODUCED AFTER 5/14/08
	C	A77DB020	6464 CYLINDER SUPP ASSY	6464 DRYERS
	D	G77DB030	6450 CYLINDER SHAFTS INSTALL	6450 DRYERS
-----COMPONENTS-----				
A	1	X7 71168	6458 CYLINDER SHAFTS	
B	1	X7 71169	6458 CYLINDER SHAFT LG BEARING	
C	1	X7 72040	6464 CYLINDER SHAFTS	
D	1	X7 72540	6450 CYLINDER SHAFTS	
all	2	07 50031A	DRYER SHAFT KEY=WHEEL	
all	3	07 50127	BRKT=BEARING AJUST	
A	4	07 50128	BRKT=BEARING MOUNTING	
BC	4	07 81228	7272 BRKT=SUPPORT BEARING MNT	
A	5	07 71280	6458 SUPP/DRIVE BEAR MTG PLT	
BC	5	07 81280	7272 SUPPORT BEAR MTG PLT	
A	6	07 70049A	BEAR ADJUST TAP PLATE	
BC	6	07 81229	7272 BEARING ADJUST PLATE	
A	7	56F1H2CSWC	FLG BRG=1.438 B.D.+COLLAR	
BC	7	56F1H2CSA	FLANGE BRG 1+7/16 ROCK#128837	
all	8	56Q1NSK	1+11/16" BUSH VPUL QD TYPE SK	
all	9	60C509UT	WHEEL SINGLE 9"OD URETHANE	
all	10	15K147	HXCAPSCR 1/2-13UNC2X1 GR5 ZINC	
all	11	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	12	15U286	FLATWASHER 2"0DX17/32"IDX1/4"	
all	13	15K162	HXCAPSCR 1/2-13UNC2AX1.5 GR5 P	
all	14	15D119	HXTAPSCR 1/2-13X4 GR5 ZNC FULL	
all	15	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	16	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	17	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	

Drive & Support Rollers

6450, 6458, 6464 Dryers

Parts List—Drive & Support Rollers				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
all	18	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	19	15N082	FILMACSCR 8-32UNC2X3/8SS18-8	
all	20	03 BL1X1A	TARGET FOR PHOTOEYE 6458 DRYER	
all	21	03 BL1X1B	PHOTOEYE BRACKET 6458 DRYER	DRIVE LEFT
all	21	03 BL1X1C	PHOTOEYE RT SIDE BRKT 6458 DRY	DRIVE RIGHT
All	22	20C008C	THDLKSEAL LCT24241 RMUBL250CC	
all	23	20C012DA	RETAINCMPD ADH LCT#68060 250ML	
All	24	5N0C03AG42	NPT NIP 1/8X3 TBE GALSTL Sk40	
all	25	5SCC0CBE	NPT COUP 1/8 BRASS 125# 103A-A	
all	26	54M015	GREASEFIT 60X36/60X44 1610BL	
all	27	53A031B	BODY-EL90MALE.25X1/8 #269C-42B	
all	28	60E004TC	TUBING NYL(NAT)1/4"ODX.17ID	
all	29	53A501	TUBE INSERT .163"OD #63PT-4-40	
all	30	53A500	SLEEVE DELRIN 1/4"OD#60PT-4	
all	31	53A059A	NUT 1/4"BR.HOLYOKE AND #61A-4	
all	32	53A007B	BODYFEMCON.25X.25COMP#B66A-4B	
all	33	5SL0EBEC	NPTEL B 90DEG STRT 1/4 BRASS125	
all	34	15U280	FL+WASHER(USS STD)1/2 ZNC PL+D	
all	35	5SB0E0CBEO	NPTHEXBUSH 1/4X1/8 BRASS 125#	
all	36	54M005	GRSFITADPSTR#5405-01-02 1/4-28	

Drive & Support Roller Installation

7676TG1L/R, TS1L/R 8282TG1L/R

Figure 1: Rollers, shaft, sprockets, and motor

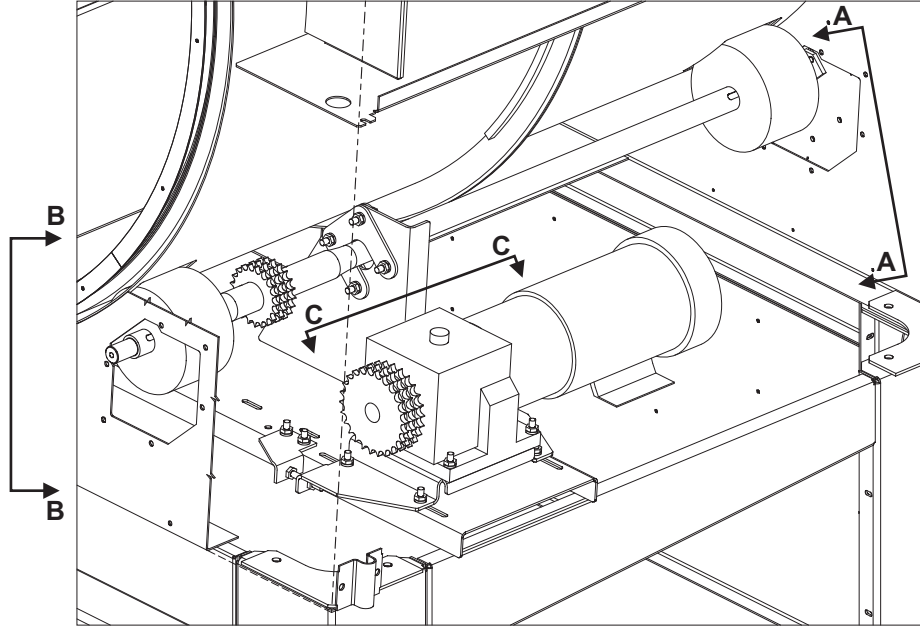
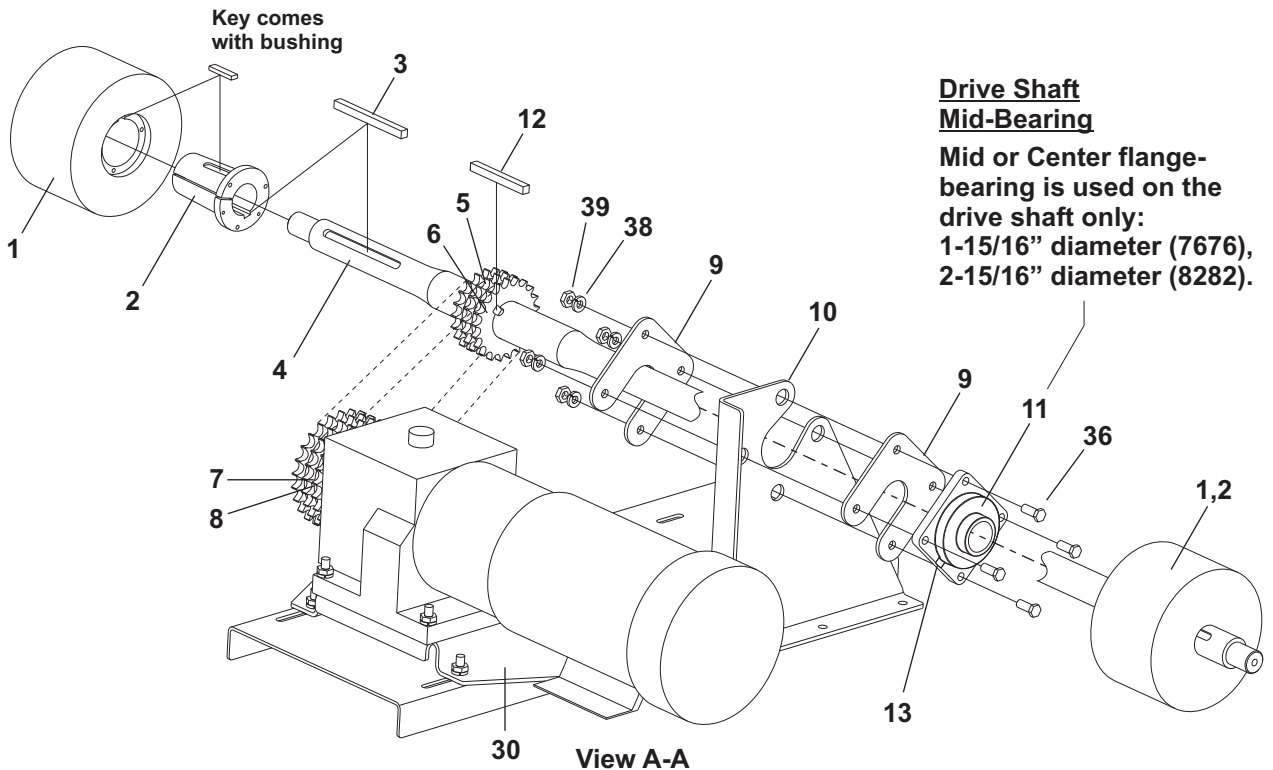


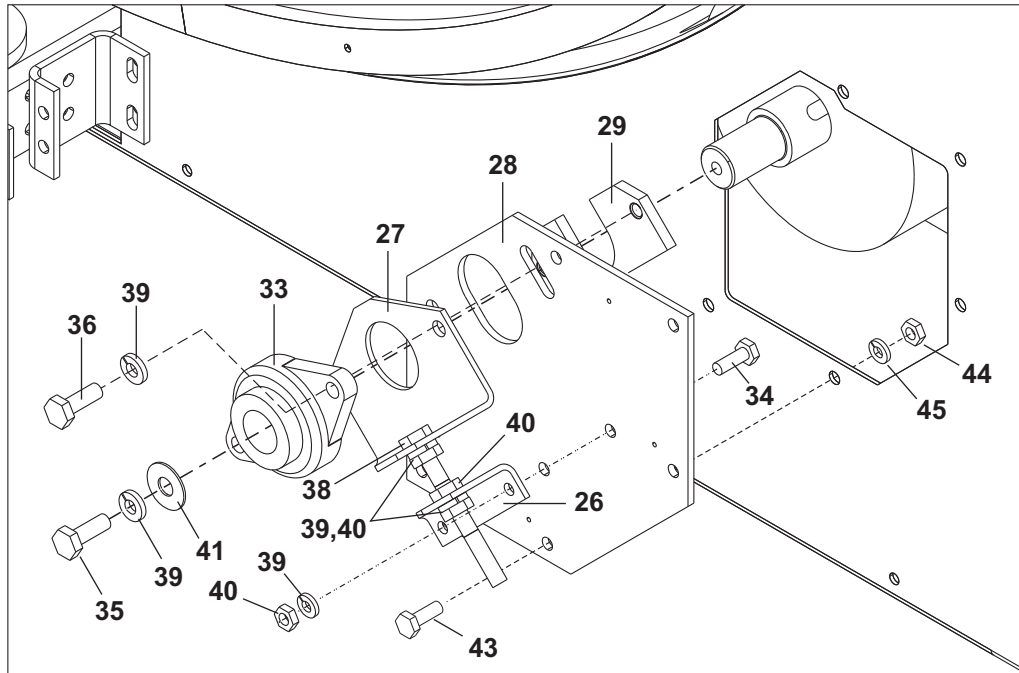
Figure 2: Drive shaft, rollers, bushings, and center flange bearing



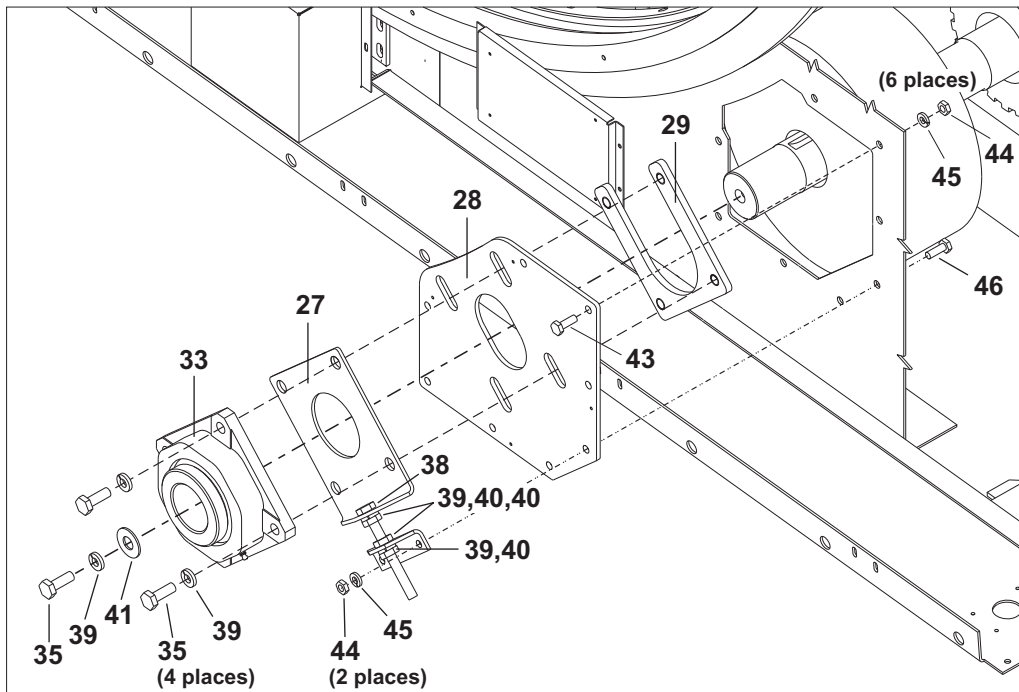
Drive & Support Roller Installation

7676TG1L/R, TS1L/R 8282TG1L/R

Figure 3: Drive and support shafts ends, front and rear bearing installation, typical



View B-B: Shaft End Bearings 7676TG1L/R



View B-B: Shaft End Bearings 8282TG1L/R

Drive & Support Roller Installation

7676TG1L/R, TS1L/R 8282TG1L/R

Figure 4: Drive motor installation

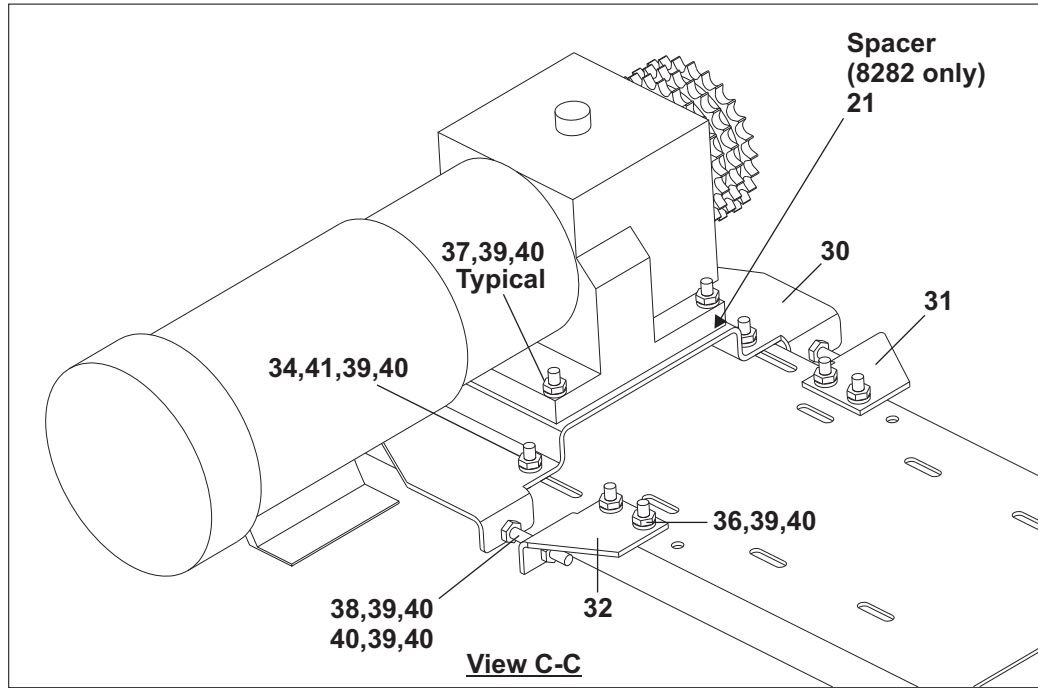
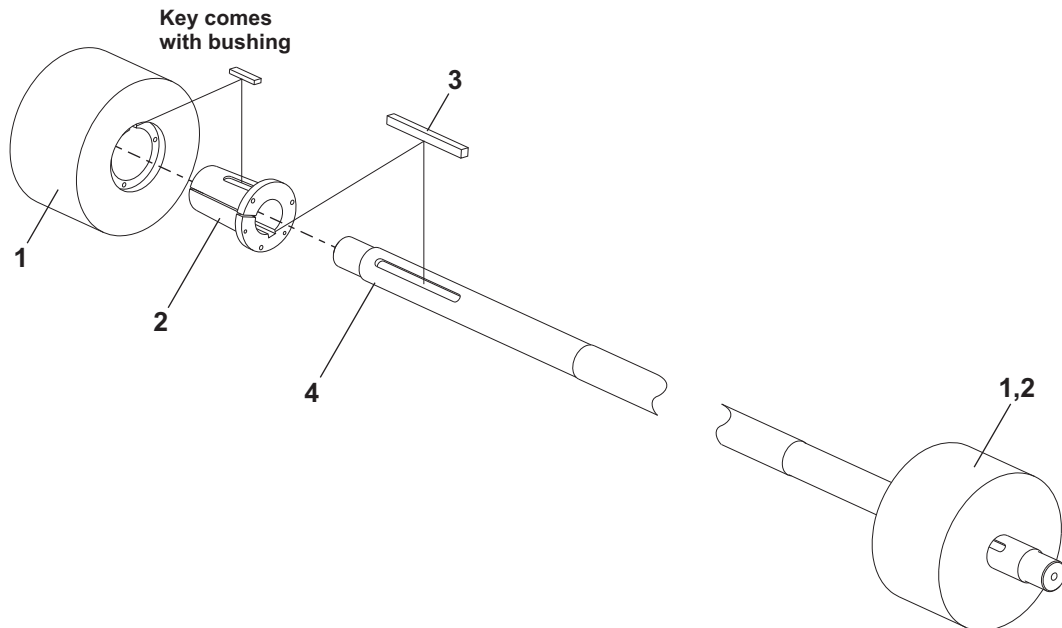


Figure 5: Support shaft, rollers, and bushings



Drive & Support Roller Installation

7676TG1L/R, TS1L/R 8282TG1L/R

Figure 6:
Rear drive shaft
proximity switch and
target (8282TG1L
shown)

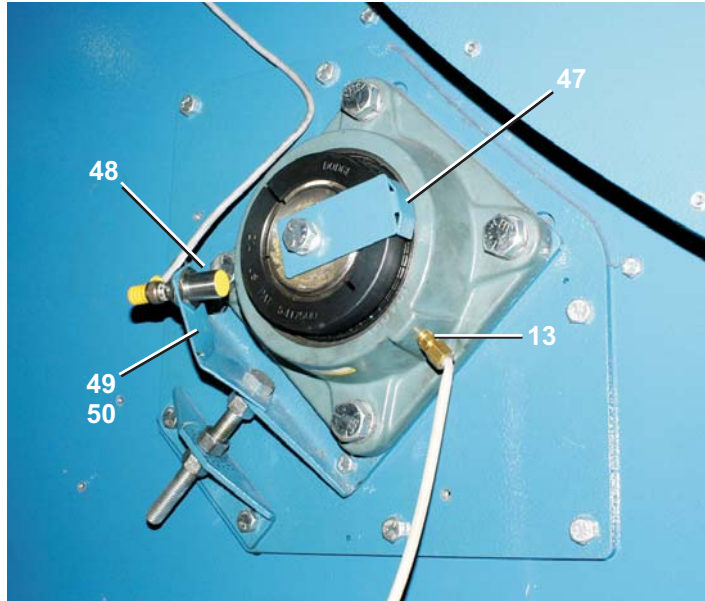
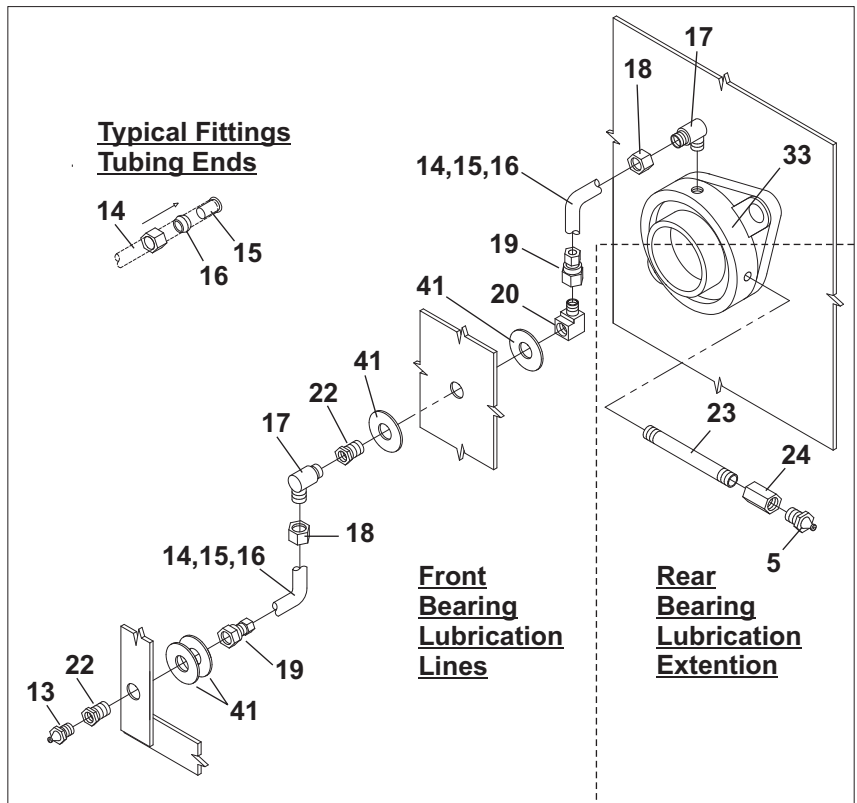


Figure 7:
Shaft bearing lubrication lines



Detail: Lubrication Lines

Drive & Support Roller Installation

7676TG1L/R,TS1L/R 8282TG1L/R

Parts List—Drive & Support Roller Installation				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	G79DB020	7676 DRYER LEFT DRIVE SHAFT INSTALL	7676 Drive Shaft Install
	B	G79DB021	7676 DRYER LEFT SUPPORT SHAFT INSTALL	7676 Supprt Shaft L Install
	C	G79DB021A	7676 DRYER RITE SUPPORT SHAFT INSTALL	7676 Support Shaft R Install
	D	G82DB001	8282 LEFT DRIVE SHAFT INSTALL	8282 Drive Shaft Install
	E	G82DB002	8282 SUPPORT SHAFT INSTALL	8282 Support Shaft Install
-----COMPONENTS-----				
ABC	1	60C510UT	WHEEL DOUBLE 9"OD URETHANE	
DE	1	60C514UT	WHEEL14"OD URETHANE	
A	2	56Q1TQ3S	1+15/16" SPLIT BUSHING BROWN#Q3	
D	2	56Q2PR2	2+3/4" BUSHING MST TYPE R2	
A	3	07 70029	5880 DRYER SHAFT KEY=WHEEL	
D	3	15E237C	SQMACHKEY 5/8" X 5/8" X 5"	
A	4	07 85287A	7676 DRIVE SHAFT 1+3/4 BEARINGS	
BC	4	07 85286A	7676 SUPPORT SHAFT, 1+3/4 BEARINGS	
D	4	07 88081	8282 DRIVE SHAFT	
E	4	07 88082	8282 SUPPORT SHAFT	
A	5	54N060E21	SPRKT E60Q21H TRIPLE STYLE MST Q1 BUSHING	
D	5	54N080E19	SPRKT E80Q19H TRIPLE STYLE MST Q2 BUSHING	
A	6	56Q2EB2	BUSH, MARTIN Q1 2+3/8 DUCTILE	
D	6	56Q2CQ2	2+1/8" BUSHING MST TYPE Q2	
A	7	54N060E26	SPRKT E60Q26H TRIPLE STYLE MST Q1 BUSHING	
D	7	54N080E23	SPRKT E80R23H TRIPLE STYLE MST R1 BUSHING	
A	8	56Q1MB2	1+5/8 BUSH, MARTIN Q1 SINTERED METAL	
D	8	56Q2TR1A	2+15/16" BUSHING MST TYPE R1	
A	9	07 85039	7676 CENTER BEARING ADJUST PLATE	
D	9	07 88087	8282 CENTER BEARING ADJUST PLATE	
A	10	07 85038	7676 LEFT CENTER BEARING MOUNT PLATE	
D	10	07 88080	8282 LT CENTER BEARING MOUNT PLATE	
A	11	54AF1937	FLBRG 1+15/16" BROWNING #VF4B-231	
D	11	54AF29375	FLGBRG 2+15/16 4-BOLT=DODGE#F4B-DL-215	
A	12	15E238	7676 DRIVE STEP KEY	
D	12	15E239	3/4" X 3/4" X 5.00" KEY	
all	13	54M005	GRSFITADPSTR#5405-01-02 1/4-28	
all	14	60E004TC	TUBING NYL(NAT)1/4"ODX.17ID	
all	15	53A501	TUBE INSERT .163"OD #63PT-4-40	
all	16	53A500	SLEEVE DELRIN 1/4"OD#60PT-4	
all	17	53A031B	BODY-EL90MALE.25X1/8 #269C-42B	
all	18	53A059A	NUT 1/4"BR.HOLYOKE AND #61A-4	
all	19	53A007B	BODYFEMCON.25X.25COMP#B66A-4B	
all	20	5SL0EBEC	NPTELB 90DEG STRT 1/4 BRASS125	

Drive & Support Roller Installation

7676TG1L/R,TS1L/R 8282TG1L/R

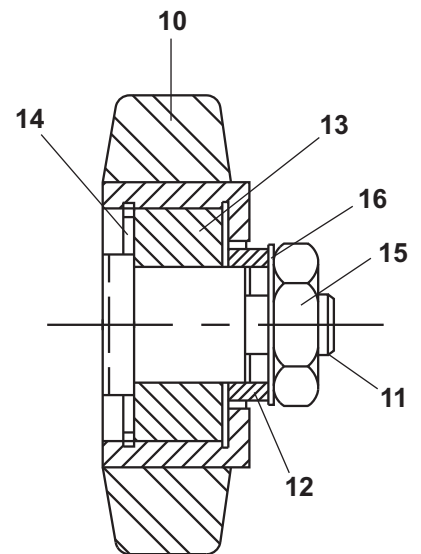
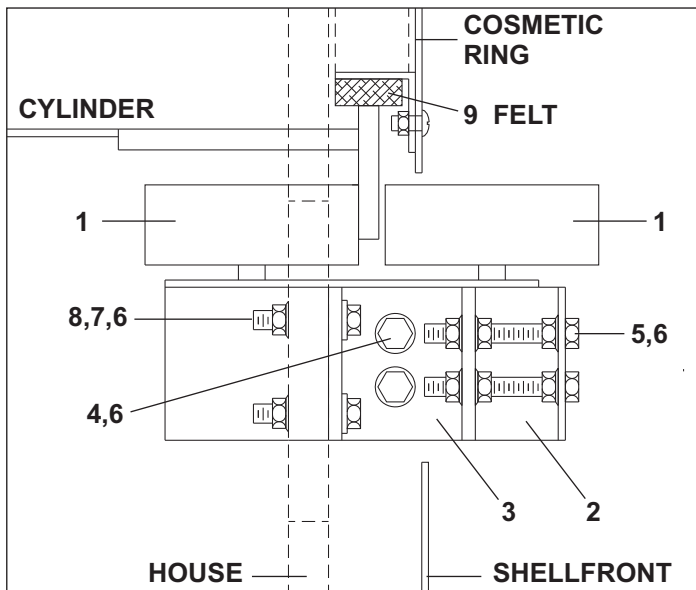
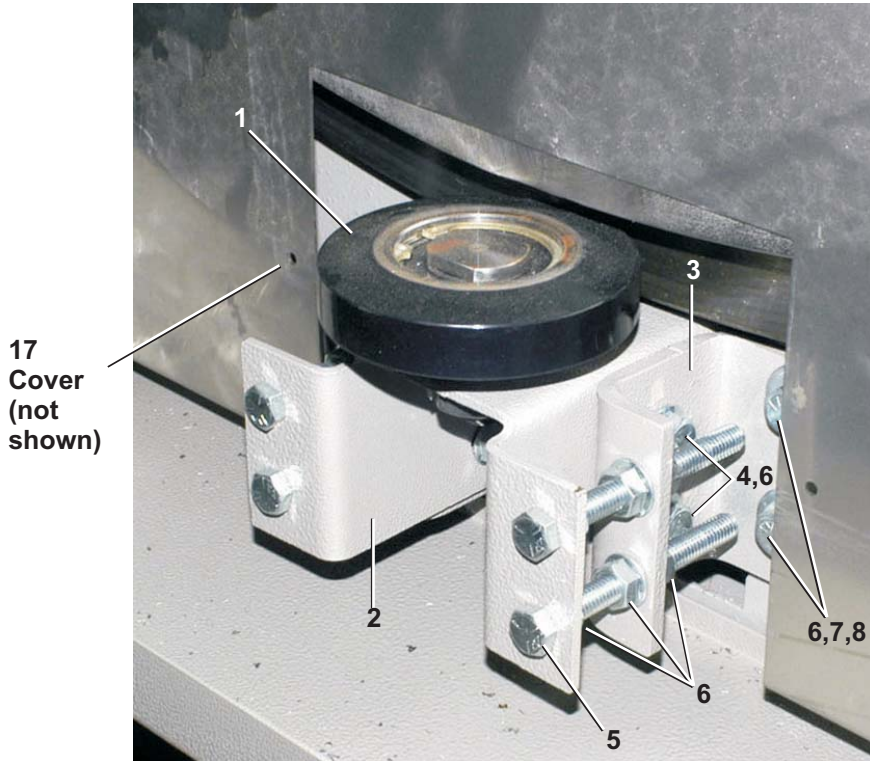
Parts List—Drive & Support Roller Installation

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
all	21	07 88079B	8282 MOTOR MNT SPACER PLATE	
all	22	5SB0E0CBEO	NPTHEXBUSH 1/4X1/8 BRASS 125#	
all	23	5N0C03AG42	NPT NIP 1/8X3 TBE GALSTL SK40	
all	24	5SCC0CBE	NPT COUP 1/8 BRASS 125# 103A-A	
all	25	54M015	GREASEFIT 60X36/60X44 1610BL	
all	26	07 50127	BRKT=BEARING AJUST	
ABC	27	07 85281	7676 BEARING MNT SUPPORT BRKT	
DE	27	07 88084	8282 BEARING MNT SUPPORT BRKT	
ABC	28	07 85280	7676 BEARING MOUNTING PLATE	
DE	28	07 88083	8282 BEARING MOUNTING PLATE	
ABC	29	07 85282	7676 BEARING ADJUST TAP PLATE	
DE	29	07 88085	8282 BEARING ADJUST TAP PLATE	
ABC	30	07 85037	7676 MOTOR SUPPORT BRACKET	
DE	30	W7 88079	8282 MOTOR MNT SUPPORT BRKT WLMT	
all	31	07 85166	7676 LEFT MOTOR MNT ADJ BOLT BKT	
all	32	07 85166A	7676 RITE MOTOR MNT ADJ BOLT BKT	
ABC	33	54AF1750	FLGBRG 1+3/4" 2-BOLT = DODGE# F2B-DL-112	
DE	33	54AF26875	FLGBRG 2+11/16 4-BOLT=DODGE#F4B-DL-211	
all	34	15K147	HXCAPSCR 1/2-13UNC2X1 GR5 ZINC	
all	35	15K151	HXCAPSCR 1/2-13UNC24X1.25 GR5	
all	36	15K173A	HXCAPSCR 1/2-13UNC2AX1.75 GR5	
all	37	15K191	HXCAPSCR 1/2-13UNC2AX2.5 GR5 Z	
all	38	15K205	HXCAPSCR 1/2-13UNC2AX8.5GR5 ZI	
all	39	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	40	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	41	15U280	FL+WASHER(USS STD)1/2 ZNC PL+D	
all	43	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	44	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	45	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	46	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
ABC	47	03 BL1X1A	TARGET FOR PHOTOEYE 6458 DRYER	
DE	47	03 BL1X1E	8282 TARGET FOR PHOTOEYE	
all	48	09RPS18ADU	PRXSW QK CONN 18M NO-DC UNSHLD	
ABC	49	03 BL1X1B	PHOTOEYE BRACKET 6458 DRYER	
DE	49	03 BL1X1F	8282 PHOTO EYE BRACKET LT	
ABC	50	03 BL1X1C	PHOTOEYE RT SIDE BRKT 6458 DRY	
DE	50	03 BL1X1G	8282 PHOTO EYE BRACKET RT	

Guide Roller Assembly

5040, 5050, 6458, 6464, 7272, 7676, and 8282 Dryers



Guide Roller Assembly

5040, 5050, 6458, 6464, 7272, 7676, and 8282 Dryers

Parts List—Guide Roller Assembly				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	A77GB010	6458 GUIDE ROLLER ASSY=DRYER	REFERENCE 5040TG2L/R,TS2L/R 5050TG1L/R,TS1L/R 6458TG1L/R,TS1L/R 6464TG1L/R,TS1L/R
	B	A78GB001	72" GUIDE ROLLER ASSY	REFERENCE 7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R
-----COMPONENTS-----				
A	1	A75GB003B	*4" GUIDE ROLLER WHEEL ASSY	TWO REQUIRED CONTAINS 10-16
B	1	A77GB003	5880 GUIDE ROLLER WHEEL ASSY	TWO REQUIRED CONTAINS 10-16
A	2	07 50219	BRKT GUIDE ROLLER MOUNT	
B	2	07 80150	7272 GUIDE ROLLER MOUNT	
A	3	07 50218	BRKT SMALL GUIDE ROLLER	
B	3	07 80100	72" GUIDE ROLLER BRKT	
all	4	15K092Z	HEXFLGSCR 3/8-16X1 GR5 ZINC	
all	5	15B107	HEXTAPBOLT 3/8-16UNC2X3+1/2 ZN	
all	6	15G198	HXFLGNUT 3/8-16 ZINC	
all	7	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	8	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	9	27A685	FELT 1/2"THK X 1+1/4"W SAE F-7	
	10	60C502A	4" GUIDE ROLLER 1.50 BORE	PART OF 1A
	10	60C503A	5" GUIDE ROLLER 1.38 BORE	PART OF 1B
	11	07 50053	SHAFT=GUIDE ROLLER DRYER	PART OF 1A & 1B
	12	07 50054	BUSHING=GUIDE ROLLER DRYER	PART OF 1A & 1B
	13	54A075	BALBRG NTN#63205LLBC3/C5 1/BX	PART OF 1A & 1B
	14	17B017B	INTRETRING IND#3000X206-ST-ZD	PART OF 1A & 1B
	15	15G245	HXFINJAMNUT 3/4-10UNC2 SS18-8	PART OF 1A & 1B
	16	06 20070	LOCKING WASHER ROLLER SHAFT	PART OF 1A & 1B
All	17	W7 50129	COVER GUIDE ROLLER WELDED	

Main Air Blower Wheel Replacement

NOTICE P1: "Remove electrical power from the machine" means use the necessary safety procedure for your location. In the USA, this is the OSHA lockout/tagout (LOTO) procedure. More local requirements can also apply.

The two methods to replace the blower wheel are: 1) from below, through the dryer housing or 2) from above. Replacement from below is simpler and the method explained in this document.

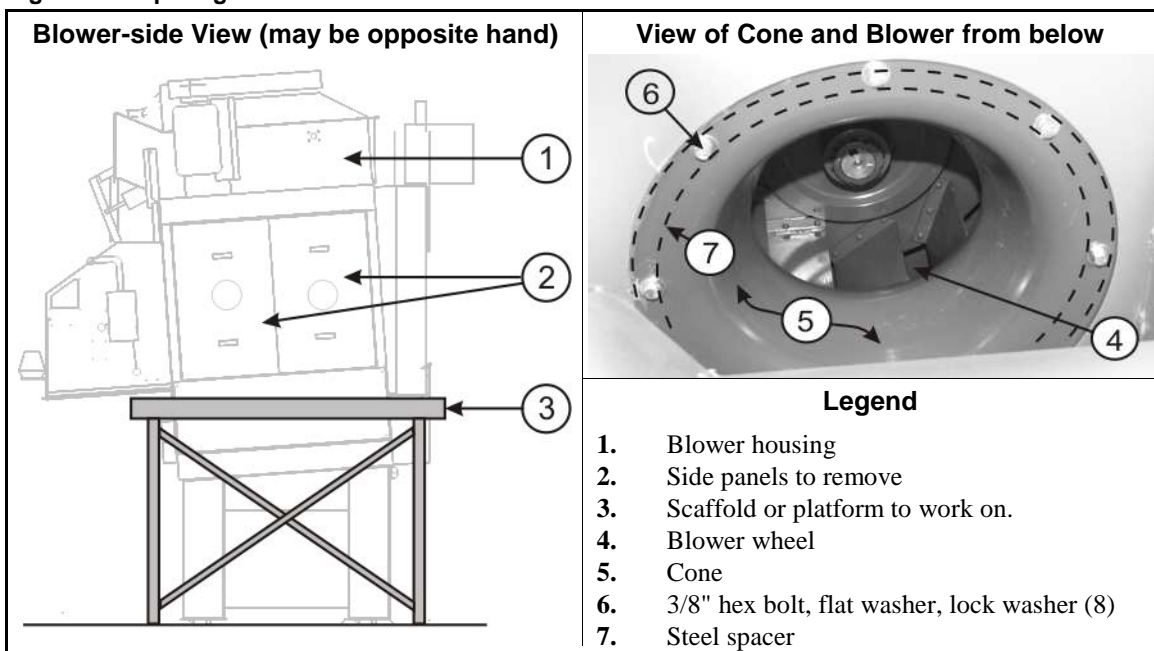
1. Resources Needed

- Two maintenance personnel to handle the blower wheel overhead. Blower wheels range in weight from about 50 to 90 pounds (23 to 41 Kg).
- A sturdy scaffold or platform to work at the level of the dryer housing (see [Figure 1](#))
- Dryer service manual (see the Blower Installation..." document)
- Replacement blower wheel from Milnor
- Tools such as a cold chisel and hammer to loosen/tighten the bearing lock nut
- Tools to remove, install, and torque 3/8" hex head bolts
- Two 3/8" x 16 x 3.5", full thread, high strength, hex head bolts to use as jack bolts
- A 2x4 wood stud to use for blocking

2. Preparations

1. Familiarize yourself with the blower assembly (see the service manual).
2. Set up the scaffold or platform against the blower side of the dryer as shown in [Figure 1](#).
3. **Remove electrical power from the machine (see Notice P1).** Allow the machine to cool.
4. Remove the two access panels on the blower side of the dryer housing.

Figure 1: Preparing for the Work



3. Remove the old blower wheel.

1. Refer to **Figure 1**. From inside the dryer housing, remove the cone (item 5) and spacer (item 7) by removing the eight bolts, flat washers, and lock washers (item 6). **Retain the bolts and washers.** With these components removed, the blower can be removed through the air passage in the dryer housing.
2. Find a location inside the dryer housing to place the 2x4 blocking. The blocking will help with installation of the new blower wheel. You will use the 2x4 as a post to hold the new blower wheel in place temporarily. Measure the needed length and cut the 2x4.



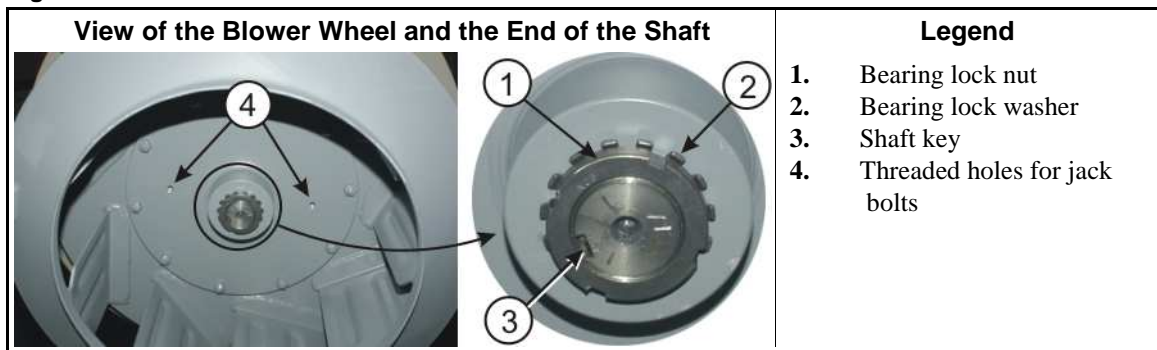
CAUTION [1]: Crush hazards—In the following steps, you will handle the blower wheel overhead, inside the dryer housing. Blower wheels range in weight from about 50 to 90 pounds (23 to 41 Kg). The blower wheel may fall as soon as the bearing lock nut is removed.

- Plan your work.
 - Use two personnel who are physically suited to the task.
3. Refer to **Figure 2**. The blower wheel is held on the shaft by a bearing lock nut (item 1), a bearing lock washer (item 2), a shaft key (item 3), and a tight fit on the shaft taper. Bend the tab on the lock washer away from the groove in the lock nut. Loosen, **but do not remove** the lock nut. Tap a groove on the lock nut with a hammer and cold chisel to loosen it.
 4. Refer to **Figure 2**. Two threaded holes on the blower wheel hub (item 4) will accept the 3/8" jack bolts. Insert both bolts until they stop against the top of the blower housing. With the bearing lock nut still attached, alternately tighten the jack bolts to push the wheel off of the shaft taper.

Tip: The blower wheel may be very tight on the taper, especially after lengthy use. Too much torque on the jack bolts can break the bolts or damage the blower housing. If you cannot coax the blower wheel loose with reasonable force, use shorter jack bolts and filler material between the end of each bolt and the top of blower housing to reduce the distance the bolts must span. For the filler material use steel plate over wood blocking.

5. When the blower wheel is held on the shaft by the lock nut alone, support the weight of the blower wheel. While supporting the blower wheel, remove the lock nut and lock washer. Carefully maneuver the old blower wheel off of the shaft and out of the dryer housing. The shaft key may fall out when the blower wheel is removed. **Retain all attachment hardware.**

Figure 2: Blower Wheel Attachment to Shaft



4. Install the new blower wheel.

1. If the shaft key came off of the shaft, replace it. It should fit tightly in the groove on the shaft.

2. Put the 2x4 blocking within reach. Carefully maneuver the new blower wheel into position and onto the shaft. While supporting the weight of the blower wheel, wedge the 2x4 blocking under the blower wheel to hold it in place temporarily.
3. Replace the bearing lock washer and lock nut on the shaft. When the lock nut is reliably on the shaft, remove the 2x4 blocking.
4. Tighten the lock nut to tighten the blower wheel on the shaft taper. Use a hammer and cold chisel to tighten the lock nut. When the face of the lock nut is flush with the end of the shaft, the blower wheel is sufficiently tight.
5. Bend a tab on the lock washer into a groove on the lock nut to lock it in place.
6. Place the cone and spacer in position on the air opening below the blower wheel. The top of the cone fits into the bottom opening in the blower wheel with **very little play**. Move the cone around until it seats into the blower wheel. While holding the fully seated cone in place, loosely install the attachment bolts, flat washers, and lock washers.
7. The bolt holes in the cone permit some sideways movement of the cone. Move the cone around to feel the fit inside the blower wheel. By feel, try to center the cone in the blower wheel. Tighten the bolts to 31 foot-pounds (42 Nm) in an alternating pattern.
8. Apply machine power. With the dryer side panels still removed, stand clear of the machine and use the manual controls to run the main blower. Check for abnormal vibration or noise.

Tip: If the blower wheel rubs against the cone, you will probably hear a metallic rubbing sound. This is normally not serious and the noise should dissipate after the machine is in operation for a while and the cone wears down. If the noise is objectionable, remove electrical power from the machine (see Notice P1) and adjust the cone position as explained above.

9. If any unusual noise or vibration persists, consult Milnor Technical Support.
10. Replace the side panels and return the dryer to operation.

— End of BIPD6M06 —

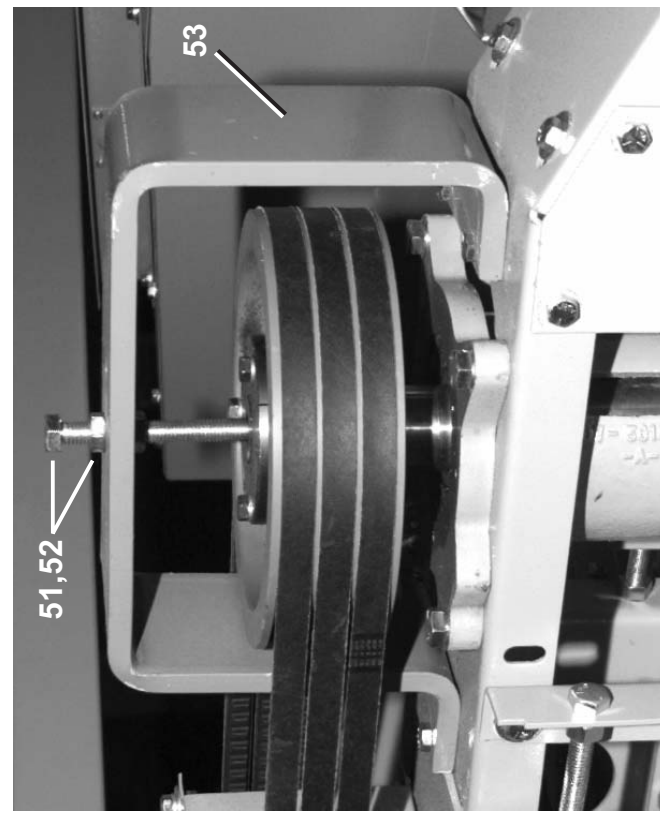
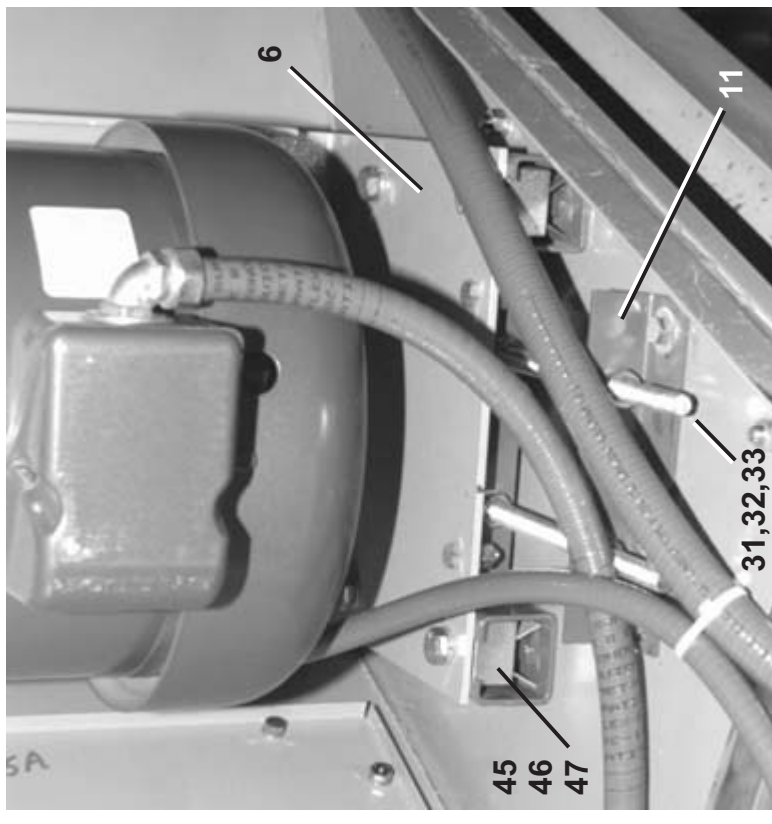
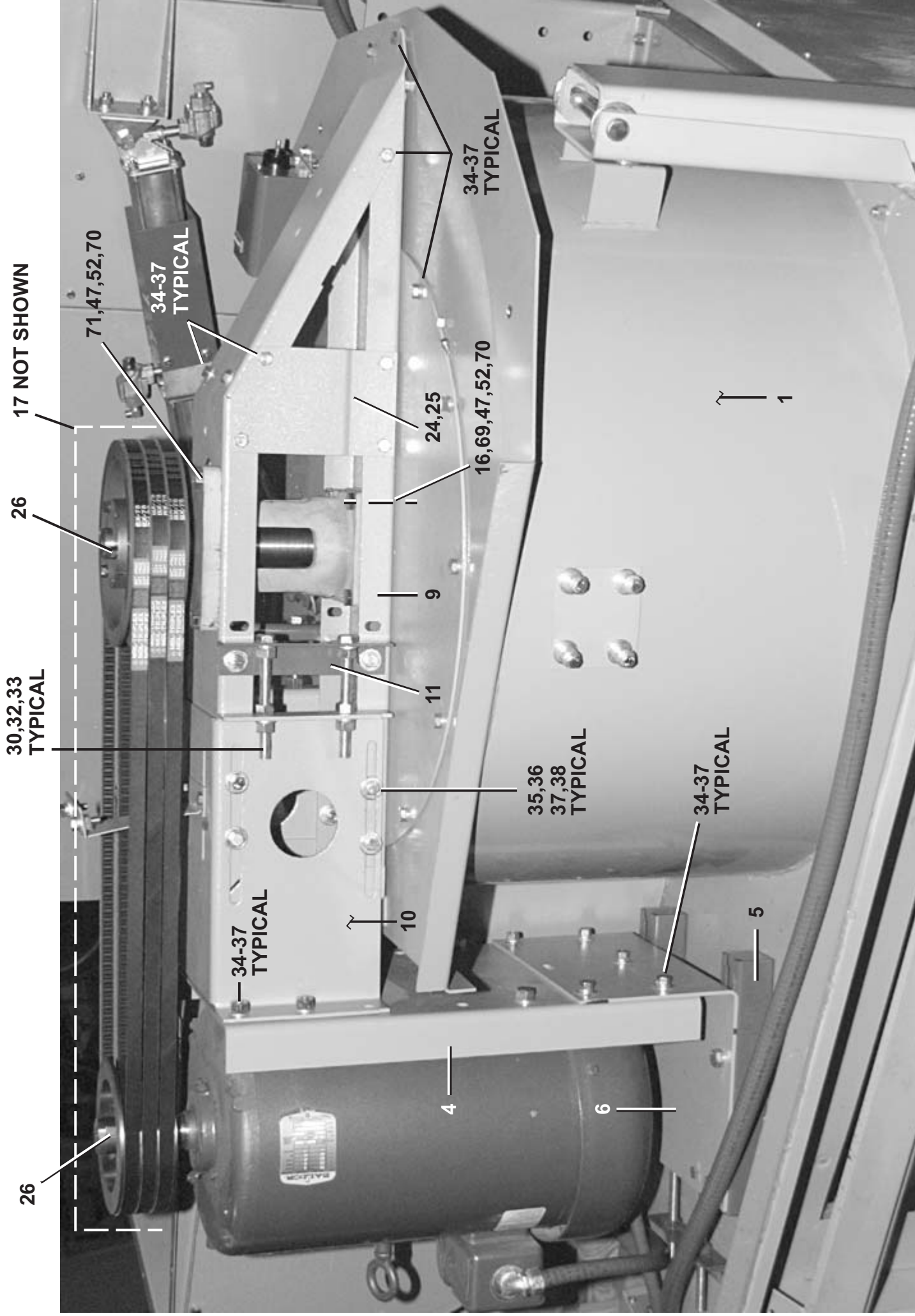
Blower Installation & Exhaust Duct to Rear
 6458TG1L,TG1R, TS1L,TS1R 6464TG1L,TG1R, TS1L,TS1R

BMP000052/2012085B
 (Sheet 1 of 4)



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Litho in U.S.A.



BEARING SHIPPING BRACKET

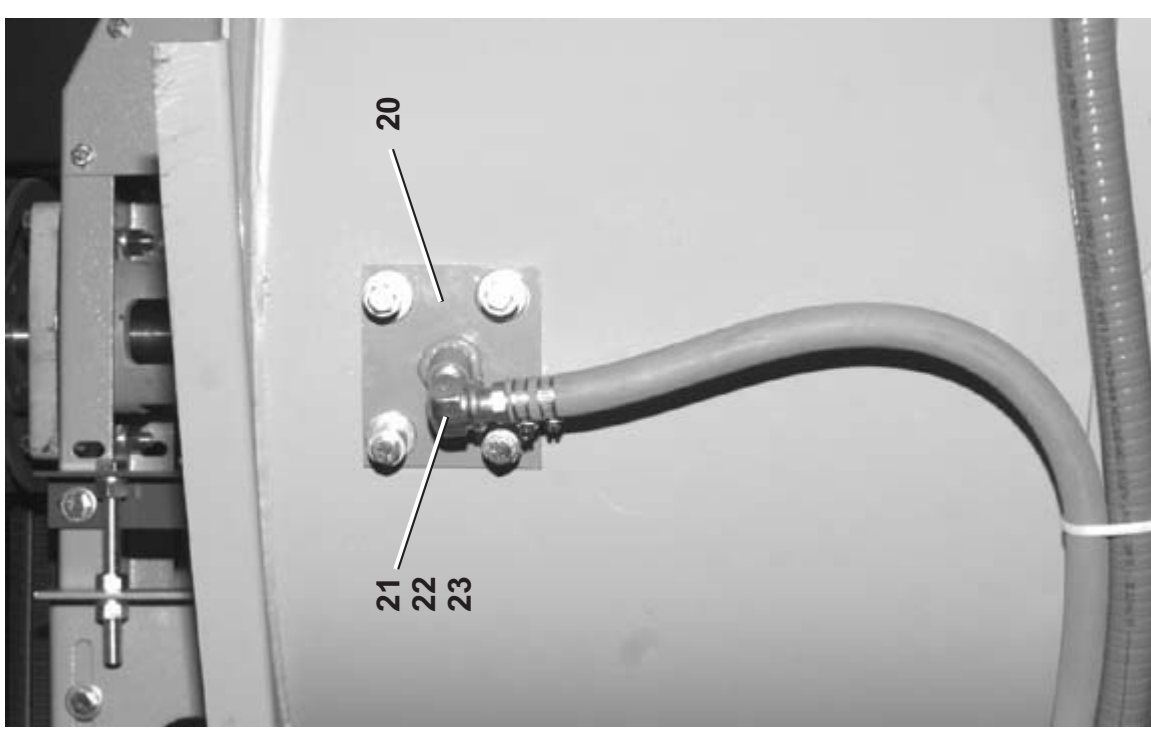
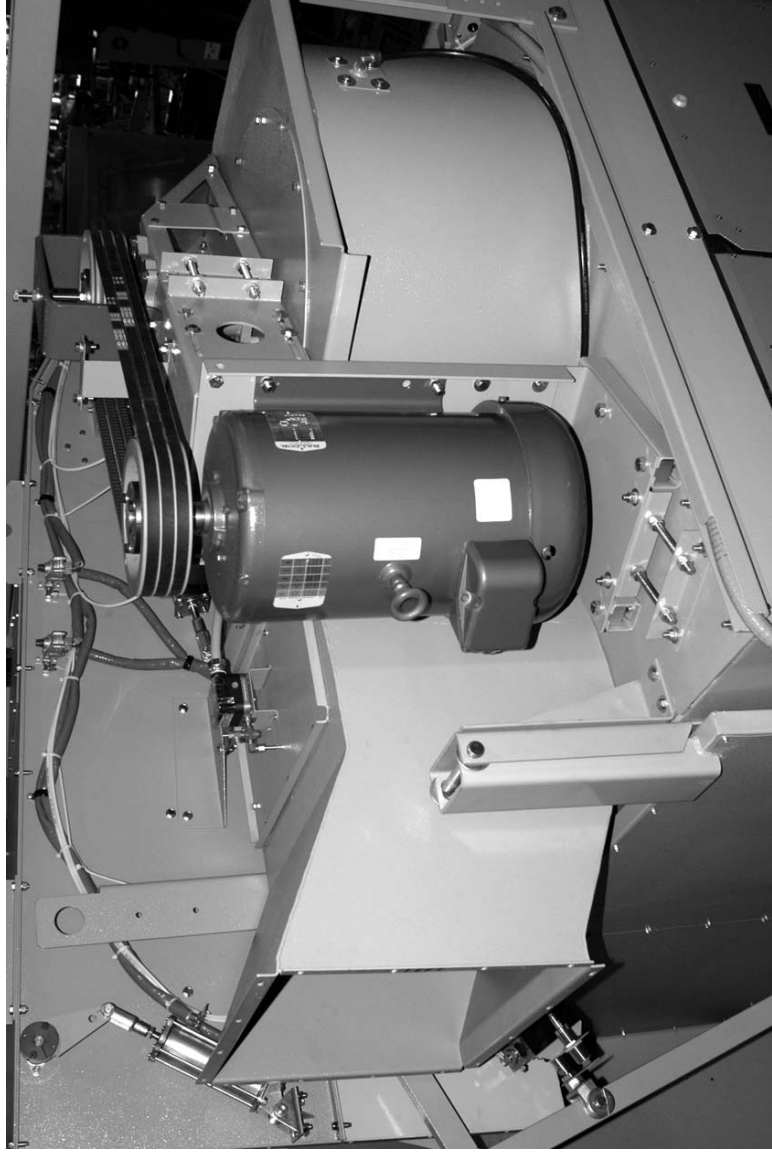
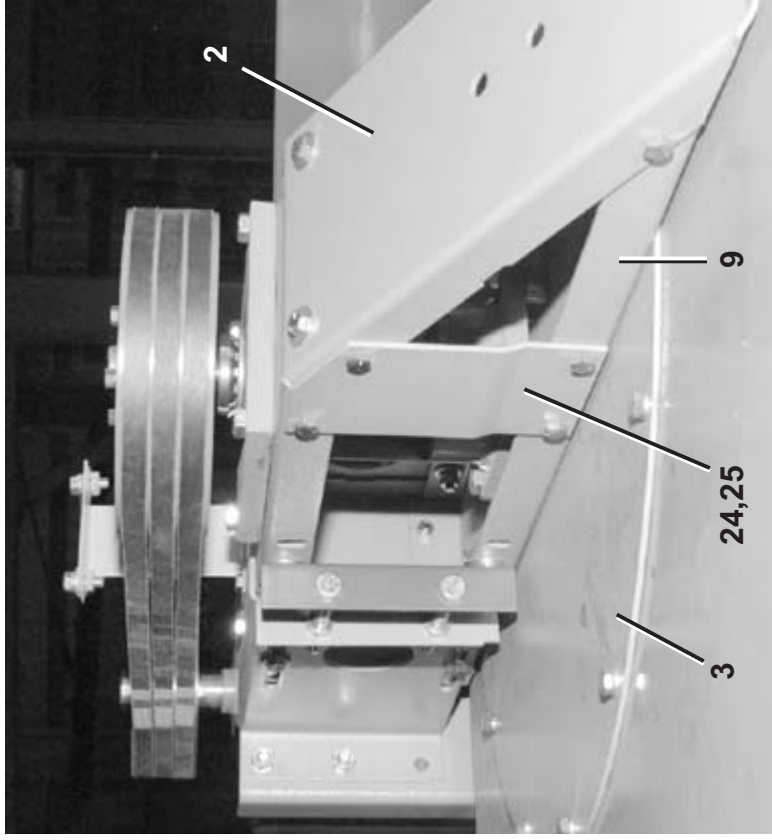
Blower Installation & Exhaust Duct to Rear
 6458TG1L,TG1R, TS1L,TS1R 6464TG1L,TG1R, TS1L,TS1R

BMP000052/2012085B
 (Sheet 2 of 4)

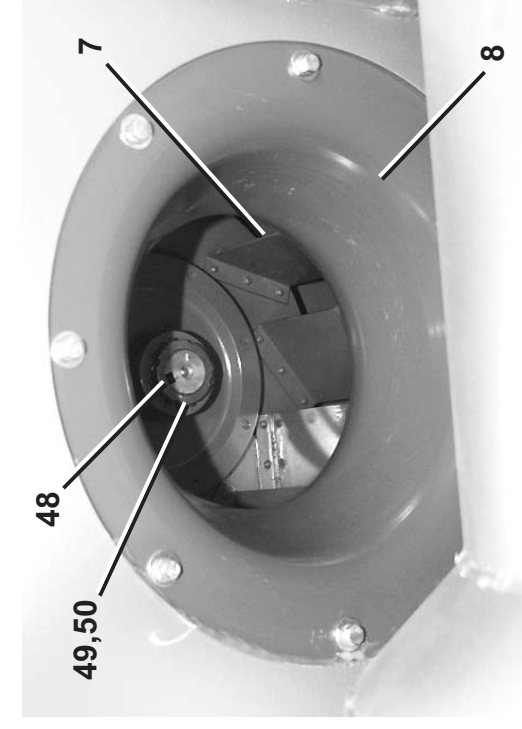
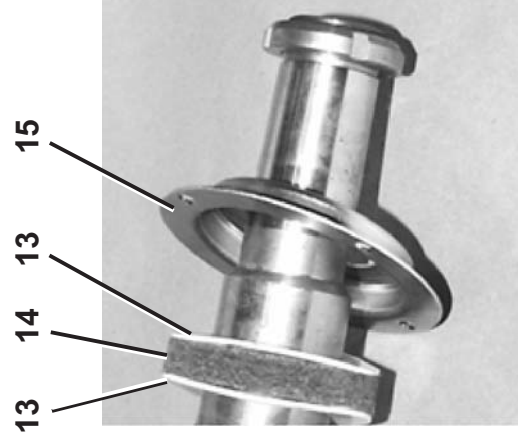


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BLOWER BLOW DOWN



UNDERSIDE OF BLOWER



FOR BEARING
 ASSEMBLY,
 SEE BMP070027

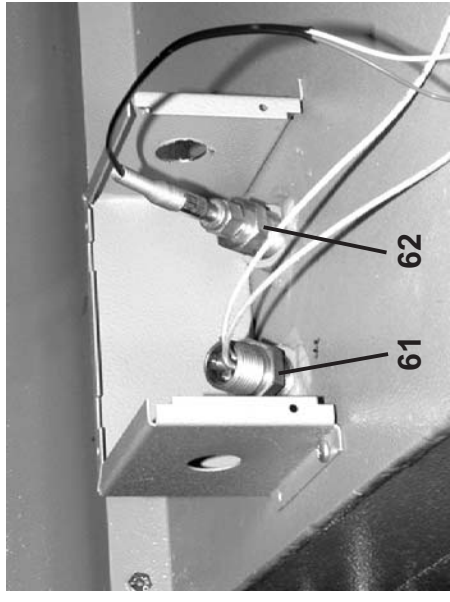
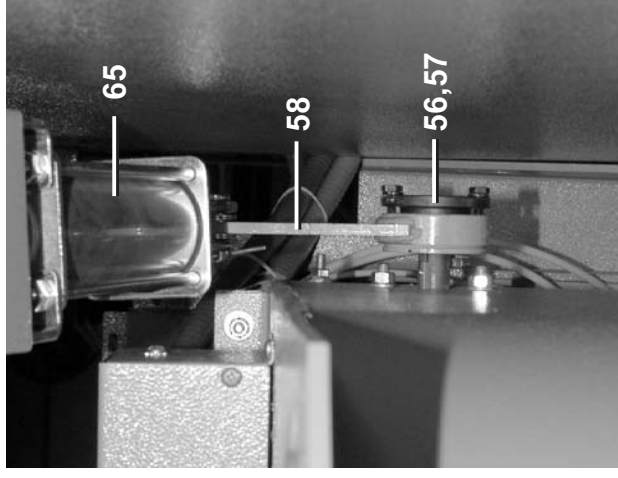
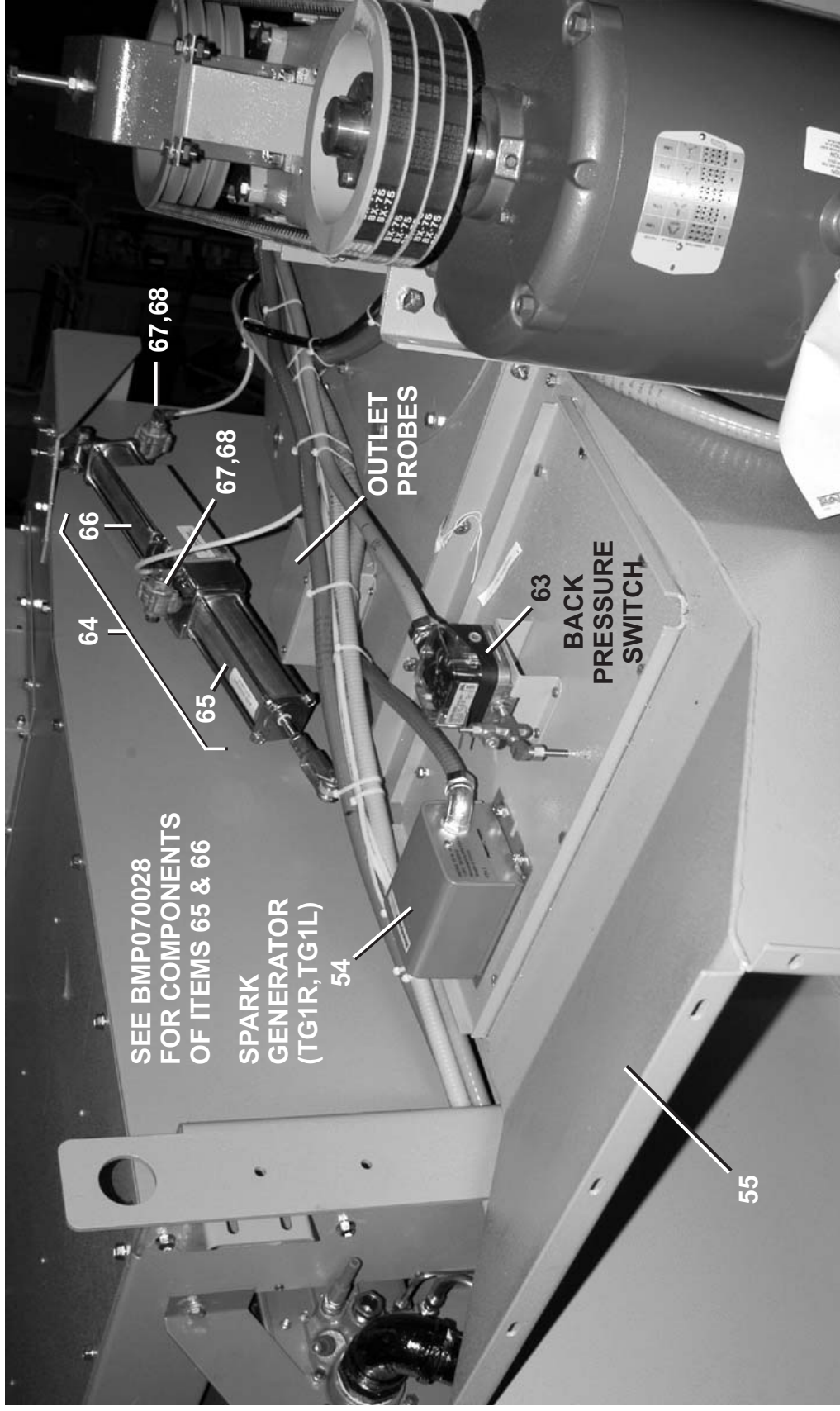
Blower Installation & Exhaust Duct to Rear
 6458TG1L,TG1R, TS1L,TS1R 6464TG1L,TG1R, TS1L,TS1R

BMP000052/2012085B
 (Sheet 3 of 4)



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Litho in U.S.A.



OUTLET PROBES

BLOWER EXHAUST DUCT





Pellerin Milnor Corporation
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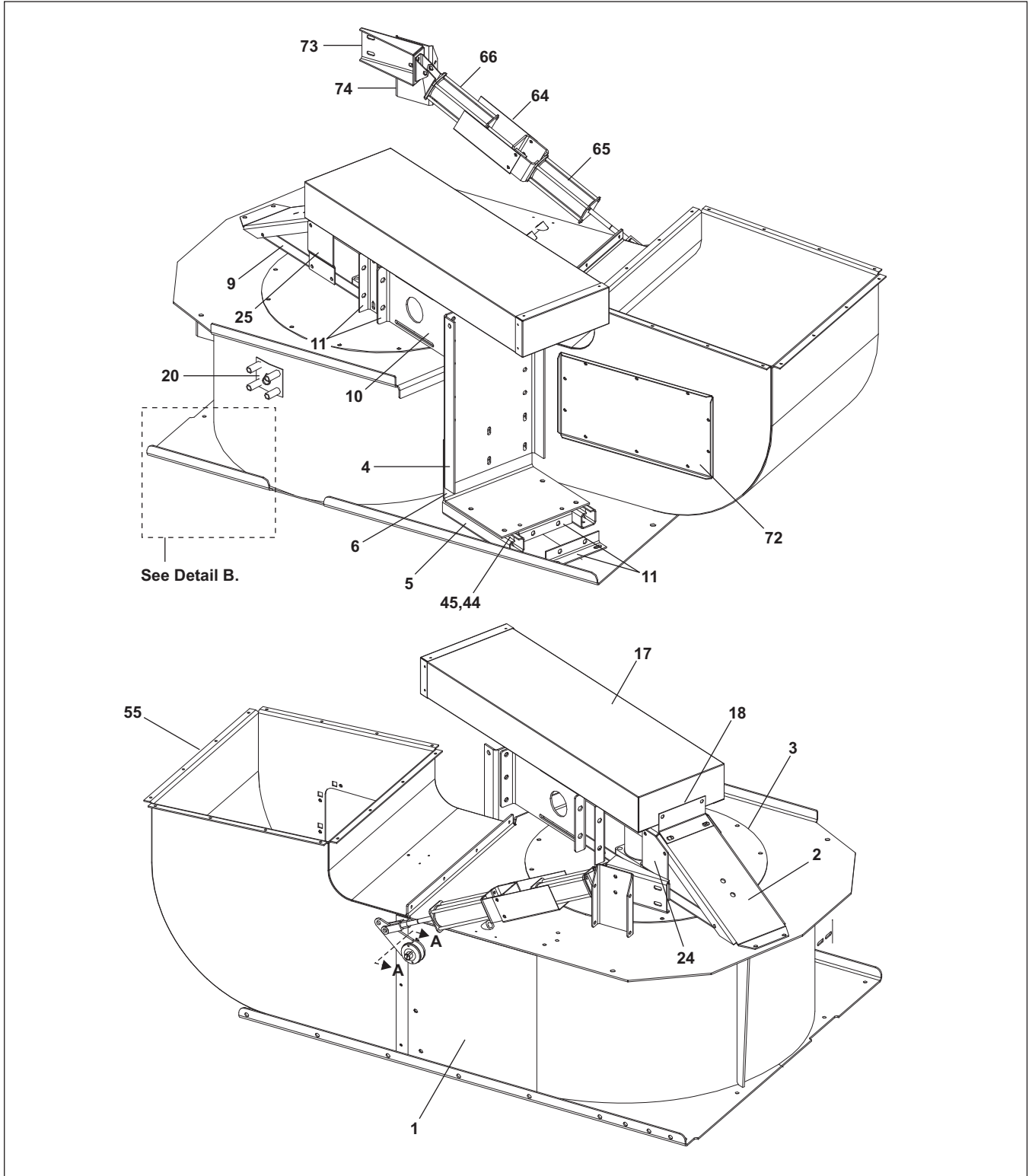
Litho in U.S.A.

Used In	Item	Part Number	Description	Comments
	A	A77BA006	6458 BLW ASSY LEFT=HORZ EXST	
	1	W7 71075	6458 - 22.25" BLOWER WELDMENT	
all		07 50254	CHANNEL=BRG MT UPPER BLOWER	
all		07 71089	6458 BLOWER TOP PLATE	
all		07 71092	6458 BLOWER MTR UPPER BKT	
all		07 70140	+5880 BLOWER MOTOR RAIL	
all		07 71094	6458 BLOWER MTR LOWER BKT	
all		13E222CW	BLOWER WHL 22+1/4"CL-3(CW)	
all		13E222CONE	FUNNEL/INLET CONE #222 WHL.	
all		07 50255	CHANN BRG MT LOWER BLOWER	
all		07 70137	+5880 MAIN BLOWER MTR SPT BKT	
all		07 50252	ANGLE=BELT ADJ BLOWER MOTOR	
all		A75BG004	BLW BRG HSE ASSY=2001354	
all		07 50288	BLOWER SHAFT TEFLON SEAL	
all		07 50287	BLOWER SHAFT FELT SEAL	
all		07 50286	BLOWER SHAFT SEAL CAP	
all		07 50184	BLWR BRG HSE SPACE SH=00143	
all		A77BA002	*5880 BLOWER BELT GUARD ASSY	
all		07 50267	BRACKET=MAIN BLW BELT GUARD	
all		07 50262	BRACKET=MAIN BLW BELT GUARD	
all		W7 60265	*LINT NOZZLE PLATE WLMT	
all		51E505	HOSESTEM BRASS 3/8H XMPT	
all		12P014SZ	TUBE CLAMP 1/2"STZ TIN#4886S	
all		90A025	COPPERTUBE 1/2"X.032X50' EA=1	
all		07 50257	20" BLOWER BKT SUPPORT LEFT	
all		07 50257A	20" BLOWER BKT SUPPORT RT	
all		15E195	SQMACHKEY 3/16X1+1/2 NOTAPER&H	
all		15K202	HEXCAPSCR 1/2-13UNC2AX5 GR5 ZI	
all		15D122C	HEXTAPSCR 1/2-13UNC 8.5 FLTHD	
all		15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all		15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all		15K095	HXCPCSCR 3/8-16UNC2AX1 GR5 ZINC	
all		15G205	HXNUT 3/8-16UNC2B ZINC GR2	

Used In	Item	Part Number	Description	Comments
all	36	15U255	LOKWASHER MEDIUM 3/8 ZINCPL	
all	37	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	38	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	39	15N140	RDMACSCR 10-24UNC2AX3/4 ZINC G	
all	40	15G125	HXMACHSCRNUT 10-24UNC2B ZINC G	
all	41	15U150	LOKWASHER MEDIUM #10 ZINCPL	
all	42	15K039	HXCAPSCR 1/4-20UNC2AX3/4 GR5 Z	
all	43	15U180	LOKWASHER MEDIUM 1/4 ZINCPL	
all	44	15G165	HXNUT 1/4-20UNC2BSAE ZC GR2	
all	45	02 19283	NUT=1/2-13UNCX1+1/2SQ SPEC	
all	46	15K151	HXCAPSCR 1/2-13UNC24X1.25 Gr5	
all	47	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	48	15E225	SQMACHKEY 3/8X1+1/2 NOTAPER-NO	
all	49	56AHN08	N08 BEARING LOCKNUT	
all	50	56AHW108	TW108 BEARING LOCKWASHER	
all	51	15D119	HXTAPSCR 1/2-13X4 GR5 ZNC FTL	
all	52	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	53	07 50187	BLOWER BEARING HOLDER	
A	54A	09X175	IGNITION TRANSFRMER Q624A1014B	U.S.
B	54B	09X175A	IGNITION TRANSFRMER CE ECLIPSE 10012234	CE (EUROPE)
B	54BB	09X175AB	MOUNTING KIT FOR 09X175A - ECLIPSE	CE (EUROPE)
all	55	W7 71137	6458 BLW EXHST WELD=LF=HORZ	
all	55	W7 71137A	6458A BLW EXHST WELD=RT=HORZ	
all	56	15E195	SQMACHKEY 3/16X1+1/2 NOTAPER&H	
all	57	56Q0PH	3/4" BUSH VPUL TYPE H,D, OR QT	
all	58	W7 71098B	6458 BLWR DAMP ARM WELD HORZ	
all	59	54E015	FLGMTBRG 3/4 BORE BRZ #FLB12	
all	60	W7 71097	6458 BLWR DAMP WELD HORZ LF	
all	61	30R0225P	THERMOSW.FENWAL CLOSE @ 225F	
all	62	30R0055PP	* DRYER OUTLET T/C PROBE ASSY	
all	63	A77BP001	6458 BACK PRESSURE SWIT ASSY	
all	64	A77AC003	6458 MAIN DAMP CYL ASSY	
all	65	A75 01300A	6458 AIR CYL. DAMP=2"STROKE	
all	66	A75 01200A	6458 AIR CYL. DAMP=3" STROKE	
all	67	96M055	DELTROL QUICK EXHAUST VLV.1/4"	
all	68	5SP0GFFSSV	NPT PLUG 3/8 SQSOLIDVENTBLKSTL	
all	69	15K191	HXCAPSCR 1/2-13UNC2AX2.5 GR5 Z	
all	70	15U243	FLTWASHER 7/8ODX33/64IDX16GA Z	

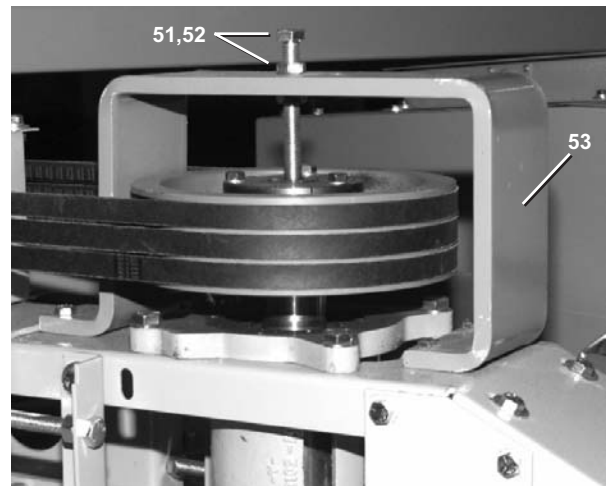
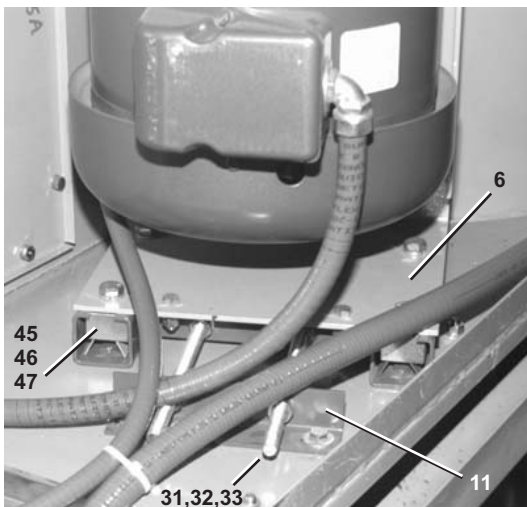
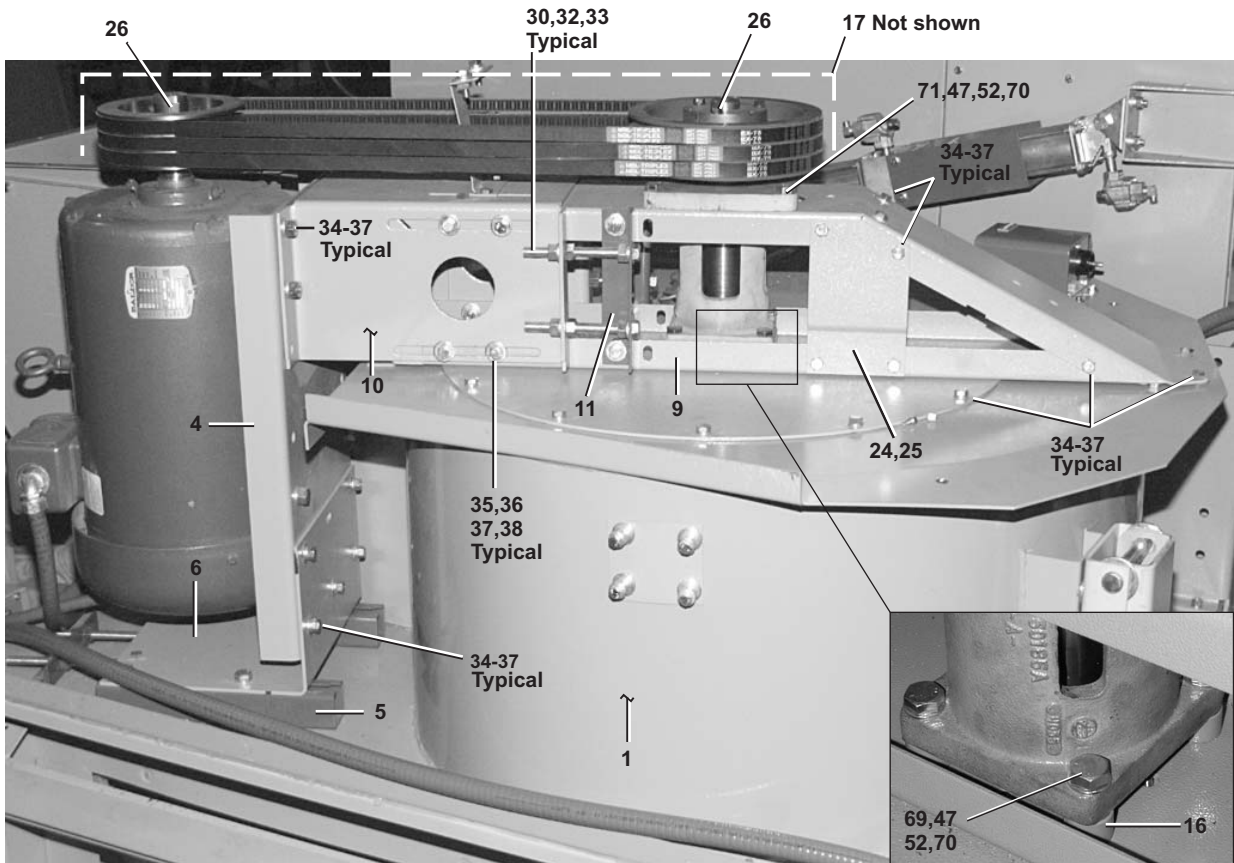
Blower with Front Vertical Exhaust

6458TG1L/R, 6464TG1L/R



Blower with Front Vertical Exhaust

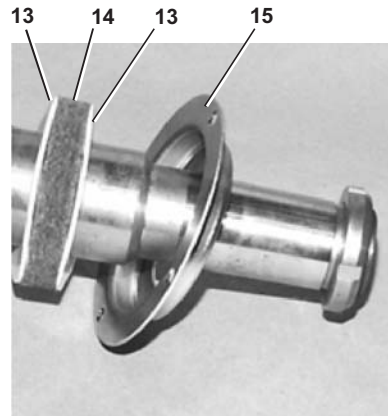
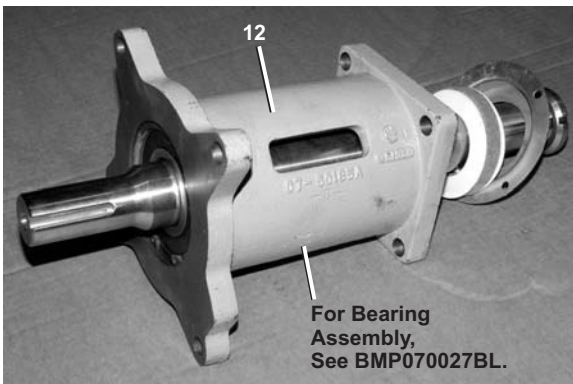
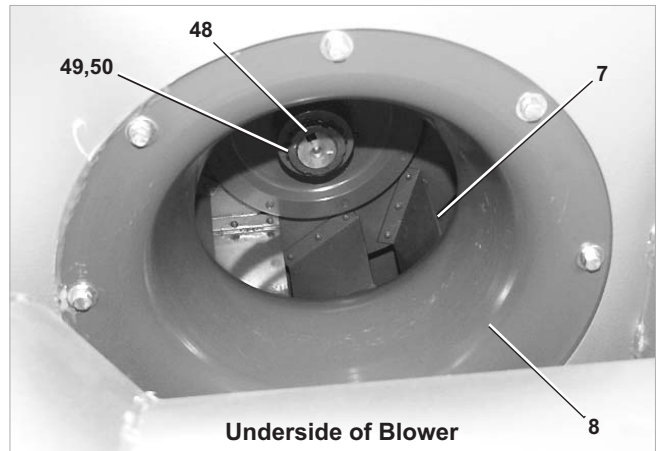
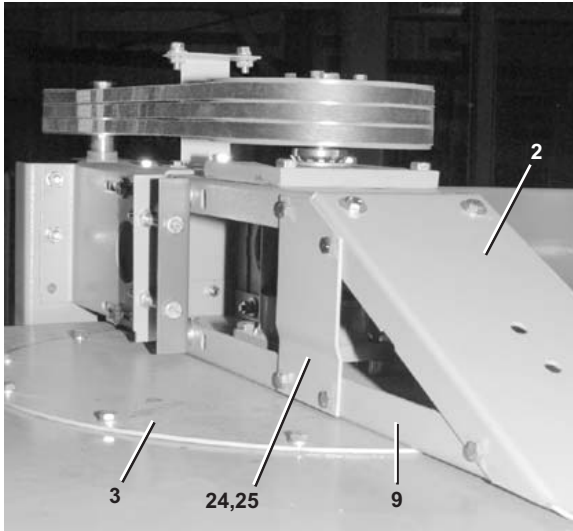
6458TG1L/R, 6464TG1L/R



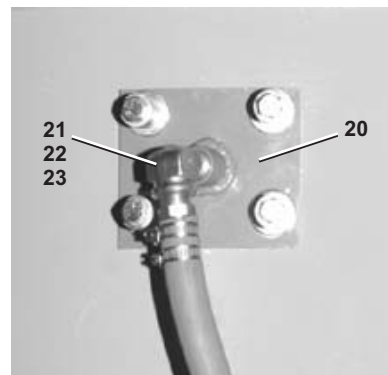
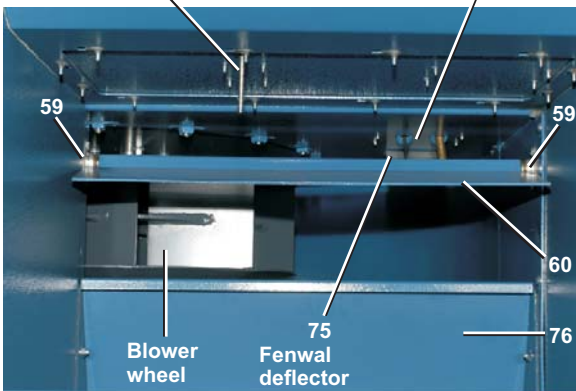
Bearing Shipping Bracket

Blower with Front Vertical Exhaust

6458TG1L/R, 6464TG1L/R



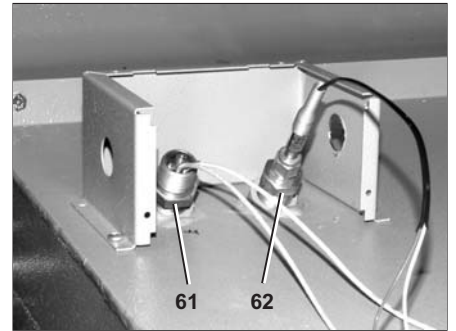
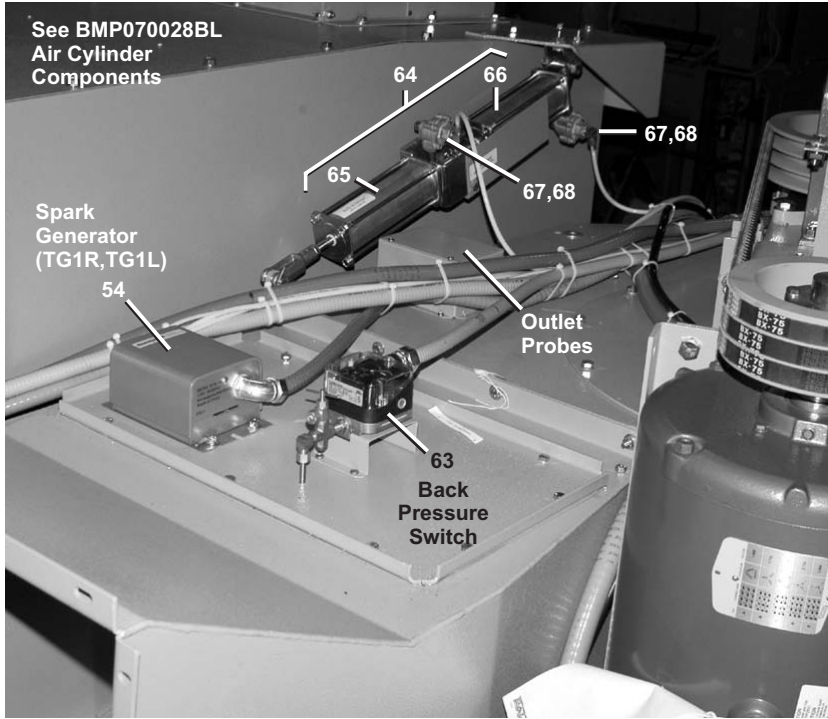
Back pressure switch Outlet probes



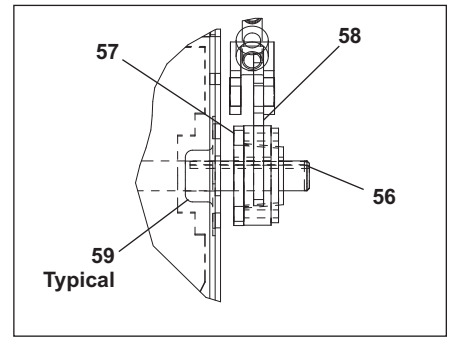
Blower Blow Down

Blower with Front Vertical Exhaust

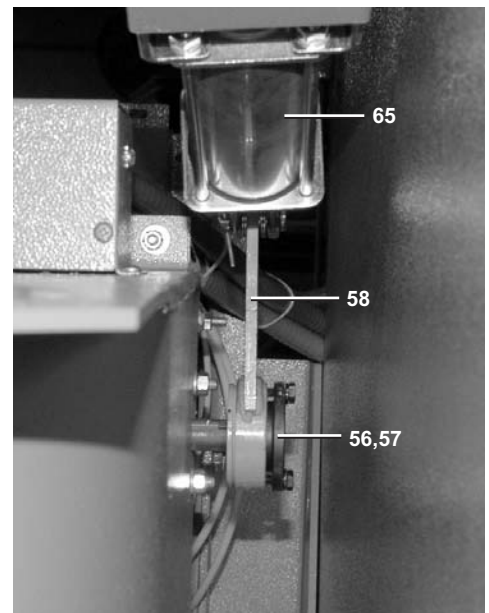
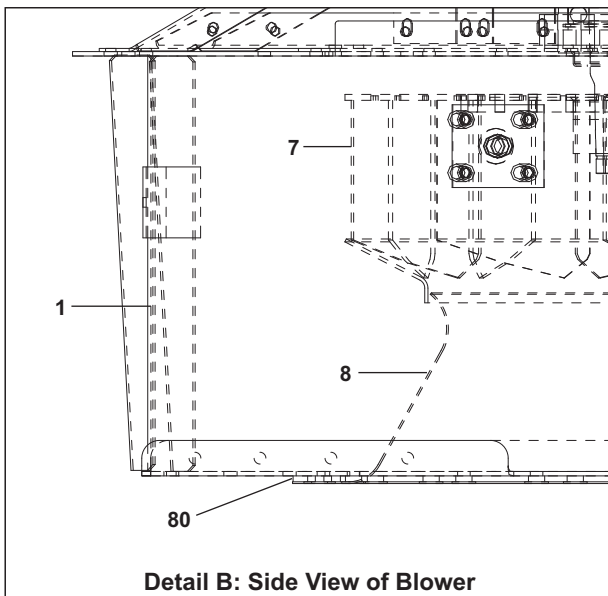
6458TG1L/R, 6464TG1L/R



Outlet Probes



View A-A



Blower with Front Vertical Exhaust

6458TG1L/R, 6464TG1L/R

Parts List				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	A77BA008	6464 NL FRNT VT EXHST BLWR ASSY - LT	
	B	A77BA008A	6464 NL FRNT VT EXHST BLWR ASSY - RT	
-----COMPONENTS-----				
A	1	W7 71075B	WLMT=BLOWR VOLUTE 22.25" 6464 LT	
B	1	W7 71075C	WLMT=BLOWR VOLUTE 22.25" 6464 RT	
all	2	07 50254	CHANNEL=BRG MT UPPER BLOWER	
all	3	07 71089	6458 BLOWER TOP PLATE	
all	4	07 71092	6458 BLOWER MTR UPPER BKT	
all	5	07 70140	+5880 BLOWER MOTOR RAIL	
all	6	07 71094	6458 BLOWER MTR LOWER BKT	
all	7	13E222CWA	BLOWER WHL 22+1/4"CL-3 CW	
all	8	13E222CONE-P	FUNNEL/INLET CONE #222 WHL.PAINTED	
all	9	07 50255	CHANN BRG MT LOWER BLOWER	
all	10	07 70137	+5880 MAIN BLOWER MTR SPT BKT	
all	11	07 50252	ANGLE=BELT ADJ BLOWER MOTOR	
all	12	A75BG004	BLW BRG HSE ASSY=2001354	
all	13	07 50288	BLOWER SHAFT TEFLON SEAL	
all	14	07 50287	BLOWER SHAFT FELT SEAL	
all	15	07 50286	BLOWER SHAFT SEAL CAP	
all	16	07 50184	BLWR BRG HSE SPACE SH=00143	
all	17	A77BA002	*5880 BLOWER BELT GUARD ASSY	
all	18	07 50267	BRACKET=MAIN BLW BELT GUARD	
all	19	07 50262	BRACKET=MAIN BLW BELT GUARD	
all	20	W7 60265	*LINT NOZZLE PLATE WLMT	
all	21	51E505	HOSESTEM BRASS 3/8H XMPT	
all	22	12P014SZ	TUBE CLAMP 1/2"ST/Z TIN#4886S	
all	24	07 50257	20" BLOWER BKT SUPPORT LEFT	
all	25	07 50257A	20" BLOWER BKT SUPPORT RT	
all	26	15E195	SQMACHKEY 3/16X1+1/2 NOTAPER&H	
all	30	15K202	HEXCAPSCR 1/2-13UNC2AX5 GR5 ZI	
all	31	15D122C	HEXTAPSCR 1/2-13UNCK 8.5 FLTHD	
all	32	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	33	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	34	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	35	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	36	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	

Blower with Front Vertical Exhaust

6458TG1L/R, 6464TG1L/R

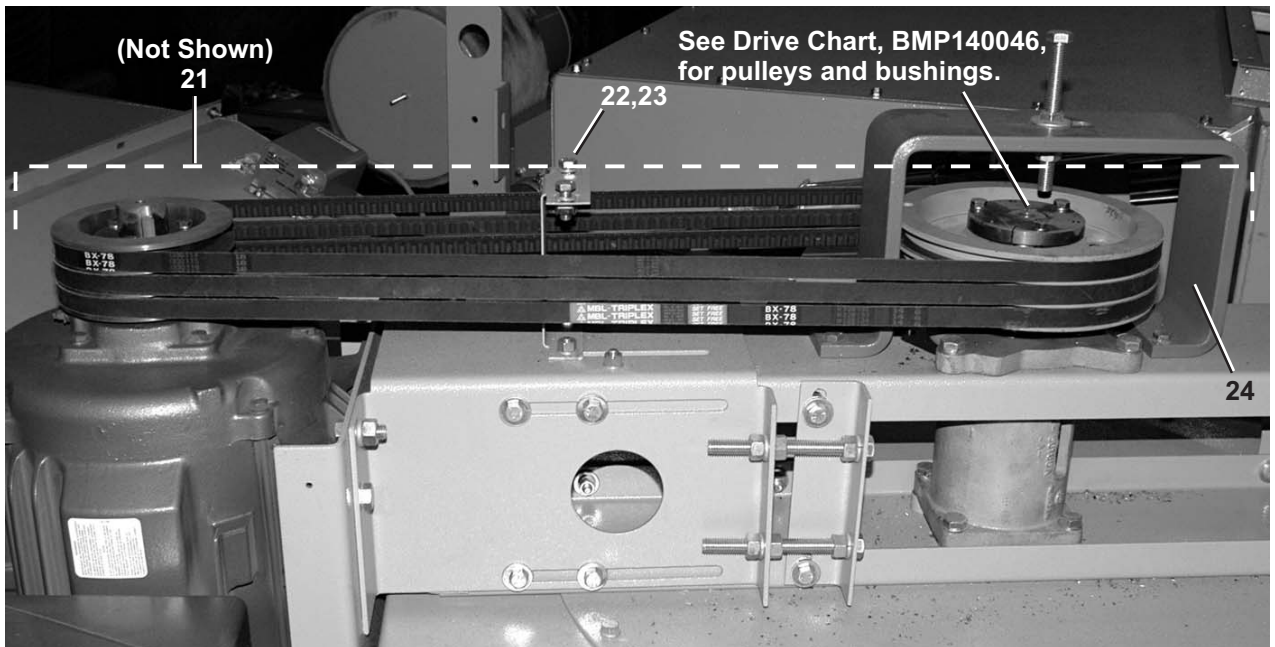
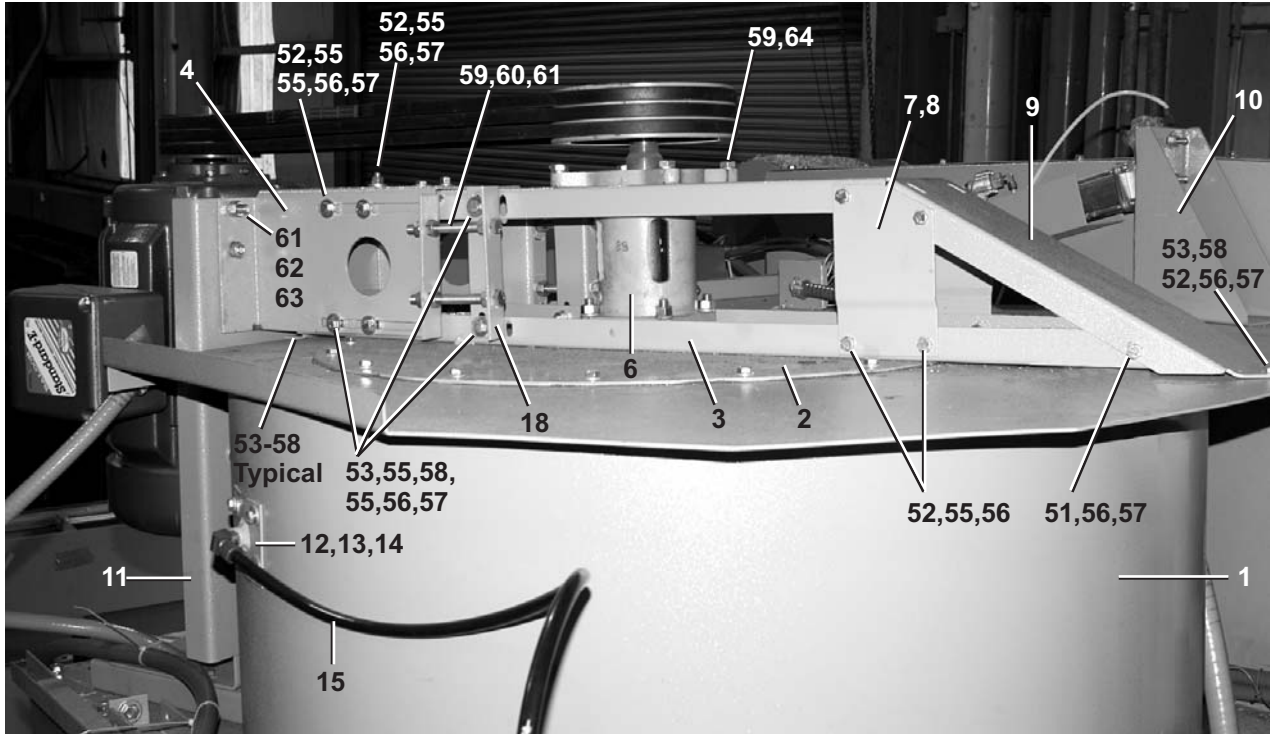
Parts List

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
all	37	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	38	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	39	15N140	RDMACSCR 10-24UNC2AX3/4 ZINC G	
all	40	15G125	HXMACHSCRNUT 10-24UNC2B ZINC G	
all	41	15U150	LOCKWASHER MEDIUM #10 ZINCPL	
all	42	15K039	HXCAPSCR 1/4-20UNC2AX3/4 GR5 Z	
all	43	15U180	LOCKWASHER MEDIUM 1/4 ZINCPL	
all	44	15G165	HXNUT 1/4-20UNC2BSAE ZC GR2	
all	45	02 19283	NUT=1/2-13UNCX1+1/2SQ SPEC	
all	46	15K151	HXCAPSCR 1/2-13UNC2AX1.25 GR5	
all	48	15E225	SQMACHKEY 3/8X1+1/2 NOTAPER-NO	
all	49	56AHN08	N08 BEARING LOCKNUT	
all	50	56AHW108	TW108 BEARING LOCKWASHER	
all	51	15D119	HXTAPSCR 1/2-13X4 GR5 ZNC FTL	
all	53	07 50187	BLOWER BEARING HOLDER	
all	54	09X175	IGNITION TRANSFRMER Q624A1014-B (BULK PAK)	
all	55	W7 71071	6458 BLOWER EXHAUST WELD	
all	57	56Q0PH	3/4" BROWNING H BUSHING TYPE 1	
all	58	W7 71098	6458 BLOWER DAMPER ARM WELD	
all	59	54E015	FLGMTBRG 3/4 BORE BRZ #FLB12	
all	60	W7 71097	6458 22.75" BLWR DAMP WELD LF	
all	61	30R0225P	THERMOSW.FENWAL CLOSE @ 225F	
all	62	30R0055PP	* DRYER OUTLET T/C PROBE ASSY	
all	63	A77BP001	6458 BACK PRESSURE SWIT ASSY	
all	64	A77AC003	6458 MAIN DAMP CYL ASSY	
all	65	A75 01300A	6458 AIR CYL. DAMP=2" STROKE	
all	66	A75 01200A	6458 AIR CYL. DAMP=3" STROKE	
all	67	96M055	DELTROL QUICK EXHAUST VLV.1/4"	
all	68	5SP0GFFSSV	NPT PLUG 3/8 SQSOLIDVENTBLKSTL	
all	69	15K191	HXCAPSCR 1/2-13UNC2AX2.5 GR5 Z	
all	70	15U243	FLTWASHER 7/8ODX33/64IDX16GA Z	
all	71	15K173A	HXCAPSCR 1/2-13UNC2AX1.75 GR5	
all	72	07 71095B	COVER=CLEAN OUT 6458	
all	73	07 85197B	6464 FB RETRO AIR DMPR ANGLE EXT BRKT	
all	74	07 85197	6464 FB RETRO AIR DMPR BRKT	
all	75	07 71040	FENWALL DEFLECTOR	
all	76	07 71090	6458 BLOWER CUTOFF PLATE	

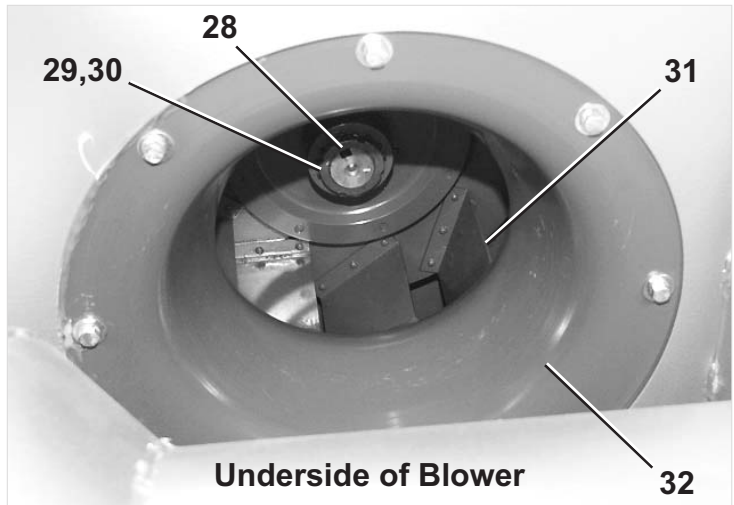
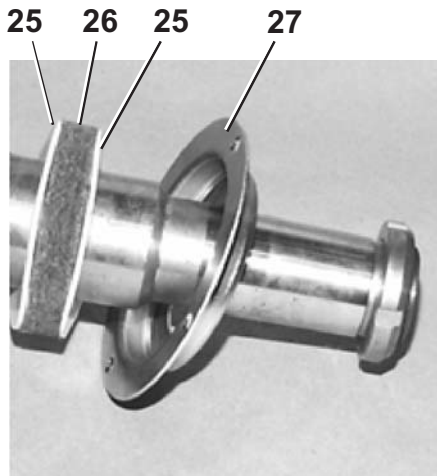
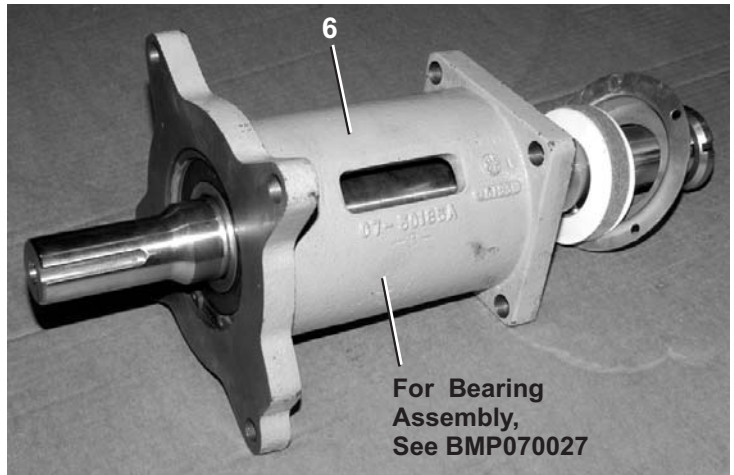
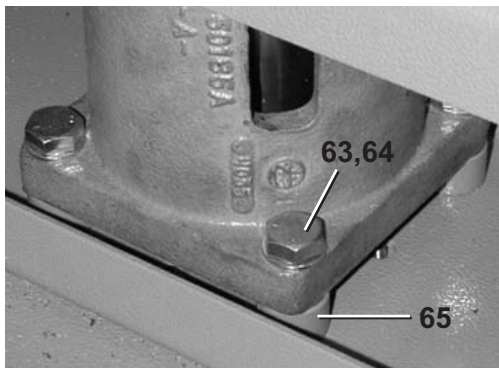
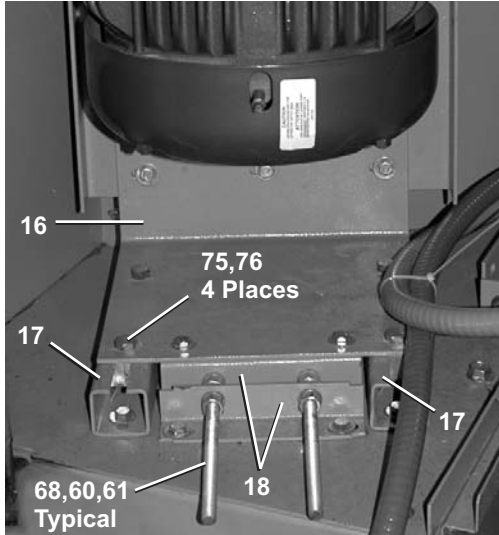
Blower & Exhaust Duct Installation

7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R



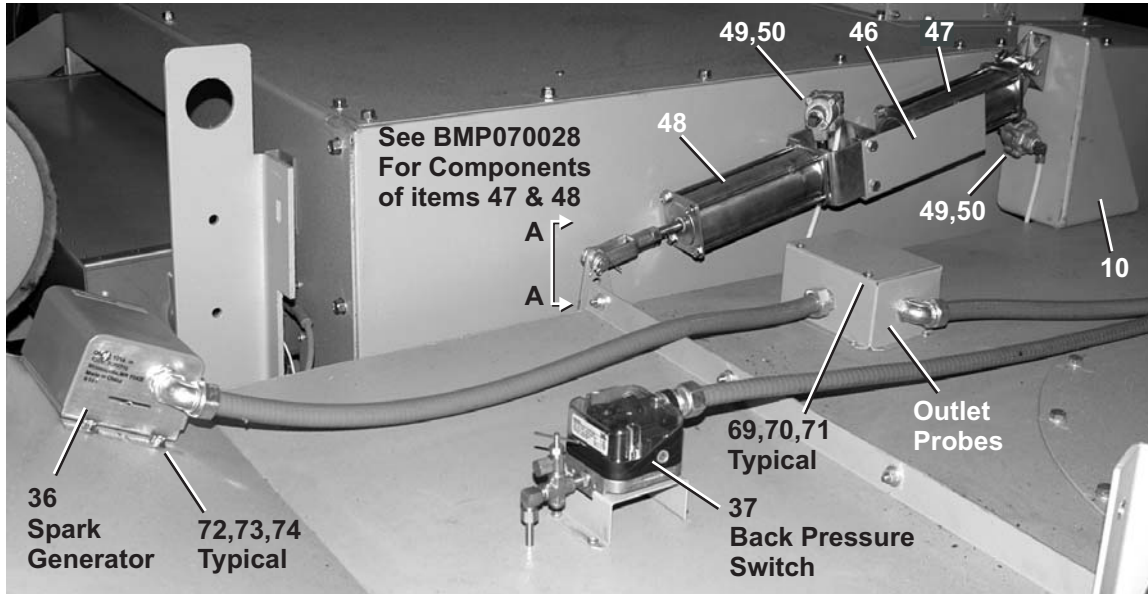
Blower & Exhaust Duct Installation

7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R

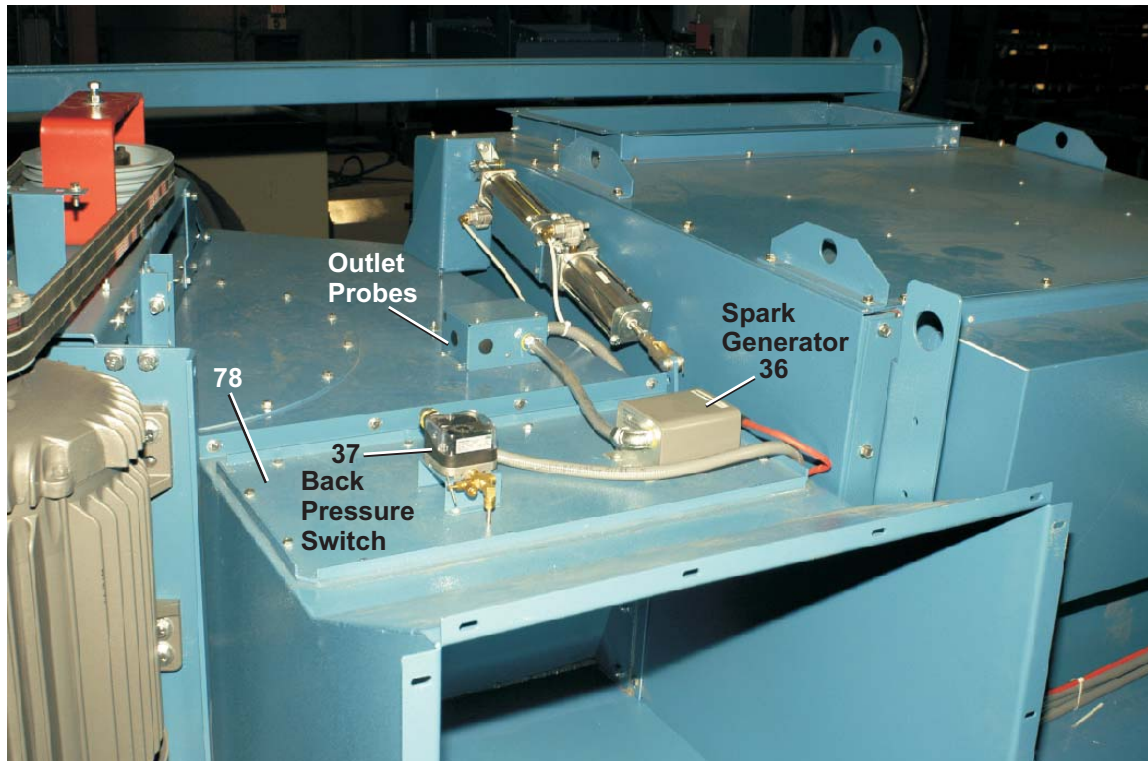


Blower & Exhaust Duct Installation

7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R



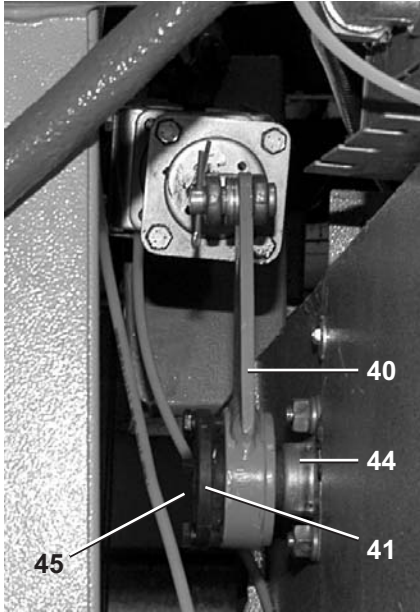
7272TG1L/R



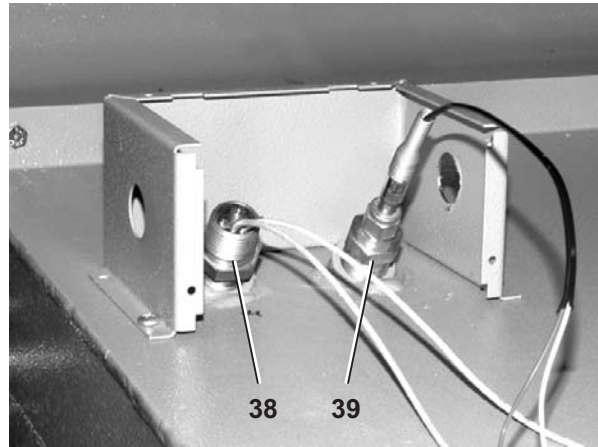
7676TG1L/R

Blower & Exhaust Duct Installation

7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R

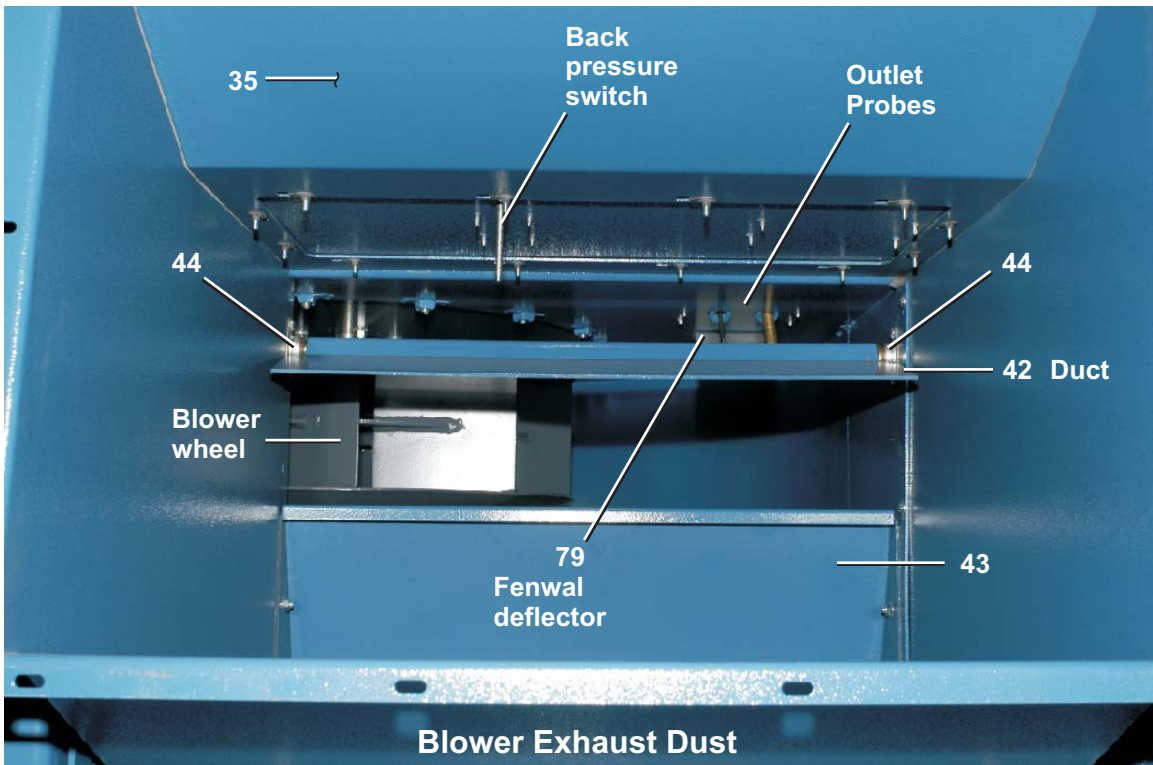


View A-A



Outlet Probes

See also, Temperature Sensors, BMP140050.



Blower Exhaust Dust

Blower & Exhaust Duct Installation

7272TG1L/R,TS1L/R 7676TG1L/R 8282TG1L/R

Parts List—Blower & Exhaust Duct Installation				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	A79BA006	7272 BLW ASSY LEFT=HORZ	7272TG1L
	B	A79BA006A	7272 BLW ASSY RIGHT=HORZ	7272TG1R
	C	A79BA020	7676 BLOWER ASSY LEFT	7676TG1L
	D	A79BA020A	7676 BLOWER ASSY RIGHT	7676TG1R
	E	A82BA001	8282 LEFT BLOWER ASSY	8282TG1L
	F	A82BA001A	8282 RIGHT DRYER ASSY	8282TG1R
-----COMPONENTS-----				
A	1	W7 81075	7272=27" BLOWER WELDMNT	
B	1	W7 81075A	7272A=27" BLOWER WELDMNT	
C	1	W7 85046	WLMT=7676 DRYER BLOWER LEFT	
D	1	W7 85046A	WLMT=7676 DRYER BLOWER RIGHT	
E	1	W7 88090	8282 LT BLOWER WLMT	
F	1	W7 88090A	8282 RT BLOWER WLMT	
ABCD	2	07 81073	7272 BLOWER TOP PLATE	
EF	2	07 88204	8282 BLOWER TOP PLATE	
ABCD	3	07 81122	7272 CHANN=BRG MT LOWER BLWR	
EF	3	07 81122A	8282 CHANN=BRG MT LOWER BLWR	
ACE	4	07 81119	7272 MAIN BLOWER MTR SPT BKT	
BDF	4	07 81119A	7272 MAIN BLOWER SUP BKT	
all	6	A75BG004	BLW BRG HSE ASSY=2001354	
all	7	07 50257	20" BLOWER BKT SUPPORT LEFT	
all	8	07 50257A	20" BLOWER BKT SUPPORT RT	
all	9	07 81121	7272 BRG MT UPPER BLOWER	
ACE	10	07 81143	7272 REAR EXH MAIN CLY SUPP	
BDF	10	07 81143A	7272A REAR EXH MAIN CLY SUPP	
all	11	07 81094	7272 BLOWER MTR UPPER BRKT	
all	12	W7 60265	*LINT NOZZLE PLATE WLMT	
all	13	51E505	HOSESTEM BRASS 3/8H XMPT	
all	14	53A025	MALECON.5X3/8COMP PH#68C-8-6	
all	15	60E005F	TUBING NYL.BLK.1/2"ODX.375ID	
all	16	07 71094	6458 BLOWER MTR LOWER BKT	
all	17	07 70140	+5880 BLOWER MOTOR RAIL	
all	18	07 50252	ANGLE=BELT ADJ BLOWER MOTOR	
all	21	A79BA002	7272 BLOWER BELT GUARD ASSY	

Blower & Exhaust Duct Installation

7272TG1L/R,TS1L/R 7676TG1L/R 8282TG1L/R

Parts List—Blower & Exhaust Duct Installation

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
all	22	17N070P	RETAIN NUT 3/8-16 #S10100-27	
all	24	07 50187	BLOWER BEARING HOLDER	
all	25	07 50288	BLOWER SHAFT TEFLON SEAL	
all	26	07 50287	BLOWER SHAFT FELT SEAL	
all	27	07 50286	BLOWER SHAFT SEAL CAP	
all	28	15E225	SQMACHKEY 3/8X1+1/2 NOTAPER-NO	
all	29	56AHN08	N08 BEARING LOCKNUT	
all	30	56AHW108	TW108 BEARING LOCKWASHER	
AC	31	13E270CCW	BLOWER WHL.27"CL4(CCW)TAPERHUB	
BD	31	13E270CW	BLOWER WHL 27"CL-4(CW)TAPERHUB	
EF	31	13E300CCW	BLOWER WHL.30"CL4(CCW)TAPERHUB	
ABCD	32	13E270CONE-P	FUNNEL/INLET CONE 27" WHL.	
EF	32	13E300CONE-P	FUNNEL/INLET CONE 30" WHL	
AC	35	W7 81137	7272 BLW EXHST WELD=LF=HORZ	
BD	35	W7 81137A	7272A BLW EXHST WELD=LF=HORZ	
all	36	09X175	IGNITION TRANSFRMER Q624A1014-B	
all	37	A77BP001	6458 BACK PRESSURE SWIT ASSY	
all	38	30R0225P	THERMOSW.FENWAL CLOSE @ 225F	See also BMP140050.
ABCDEF	39	30R0055PP	* DRYER OUTLET T/C PROBE ASSY	
ACE	40	W7 81098	7272 BLOWER DAMPER ARM WELD	
BDF	40	W7 81098A	7272A BLOWER DAMPER ARM WELD	
all	41	56Q0PH	3/4" BUSH VPUL TYPE H,D, OR QT, OR L	
ACE	42	W7 81096	7272 BLOWER AIR DAMPER WELD	
BDF	42	W7 81096A	7272A BLOWER AIR DAMPER WELD	
all	43	07 81090	7272 BLOWER CUTOFF PLATE	
all	44	54E015	FLGMTBRG 3/4 BORE BRZ #FLB12	
all	45	15E195	SQMACHKEY 3/16X1+1/2 NOTAPER&H	
all	46	A77AC003	6458 MAIN DAMP CYL ASSY	
all	47	A75 01200A	6458 AIR CYL. DAMP=3" STROKE	
all	48	A75 01300A	6458 AIR CYL. DAMP=2"STROKE	
all	49	96M055	DELTROL QUICK EXHAUST VLV.1/4"	
all	50	5SP0GFFSSV	NPT PLUG 3/8 SQSOLIDVENTBLKSTL	
all	52	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	

Blower & Exhaust Duct Installation

7272TG1L/R,TS1L/R 7676TG1L/R 8282TG1L/R

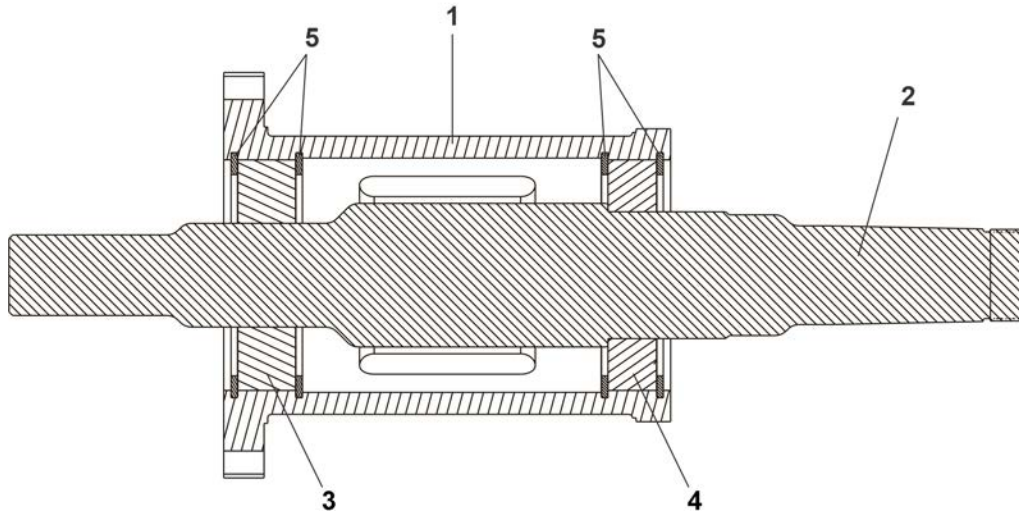
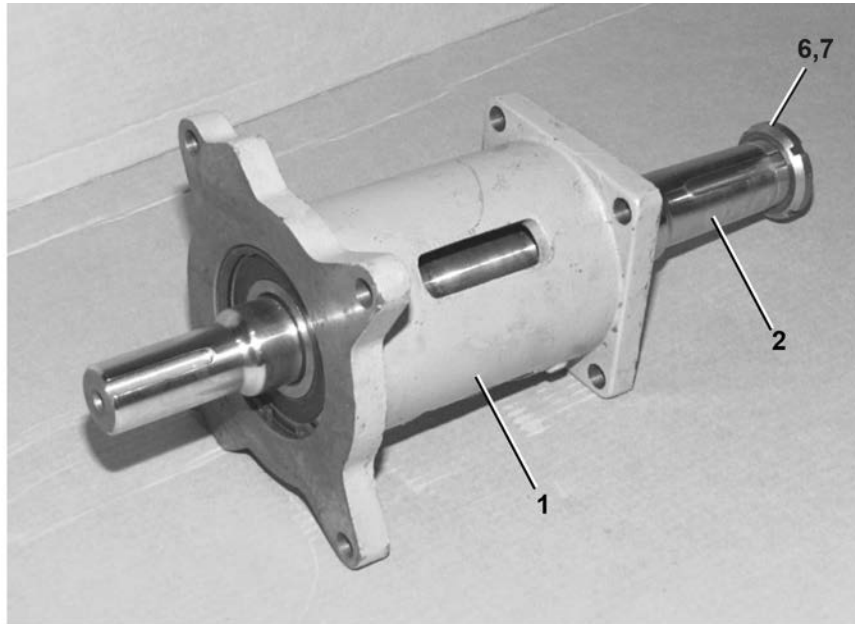
Parts List—Blower & Exhaust Duct Installation

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
all	53	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	55	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	56	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	57	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	58	15U266	FLATWASHER 1"0DX7/16"IDX3/16"	
all	59	15K202	HEXCAPSCR 1/2-13UNC2AX5 GR5 ZI	
all	60	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	61	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	62	15K173A	HXCAPSCR 1/2-13UNC2AX1.75 GR5	
all	63	15K191	HXCAPSCR 1/2-13UNC2AX2.5 GR5 Z	
all	64	15U280C	FLATWASH(US STD)1/2"CLIP+ZNC	
all	65	07 50184	BLWR BRG HSE SPACE SH=00143	
all	68	15D122C	HEXTAPSCR 1/2-13UNCK 8.5 FLTHD	
all	69	15N140	RDMACSCR 10-24UNC2AX3/4 ZINC G	
all	70	15G125	HXMACHSCRNUT 10-24UNC2B ZINC G	
all	71	15U150	LOCKWASHER MEDIUM #10 ZINCPL	
all	72	15K039	HXCAPSCR 1/4-20UNC2AX3/4 GR5 Z	
all	73	15U180	LOCKWASHER MEDIUM 1/4 ZINCPL	
all	74	15G165	HXNUT 1/4-20UNC2BSAE ZC GR2	
all	75	02 19283	NUT=1/2-13UNCX1+1/2SQ SPEC	
all	76	15K151	HXCAPSCR 1/2-13UNC24X1.25 GR5	
all	78	07 81124	COVER=7272 DAMPER ACCESS	
all	79	07 71040	FENWALL DEFLECTOR	

Blower Bearing

1 of 2

**Legend**

1. Pressing against the inner race, press bearing (item 4) on the shaft.
2. Install one (item 5) into the inner groove at each end of item 1.
3. Pressing against the outer race, press bearing (item 4) with its shaft in housing (item 1) with guide at bearing location (item 3) to keep shaft and housing concentric.
4. Pressing bearing (item 3) against both its inner and outer race, press bearing (item 3) into housing and onto shaft, backing up bearing (item 4) at both its inner and outer race.
5. Install retaining rings (item 5) into outer grooves.

Blower Bearing

Table 1. Parts List—Blower Bearing

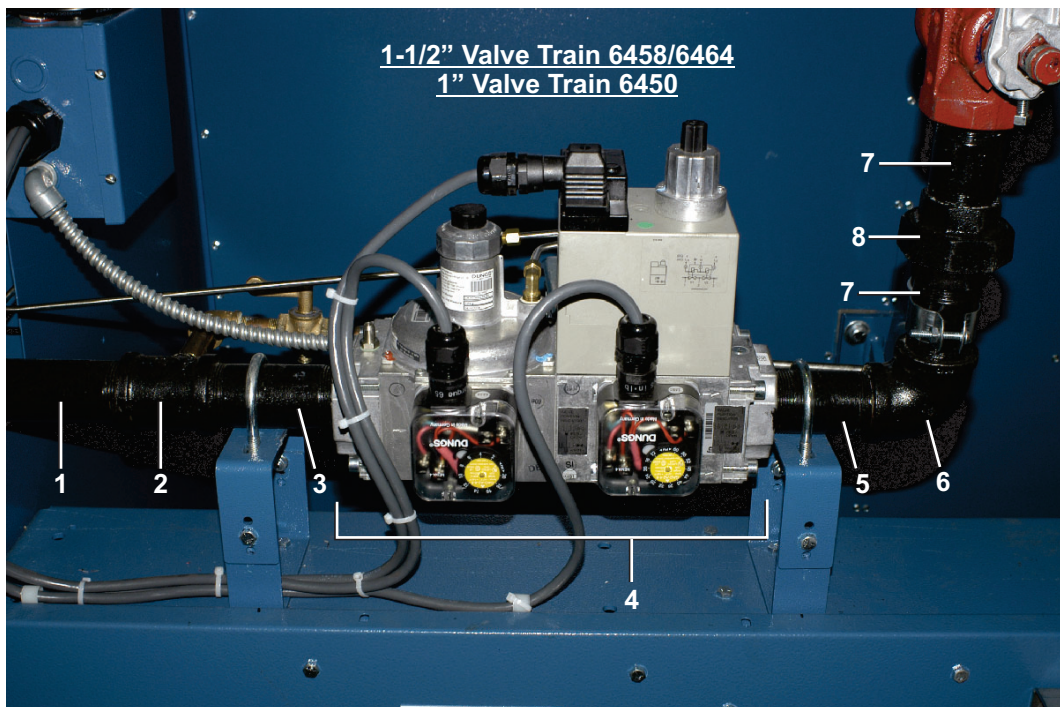
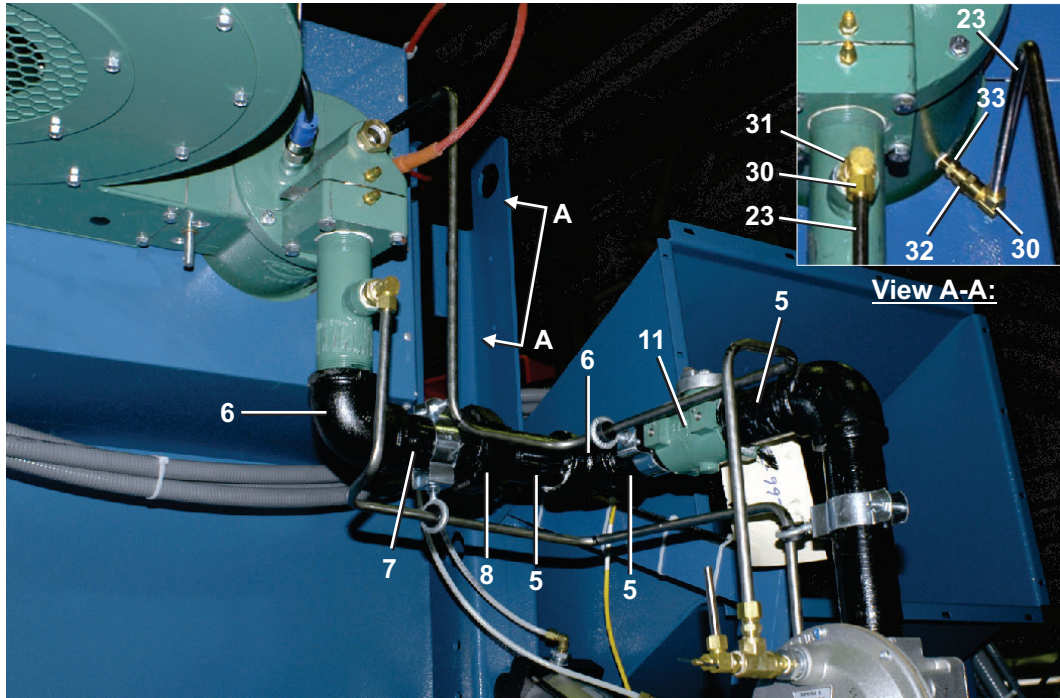
Find the assembly for your machine and the letter shown in the "Item" column. The components for your machine will show this letter or the word "all" in the "Used In" column. The numbers shown in the "Item" column are those shown in the illustrations.				
Used In	Item	Part Number	Description/Nomenclature	Comments
Reference Assemblies				
	A	A75BG004	BLW BRG HSE ASSY=2001354	ASSEMBLY CONTAINS ITEMS (1-7) BELOW
Components				
all	1	X7 50185	MACH=BLOWR BRG HSE SNAP RING	
all	2	07 50186	MACH=BLOWER SHAFT,SNAP RING	
all	3	54A073	BALBRG NTN#6309LLBC3/L627 1/BX	
all	4	54A072	BALLBEAR NSK#6211VVC3E EEMS 5	
all	5	17B014A	INTRETRING IND#3000-393	
all	6	56AHN08	N08 BEARING LOCKNUT	
all	7	56AHW108	TW108 BEARING LOCKWASHER	

Gas Assemblies

5

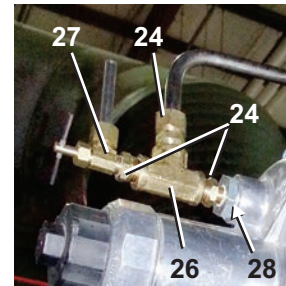
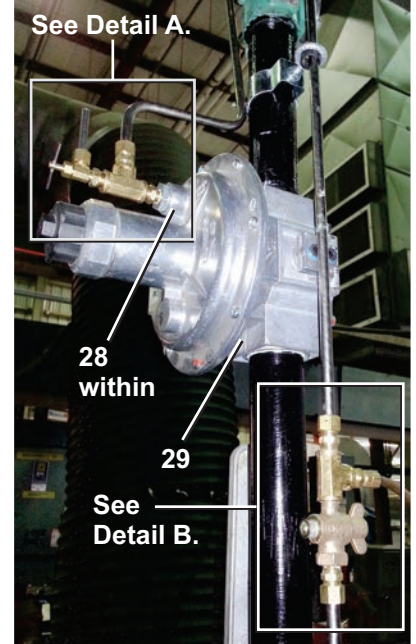
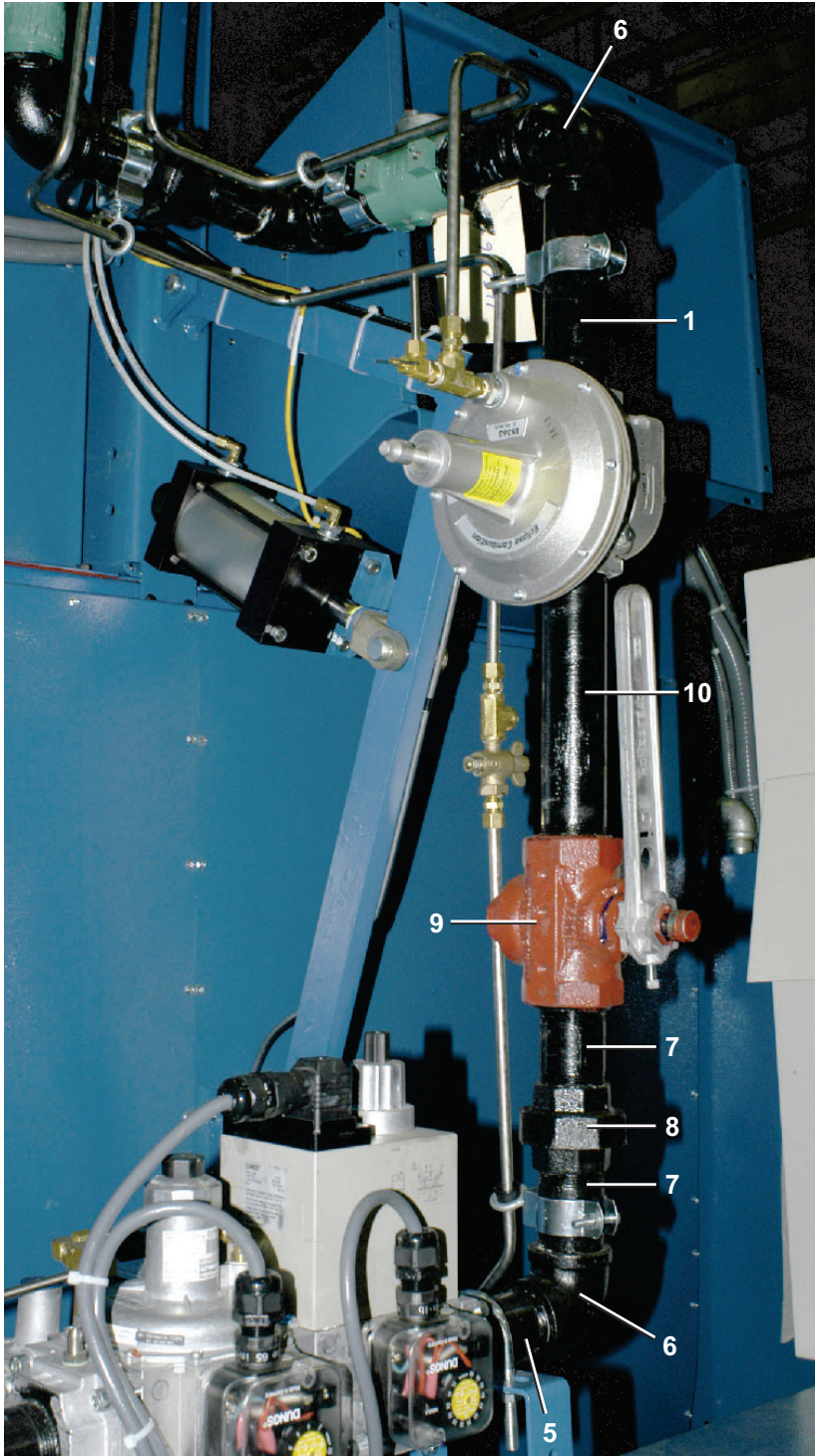
Gas Piping - Ratio Air

6450TG1L,TG1R, 6458TG1L,TG1R 6464TG1L,TG1R

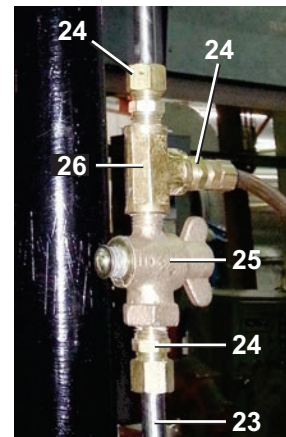


Gas Piping - Ratio Air

6450TG1L,TG1R, 6458TG1L,TG1R 6464TG1L,TG1R



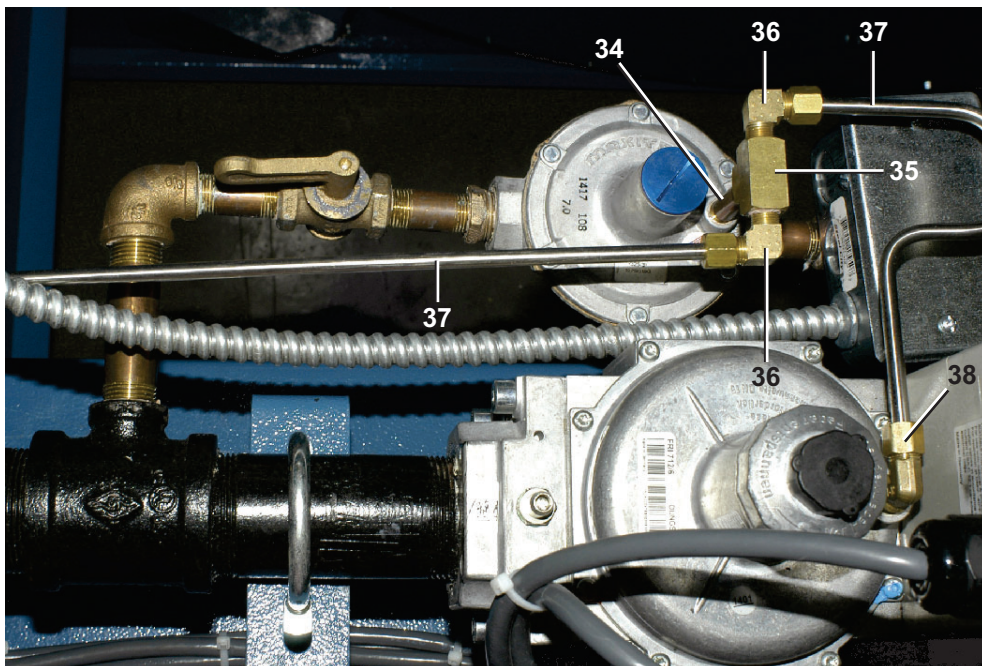
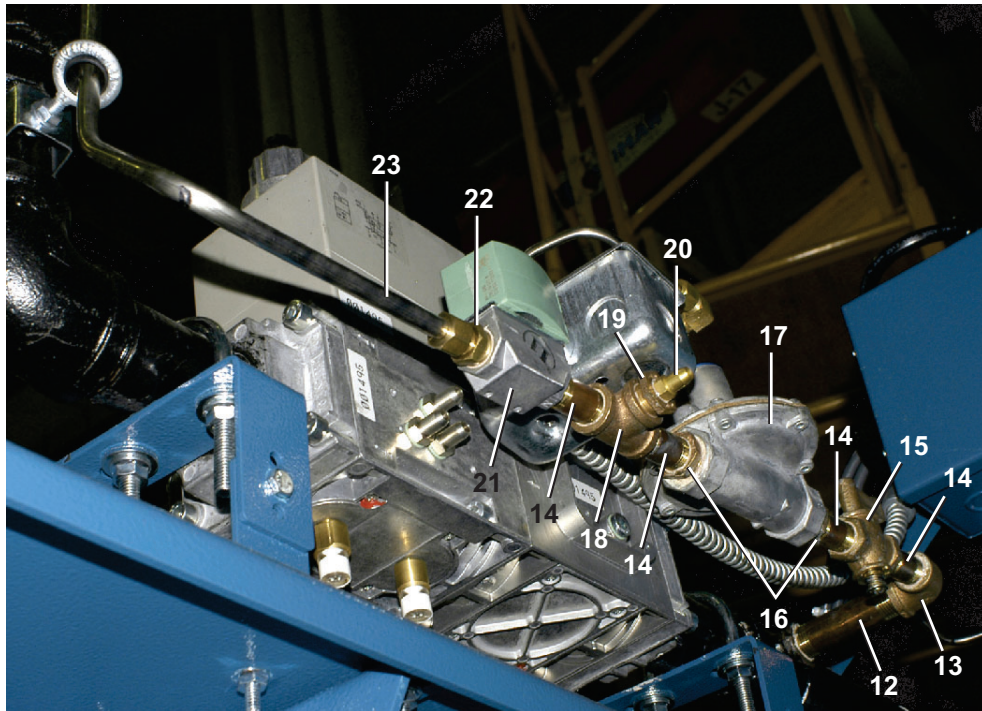
Detail A:



Detail B:

Gas Piping - Ratio Air

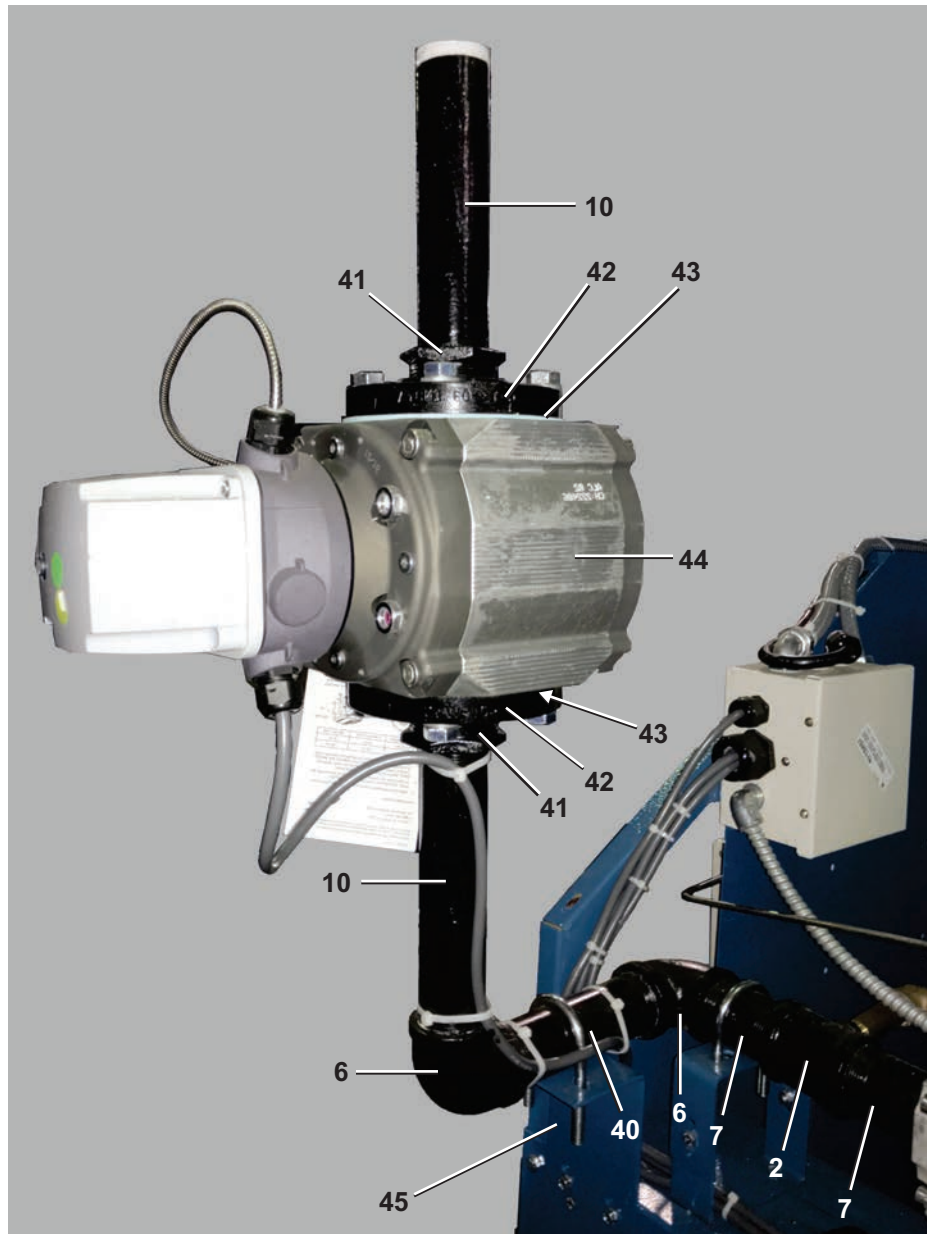
6450TG1L,TG1R, 6458TG1L,TG1R 6464TG1L,TG1R



Gas Piping - Ratio Air

6450TG1L, TG1R, 6458TG1L, TG1R 6464TG1L, TG1R

Entry Section with Optional Gas Meter (6464TG1L shown)



Gas Piping - Ratio Air

6450TG1L,TG1R, 6458TG1L,TG1R 6464TG1L,TG1R

Parts List—Gas Piping - Ratio Air				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----REFERENCE ASSEMBLIES-----				
	A	A77VG052B	6458/64TG1L RA 2V-NOVENT=CSA	6458TG1L, 6464TG1L
	B	A77VG052C	6458/64TG1R RA 2V-NOVENT=CSA	6458TG1R, 6464TG1R
	C	A74VH052B	6450TG1L RA NAT. 2V-NOVENT=CSA	6450TG1L, 6464TG1L
	D	A74VH052C	6450TG1R RA NAT. 2V-NOVENT=CSA	6450TG1L, 6464TG1L
	E	A77VG052F	6458/64TG1L RA NAT. 2V-NOVENT=CSA METER	6458/6464TG1L+ GAS METER
	F	A77VG052G	6458/64TG1R RA NAT. 2V-NOVENT=CSA METER	6458/6464TG1R+ GAS METER
-----COMPONENTS-----				
AB	1	5N1K07KF42	NPT NIP 1.5X7.5 TBE BLKSTL SK40	
AB	2	5S1KMFA0K	NPT TEE 1.5X1.5X1/2 BLKMAL150#	
AB	3	5N1K05AF42	NPT NIP 1.5X5 TBE BLKSTL SK40	
A	4	A77VG022E	RATIO AIR 1.5" VALTRAIN 2MLBTU LT TO RT UL795/CSA	
B	4	A77VG022F	RATIO AIR 1.5" VALTRAIN 2MLBTU RT TO LFT UL795/CSA	
CD	4	A74VG022E	RATIO AIR 1.0" VALTRAIN 1MLBTU LT TO RT UL795/CSA	
AB	5	5N1K04AF42	NPT NIP 1.5X4 TBE BLKSTL SK40	
AB	6	5SL1KMFA	NPT ELB 90DEG 1.5 BLKMAL 150#	
AB	7	5N1K03KF42	NPT NIP 1.5X3.5 TBE BLKSTL S40	
AB	8	5SU1KMF	NPT UNION 1.5" BLKMAL 150#	
AB	9	96G150C	1.5"GAS STOP VAL - RESUN #R-1430 W/"A" STYLE WRENCH HANDLE	
CD	9	96G100C	1"GAS STOP VALVE - RESUN #R-1430 W/"A" STYLE WRENCH HANDLE	
AB	10	5N1K09AF42	NPT NIP 1.5X9 TBE BLKSTL SK40	
AB	11	25AB442BV1	BUTTERFLY VALVE 1.5" 501218 FULL PORT	
AB	12	5N0K03KB42	NPT NIP 1/2X3.5 TBE BRASS STD	
AB	13	5SL0KBEA0G	NPTEL B 90DEG 1/2X3/8 BRASS 125	
AB	14	5N0G02ABE2	NPT NIP 3/8X2 TBE BRASS STD	
AB	15	96G030	3/8"GAS BALL VLV/ T- HANDLE-CONBRACO#80-102-07	
AB	16	5SR0K0GBE	NPT RED 1/2X3/8 BRASS 125#	
AB	17	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C	
AB	18	5S0GBEA	NPT TEE 3/8" BRASS 125#	
AB	19	5SB0G0EBEO	NPTHEXBUSH 3/8X1/4 BRASS 125#	
ABCD	20	96G0001	GAS TEST PORT ECLIPSE 13445	
ABCD	21	96TCC2BA37	3/8" N/C 2WAY 120V50/60C VALVE	
AB	22	53A026	BODYMALECON3/8X3/8 #68C-6-6B	
AB	23	87Z010	TUBE 3/8"ODX.035" SS304 *20RM	
AB	24	53A023	MALECON3/8X.25COMP ANCHR#68-64	

Gas Piping - Ratio Air

6458TG1L,TG1R 6464TG1L,TG1R

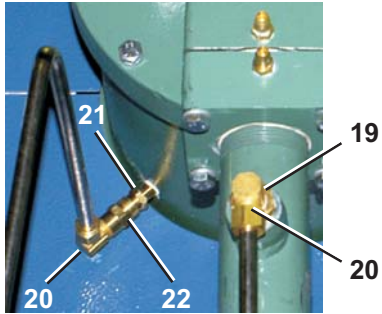
Parts List—Gas Piping - Ratio Air

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

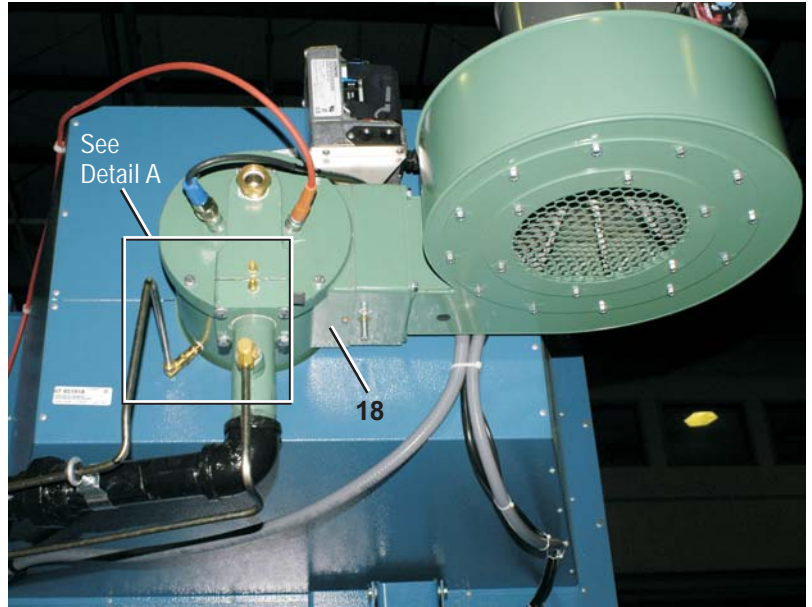
Used In	Item	Part Number	Description	Comments
ABCD	25	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL # 55-302-01	
AB	26	51V015	TEE 1/4 FGDBRASS 101T7-444	
ABCD	27	96H018	ANGLE NEEDLE VLV 1/4"T X 1/8MP	
AB	28	51T311	FLAMEARREST VNTSCREEN.375BRASS	
ABCD	29	25AB442RR	DUNGS RATIO REGULATOR 1.5" 226-462	
AB	30	53A043G	EL90 3/8X1/4COMP.AND#69A-6B	
AB	31	5SB0K0EBEO	NPTHEXBUSH 1/2X1/4 BRASS 125#	
AB	32	5SCC0EBE	NPT COUP 1/4 BRASS 150#PSI W/HEX	
AB	33	53A005B	BODYMALCON1/4X1/8COMP #B68A-4A	
AB	34	5NOC03ABE2	NPT NIP 1/8X3 TBE BRASS STD	
AB	35	51V010A	TEE 1/8"BRSEXTR BLOCTYP#2203P2	
AB	36	53A031B	BODY-EL90MALE.25X1/8 #269C-42B	
AB	37	87Z00EX035	TUBE=1/4"ODX.035WL 316LSS*20RM	
AB	38	53A031XB	BODY-EL90MALE.25X25 #269C-4-4B	
EF	40	5N1K06AF42	NPT NIP 1.5X6 TBE BLKSTL SK40	
EF	41	5SB2A1KCEO	NPTHEXBUSH 2X1.5 BLKCI 125#	
EF	42	30F600F	2" THREADED FLANGE, 150# FF CARBON STEEL A105	
EF	43	30F600G	2" 1/16" FULL FACE GASKET, 150# NON-ASBESTOS	
EF	44	30F600	AMERICAN METER 3.5M RABO ROTARY METER	
EF	45	07 71897	6458GAS METER SUPPORT BRKT	

Gas Piping - Ratio Air

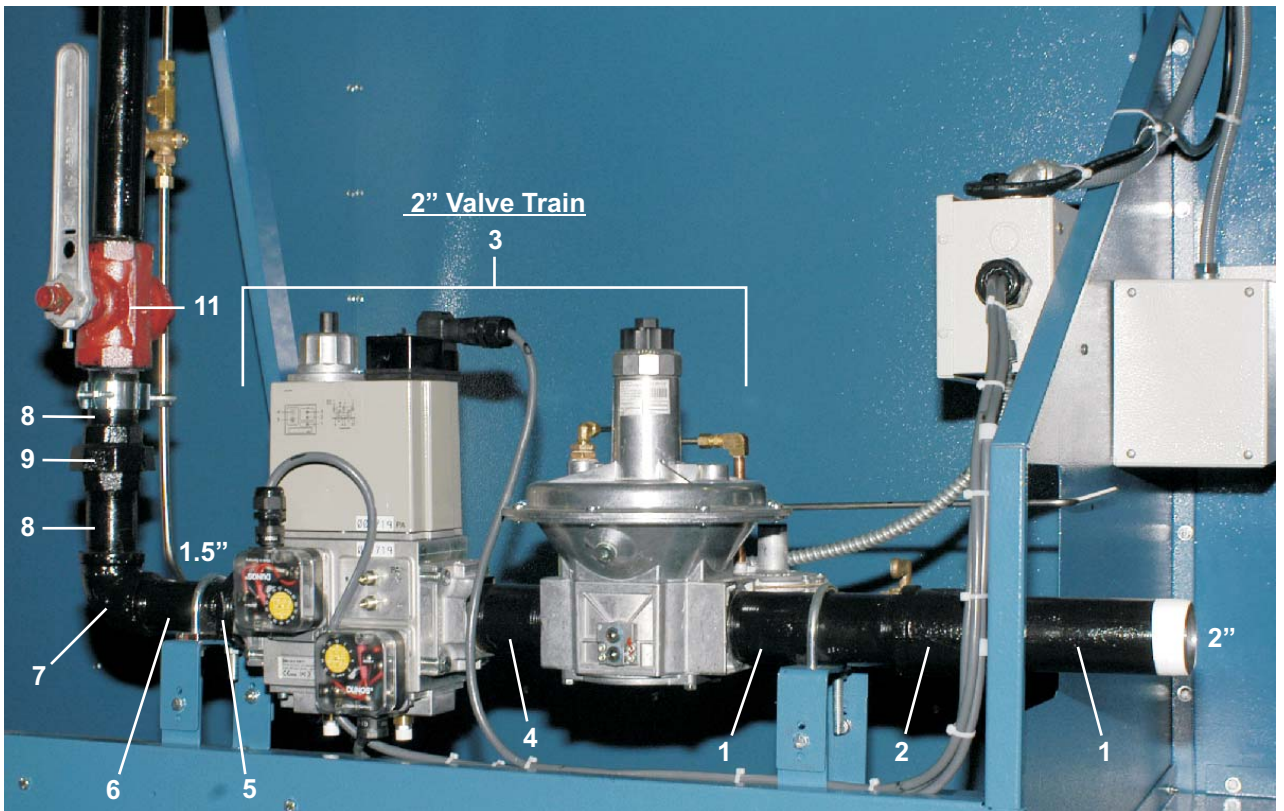
7676TG1L, TG1R



Detail A:

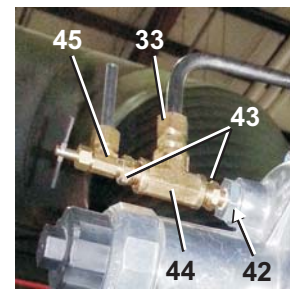
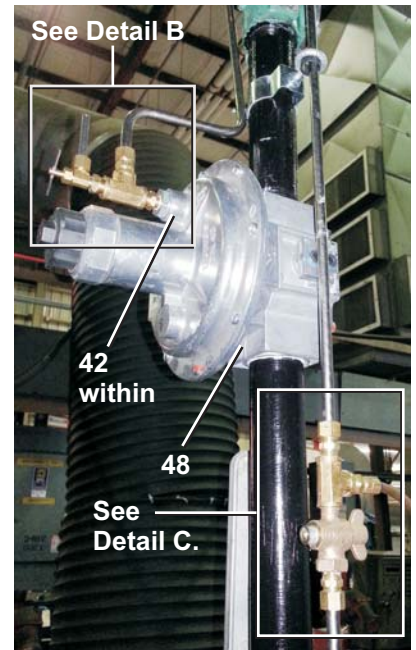
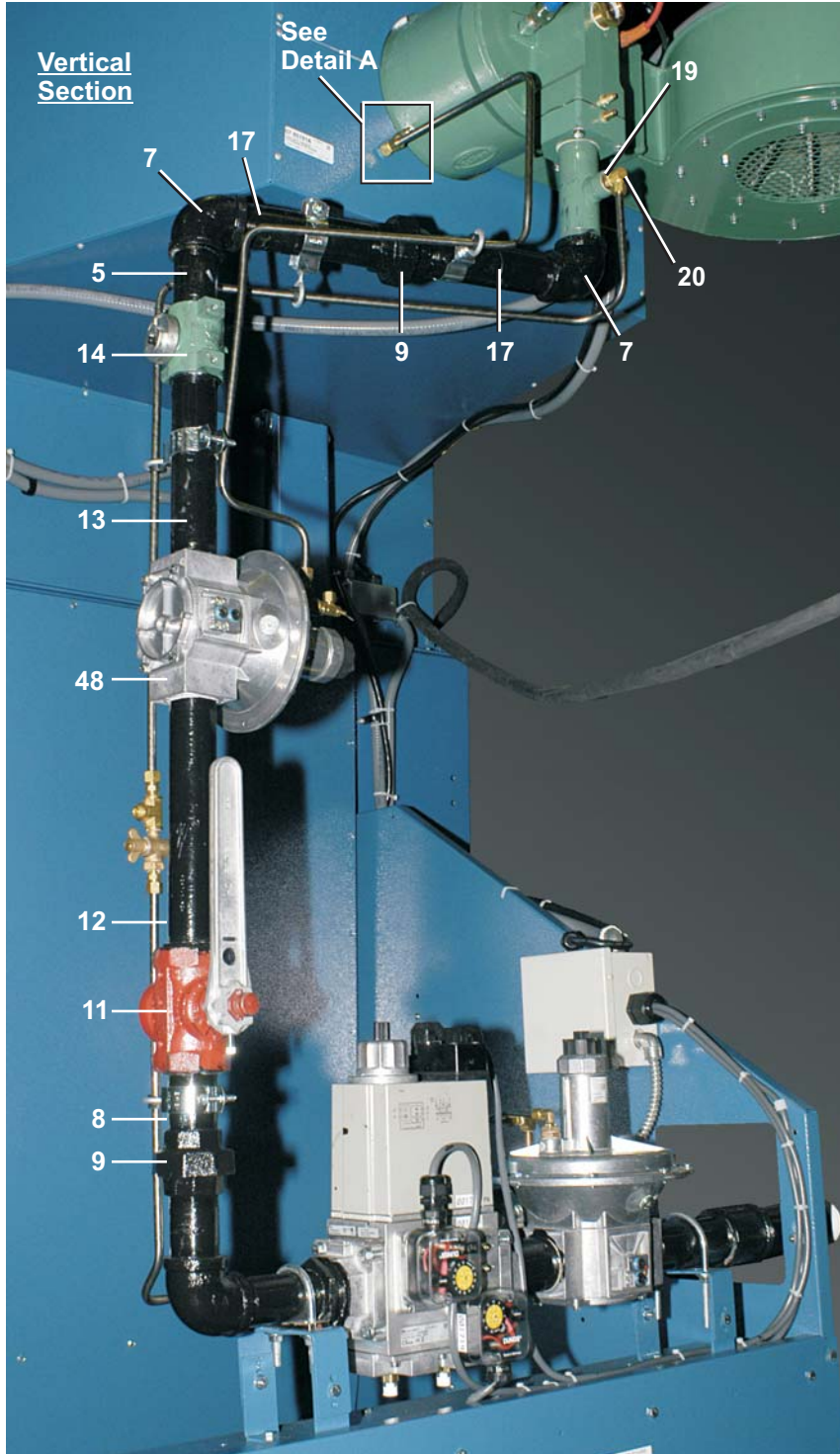


Burner and Combustion Blower Unit

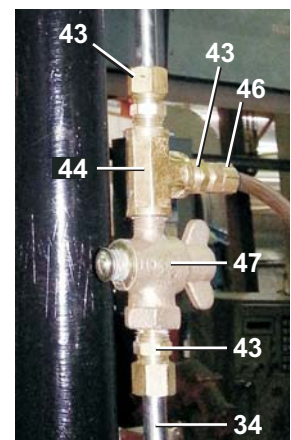


Gas Piping - Ratio Air

7676TG1L, TG1R



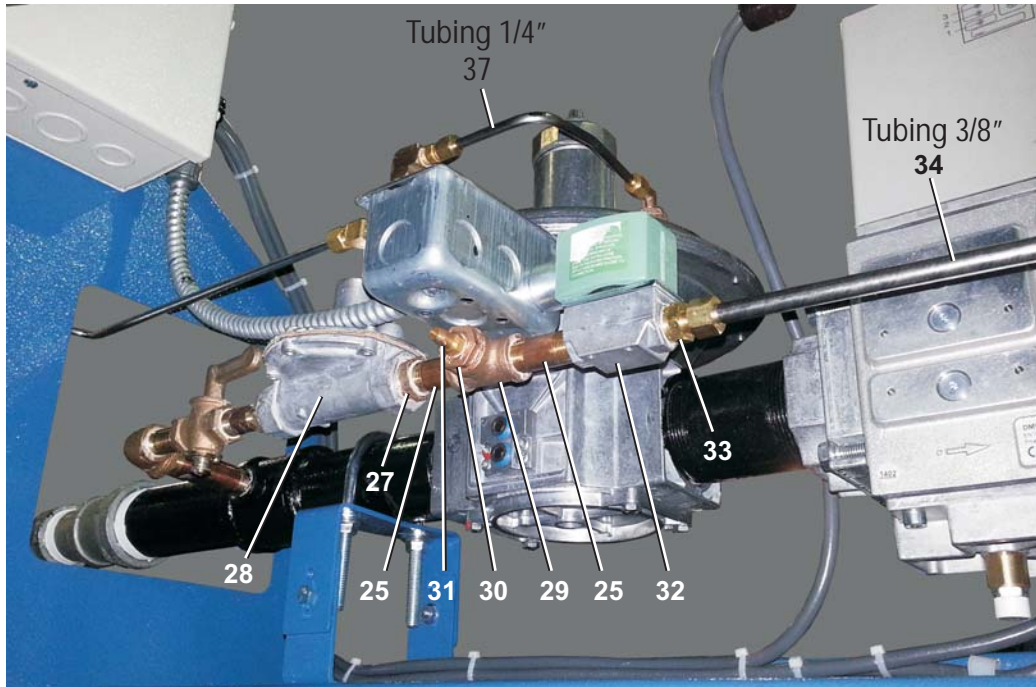
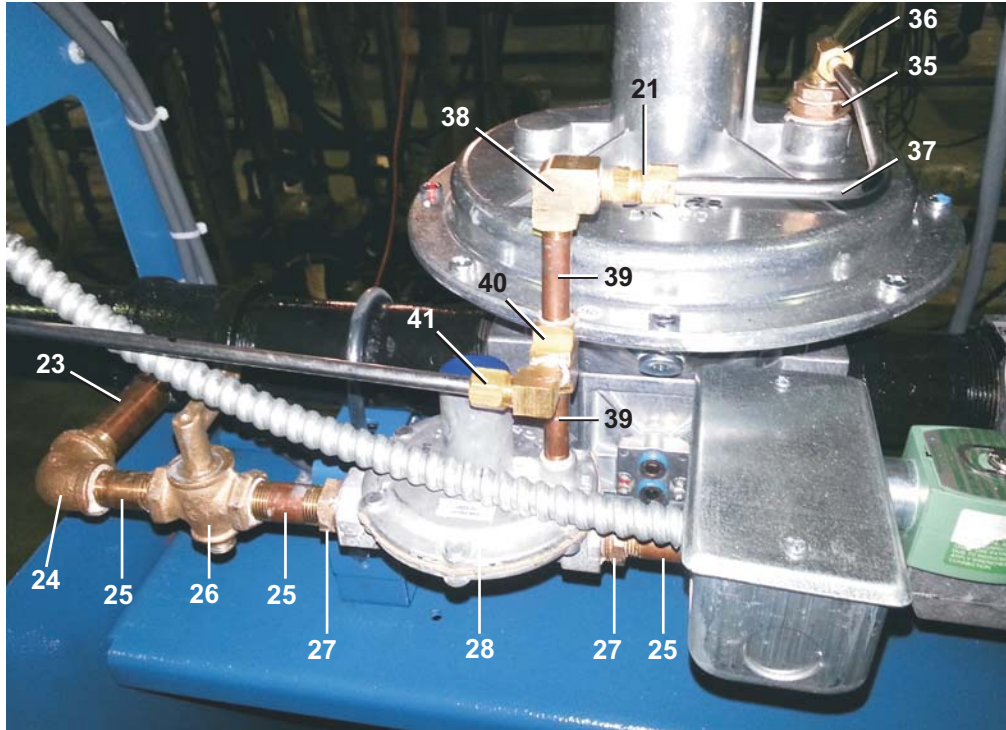
Detail B:



Detail C:

Gas Piping - Ratio Air

7676TG1L, TG1R



Gas Piping - Ratio Air

7676TG1L, TG1R

Parts List—Gas Piping - Ratio Air

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	A79VG062	7676 NAT 2V NOVENT=CSA LF	7676TG1L
	B	A79VG062A	7676 NAT 2V NOVENT=CSA RT	7676TG1R
	C	A79VG031	7676 GAS TRAIN ENTRY SECTION	
	D	A79VG034	7676 2V NOVENT-CSA BLW LEFT	
	E	A79VG034A	7676 2V NOVENT-CSA BLW RITE	
	F	A79VG035	7676 GAS TRN VER SECT=CSA	
	G	A79VG033	7676 PILOT GAS PIPE	
-----COMPONENTS-----				
All	1	5N2A07AB42	NPT NIP 2X7 TBE BLKSTL SK40	
all	2	5S2AMFA0K	NPT TEE 2X2X1/2 BLKMAL 150#	
A	3	A79VG022	THERMJET 2.0" VALTRAIN 3MILBTU LF TO RT UL795/CSA	
B	3	A79VG022A	THERMJET 2.0" VALTRAIN 3MILBTU RT TO LF UL795/CSA	
all	4	5N2A04AB42	NPT NIP 2X4 TBE BLKSTL SK40	
all	5	5SB2A1KCEO	NPTHEXBUSH 2X1.5 BLKCI 125#	
all	6	5N1K05AF42	NPT NIP 1.5X5 TBE BLKSTL SK40	
all	7	5SL1KMFA	NPT ELB 90DEG 1.5 BLKMAL 150#	
all	8	5N1K03KF42	NPT NIP 1.5X3.5 TBE BLKSTL S40	
all	9	5SU1KMF	NPT UNION 1.5" BLKMAL 150#	
all	11	96G150C	1.5"GAS STOP VAL - SMG SERIES 400	
all	12	5N1K11PF42	NPT NIP 1.5X11.75 TBE BLKSTLS40	
all	13	5N1K09AF42	NPT NIP 1.5X9 TBE BLKSTL SK40	
all	14	25AB442BV1	BUTTERFLY VALVE 1.5" 501218 FULL PORT	
all	17	5N1K07KF42	NPT NIP 1.5X7.5 TBE BLKSTL SK40	
all	18	25AB442BL	RATIO AIR 3MIL/COMB BLOWER	
all	19	5SB0K0EBEO	NPTHEXBUSH 1/2X1/4 BRASS 125#	
all	20	53A043G	EL90 3/8X1/4COMP.AND#69A-6B	
all	21	53A005B	BODYMALCON1/4X1/8COMP #B68A-4A	
all	22	5SCC0EBE	NPT COUP 1/4 BRASS 125# W/HEX	
all	23	5N0K03KB42	NPT NIP 1/2X3.5 TBE BRASS STD	
all	24	5SL0KBEA0G	NPT ELB 90DEG 1/2X3/8 BRASS 125	
all	25	5N0G02ABE2	NPT NIP 3/8X2 TBE BRASS STD	
all	26	96G030	3/8GAS STOP VAL W/CKLEVER HDL	
all	27	5SR0K0GBE	NPT RED 1/2X3/8 BRASS 125#	
all	28	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C	
all	29	5S0GBEA	NPT TEE 3/8" BRASS 125#	
all	30	5SB0G0EBEO	NPTHEXBUSH 3/8X1/4 BRASS 125#	
all	31	96G0001	GAS TEST PORT ECLIPSE 13445	

Gas Piping - Ratio Air

7676TG1L, TG1R

Parts List—Gas Piping - Ratio Air

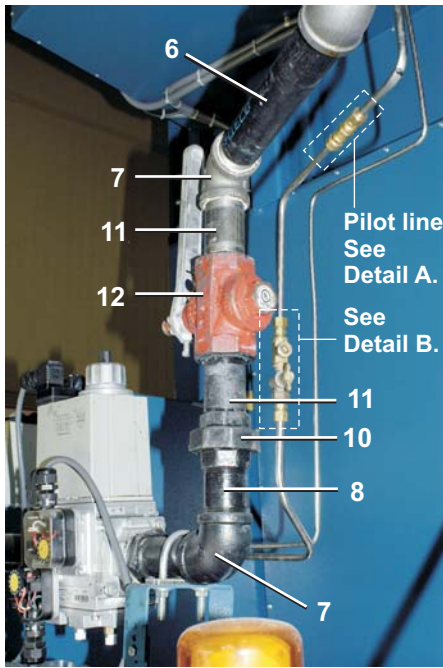
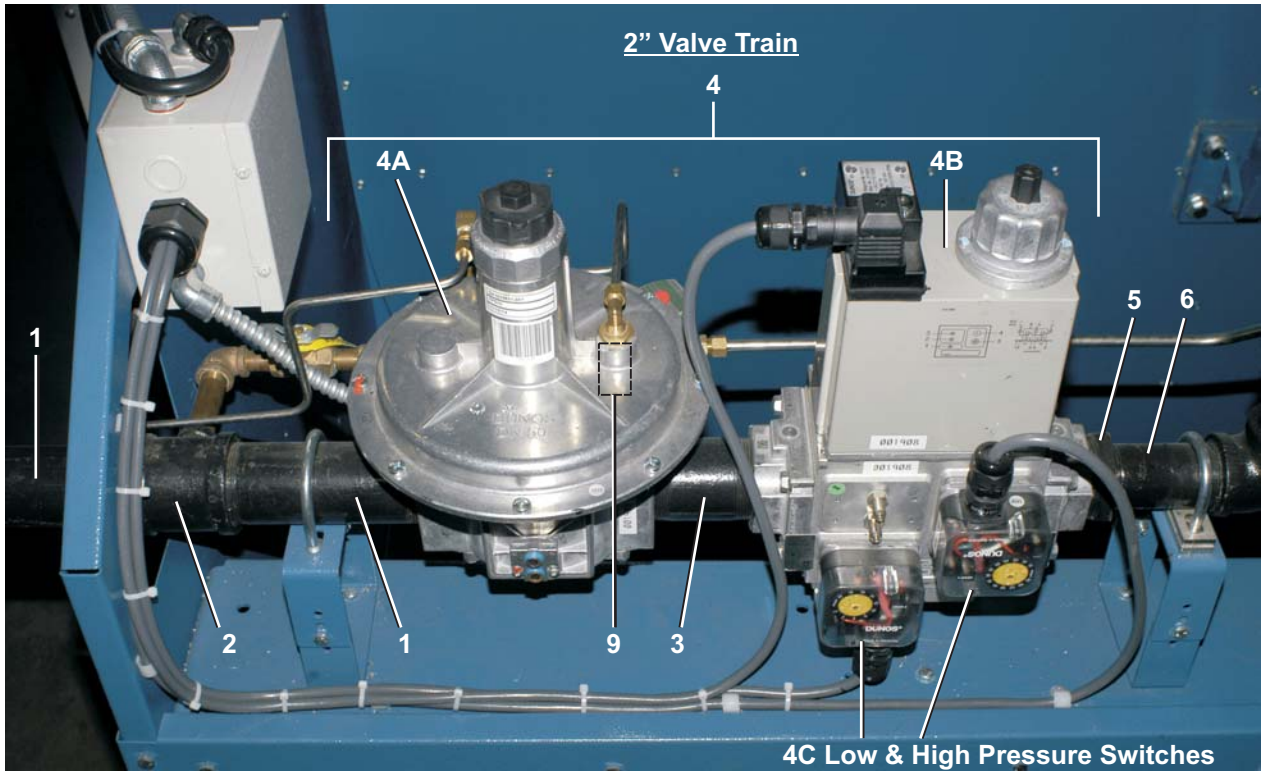
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
all	32	96TCC2BA37	3/8" N/C 2WAY 120V50/60C VALVE	
all	33	53A026	BODYMALECON3/8X3/8 #68C-6-6B	
all	34	87Z010	TUBE 3/8"ODX.035" SS304 *20RM	
all	35	5SB0K0GBEO	NPTHEXBUSH 1/2X3/8 BRASS 125#	
all	36	5SLOGBEA0E	NPTELB 90DEG 3/8X1/4 BRASS 125	
all	37	87Z00EX035	TUBE=1/4"ODX.035WL 316LSS*20RM	
all	38	5SLOCBEA	NPTELB 90DEG 1/8 BRASS 125#	
all	39	5N0C02ABE2	NPT NIP 1/8X2 TBE BRASS STD	
all	40	51V010A	TEE 1/8"BRSEXTR BLOCTYP#2203P2	
all	41	53A031B	BODY-EL90MALE.25X1/8 #269C-42B	
all	42	51T311	FLAMEARREST VNTSCREEN.375BRASS	
all	43	53A023	MALECON3/8X.25COMP ANCHR#68-64	
all	44	51V015	TEE 1/4 FGDBRASS 101T7-444	
all	45	96H018	ANGLE NEEDLE VLV 1/4" T X 1/8MP	
all	46	51P013	PLUG HXCNTRSUNK 1/4"BRASS	
all	47	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL	
All	48	25AB442RR	ECLIPSE RATIO REGULATOR 1.5" 226-462(FRG715/6)	

Gas Piping - Ratio Air

82082TG1L, TG1R

Figure 1: Gas Valve Train



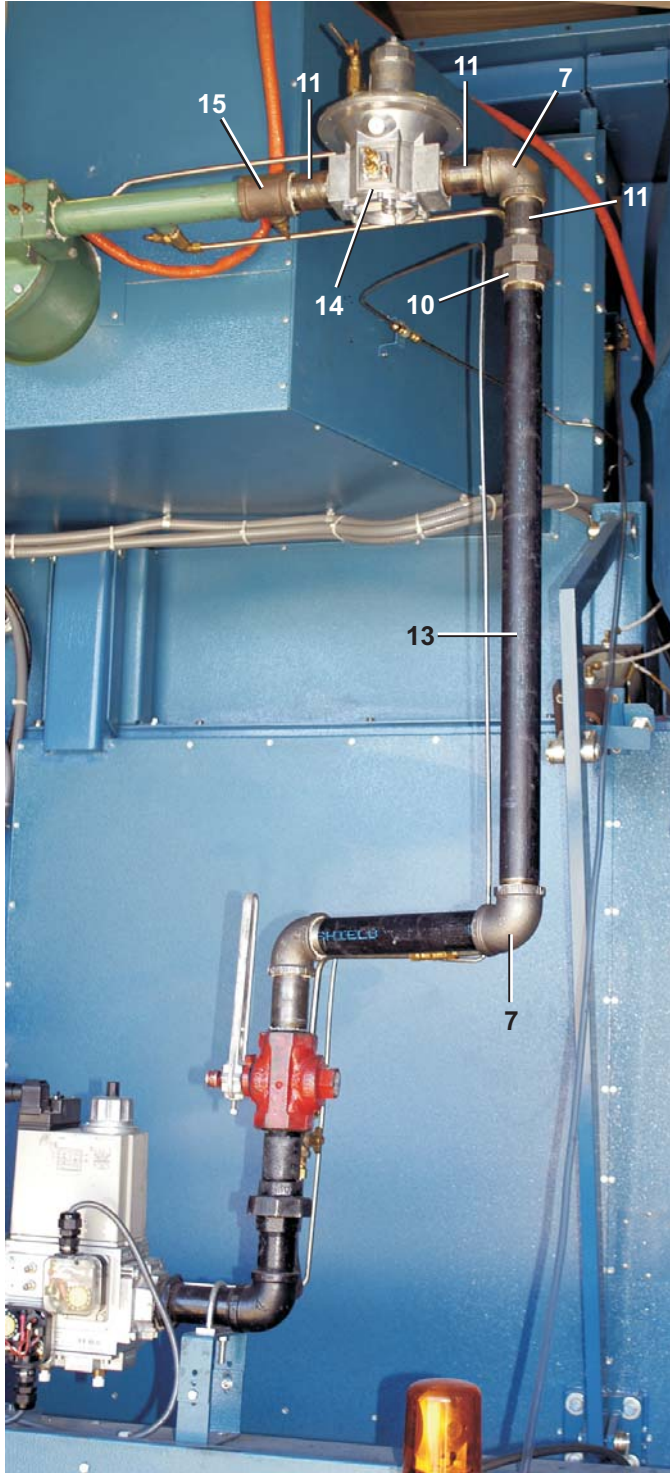
1.5" Gas Line



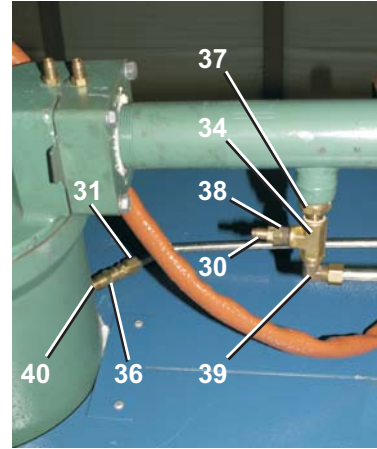
Gas Piping - Ratio Air

82082TG1L, TG1R

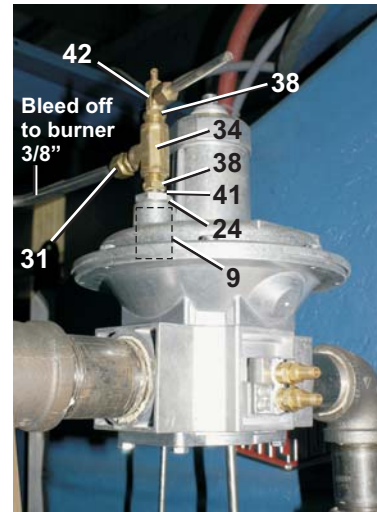
Figure 2: Main Gas to Burner



1.5" Gas Line



Pilot line to burner



Bleed off to firebox

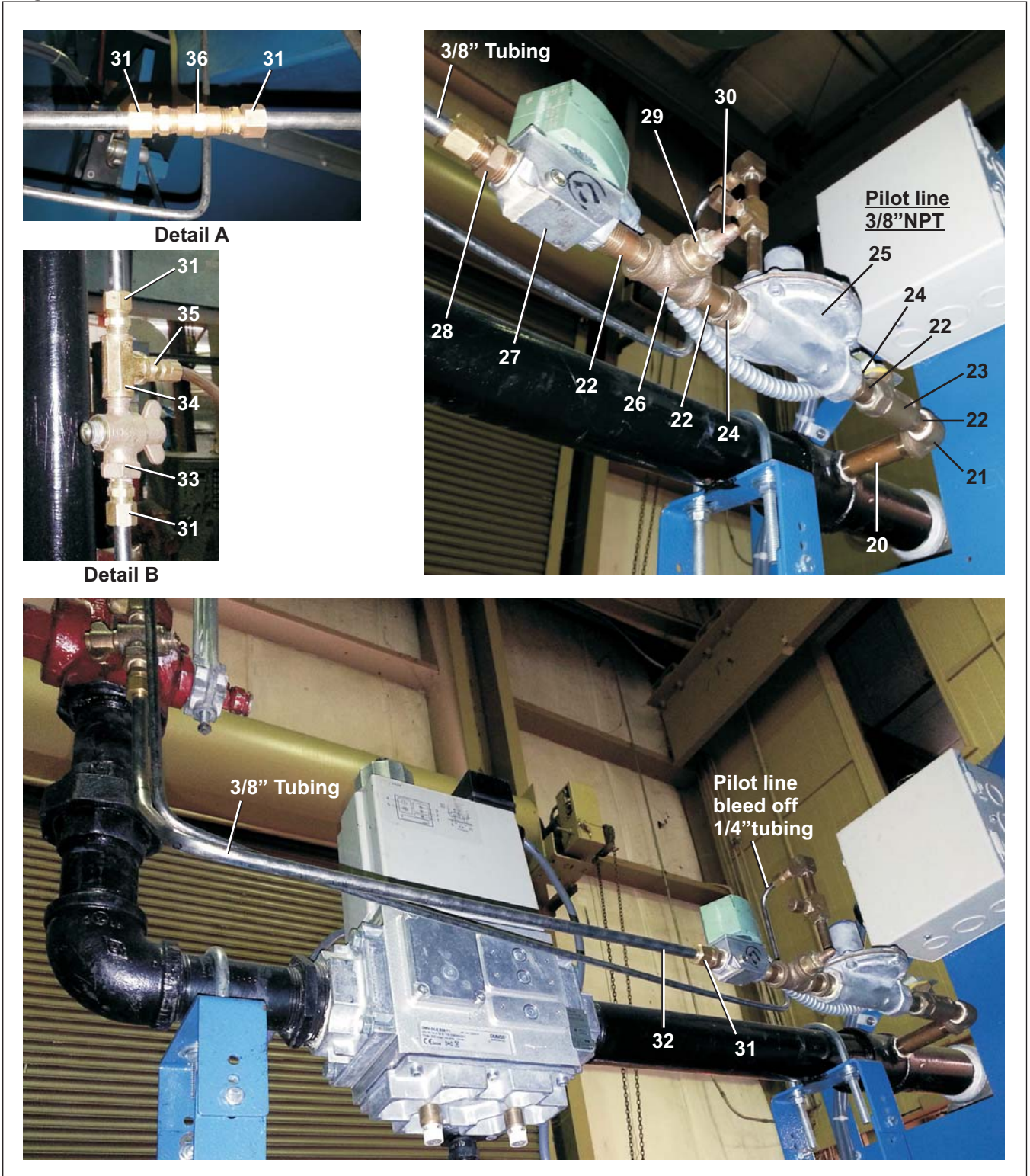


Bleed off to rear fire box

Gas Piping - Ratio Air

82082TG1L, TG1R

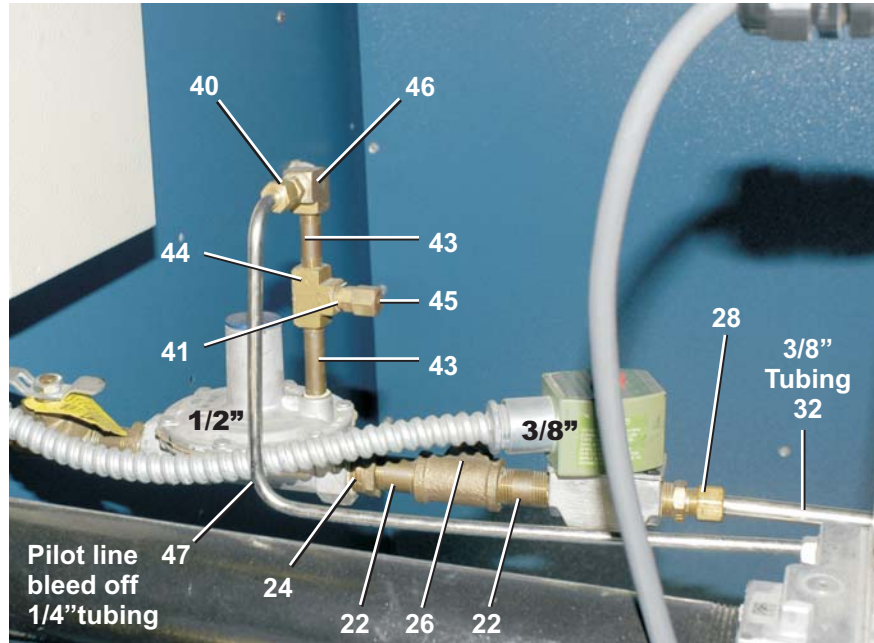
Figure 3: Pilot Line



Gas Piping - Ratio Air

82082TG1L, TG1R

Figure 4: Pilot Line



Parts List—Gas Piping

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	A82VG001	8282 NAT 2V NOVENT=CSA LF	REFERENCE
	B	A82VG012	8282 2V NOVENT-CSA BLW LEFT	REFERENCE
	C	A82VG011	8282 GAS TRN VER SECT=CSA	REFERENCE
	D	A82VG010	8282 GAS TRN TOP HORIZ SECT=CSA	REFERENCE
	E	A79VG033	7676 PILOT GAS PIPE	REFERENCE
-----COMPONENTS-----				
all	1	5N2A07AB42	NPT NIP 2X7 TBE BLKSTL SK40	
all	2	5S2AMFA0K	NPT TEE 2X2X1/2 BLKMAL 150#	
all	3	5N2A02KB42	NPT NIP 2X2.5 TBE BLKSTL SK40	
all	4	A79VG022	THERMJET 2.0" VALTRAIN 3MILBTU LF TO RT UL795/CSA	
all	4	96SD032	2"NPT FRS 720/6 GAS REGULATOR	
all	4	96SD028	DMV-DLE 525/11 DUAL SHUTOFFVAL	
all	4	96SD015	GAO-A2-4-5 HI&LO GASPRESSWITCH	
all	5	5SB2A1KCEO	NPTHEXBUSH 2X1.5 BLKCI 125#	
all	6	5N1K09AF42	NPT NIP 1.5X9 TBE BLKSTL SK40	
all	7	5SL1KMFA	NPT ELB 90DEG 1.5 BLKMAL 150#	
all	8	5N1K05AF42	NPT NIP 1.5X5 TBE BLKSTL SK40	

Gas Piping - Ratio Air

82082TG1L, TG1R

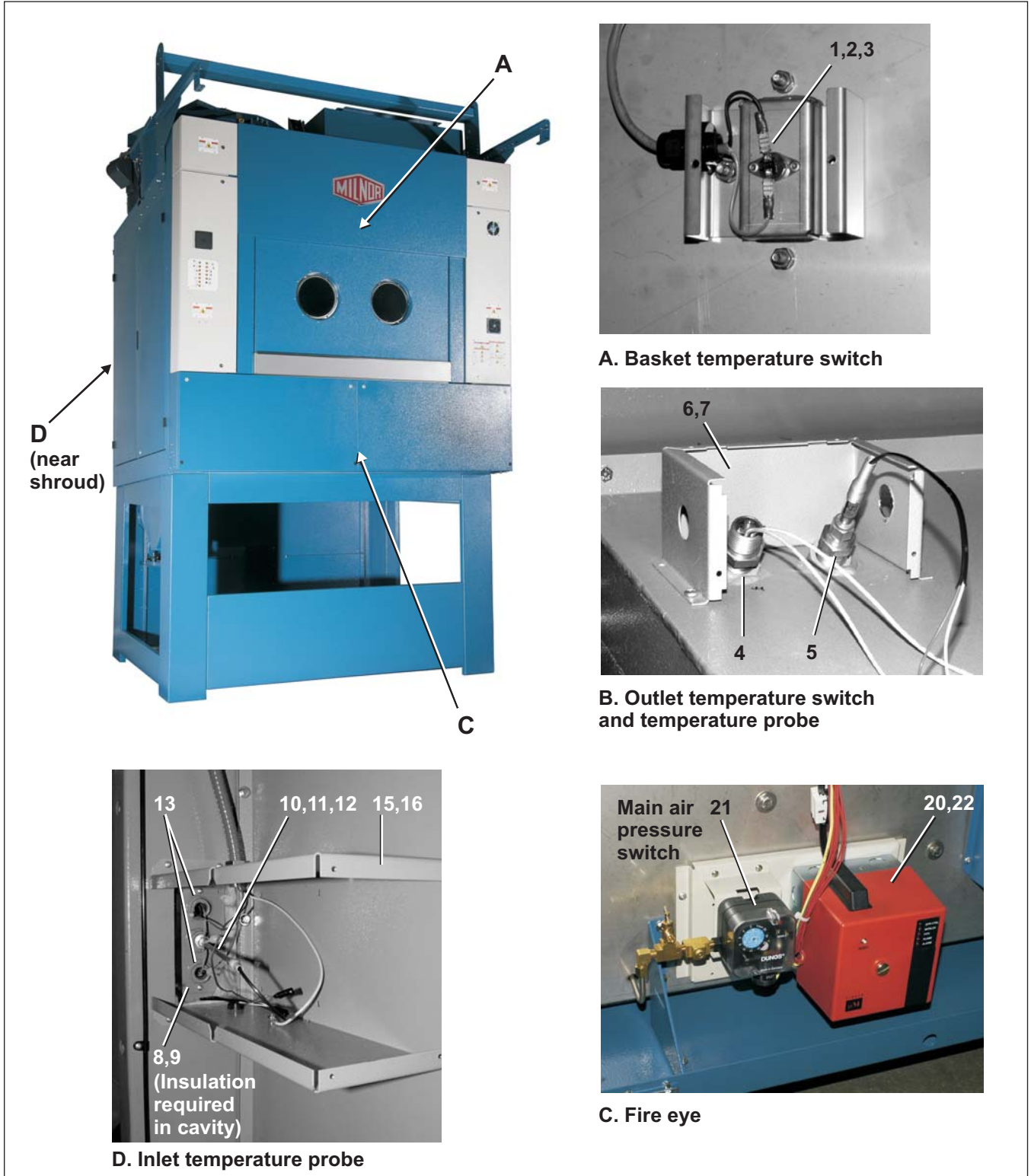
Parts List—Gas Piping

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
all	9	51T311	FLAMEARREST VNTSCREEN.375BRASS	
all	10	5SU1KMF	NPT UNION 1.5" BLKMAL 150#	
all	11	5N1K03KF42	NPT NIP 1.5X3.5 TBE BLKSTL S40	
all	12	96G150C	1.5"GAS STOP VAL - HOMESTEAD #611	
all	13	5N1K30AF42	NPT NIP 1.5X30 TBE BLKSTL SK40	
all	14	25AB442RR	ECLIPSE RATIO REGULATOR 1.5" 226-462(FRG715/6)	
all	15	25AB442BV1	BUTTERFLY VALVE 1.5" 501218 FULL PORT	
all	20	5N0K03ABE2	NPT NIP 1/2X3 TBE BRASS STD	
all	21	5SL0KBEA0G	NPT ELB 90DEG 1/2X3/8 BRASS 125	
all	22	5N0G01KBE2	3/8" X 1.5"BRASSNIPPLE TBE	
all	23	96G030	3/8"GAS BALL VLV/ T- HANDLE-CON	
all	24	5SR0K0GBE	NPT RED 1/2X3/8 BRASS 125#	
all	25	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C	
all	26	5S0GBEA	NPT TEE 3/8" BRASS 125#	
all	27	96TCC2BA37	3/8" N/C 2WAY 120V50/60C VALVE	
all	28	53A026	BODYMALECON3/8X3/8 #68C-6-6B	
all	29	5SB0G0EBEO	NPTHEXBUSH 3/8X1/4 BRASS 125#	
all	30	96G0001	GAS TEST PORT ECLIPSE 13445	
all	31	53A023	MALECON3/8X.25COMP	
all	32	87Z010	TUBE 3/8"ODX.035" SS304 *20RM	
all	33	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL # 55-302-01	
all	34	51V015	TEE 1/4 FGDBRASS 101T7-444	
all	35	51P013	PLUG HXCNTRSUNK 1/4"BRASS	
all	36	5SCC0EBE	NPT COUP 1/4 BRASS 150#PSI W/HEX	
all	37	5SB0K0EBEO	NPTHEXBUSH 1/2X1/4 BRASS 125#	
all	38	5SB0E0CBEO	NPTHEXBUSH 1/4X1/8 BRASS 125#	
all	39	53A043G	EL90 3/8X1/4COMP.AND#69A-6B	
all	40	53A005B	BODYMALCON1/4X1/8COMP #B68A-4A	
all	41	5N0CCLSB42	NPT NIP 1/8XCLS TBE BRASS STD	
all	42	96H018	ANGLE NEEDLE VLV 1/4"T X 1/8MP,	
all	43	5N0C03ABE2	NPT NIP 1/8X3 TBE BRASS STD	
all	44	51V010A	TEE 1/8"BRSEXTR BLOCTYP#2203P2	
all	45	53A007E	COMP.CAP 1/4"OD AND#N5-CT-4	
all	46	5SL0CBEA	NPT ELB 90DEG 1/8 BRASS 125#	
all	47	87Z00EX035	TUBE=1/4"ODX.035WL 316LSS*20RM	

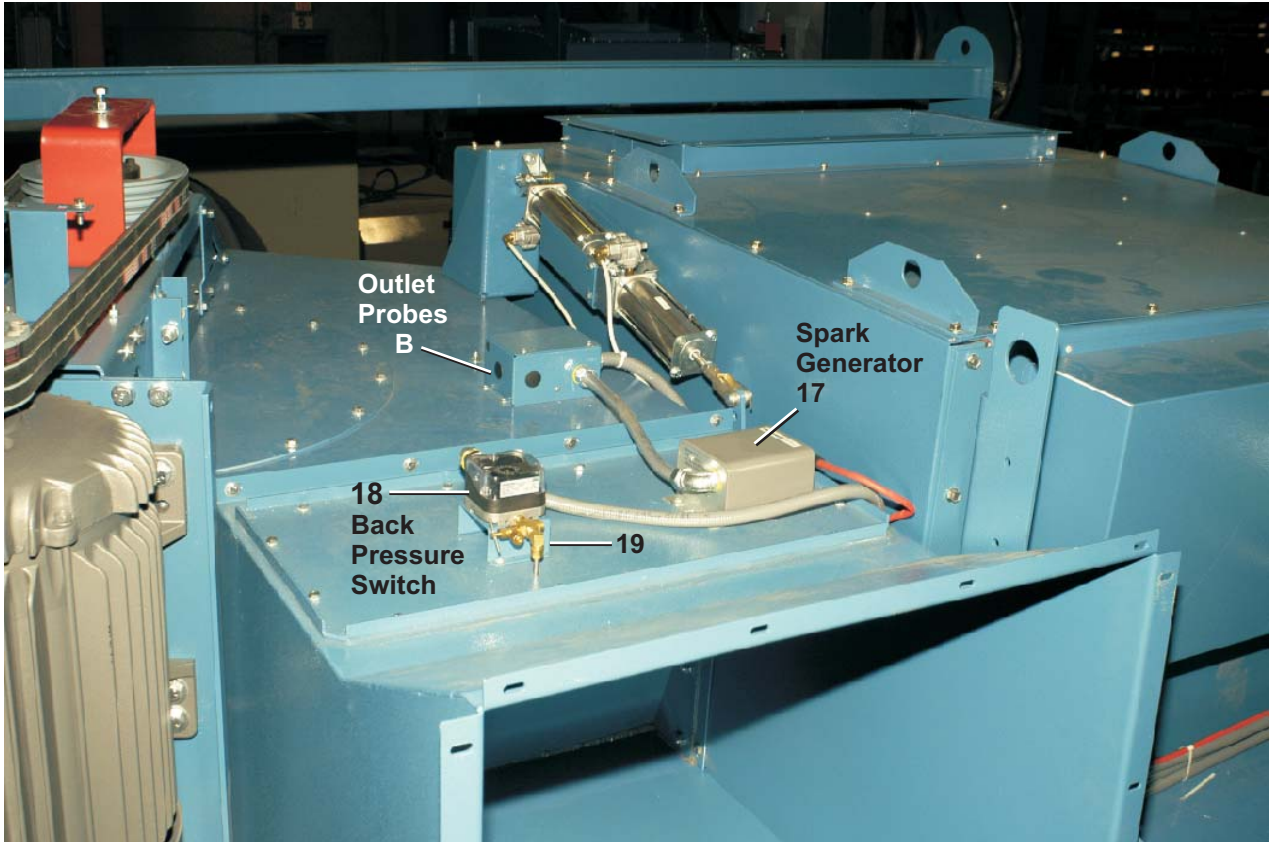
Temperature Sensors - Ratio Air

6458TG1L/R 6464TG1L/R 7676TG1L/R 8282TG1L/R

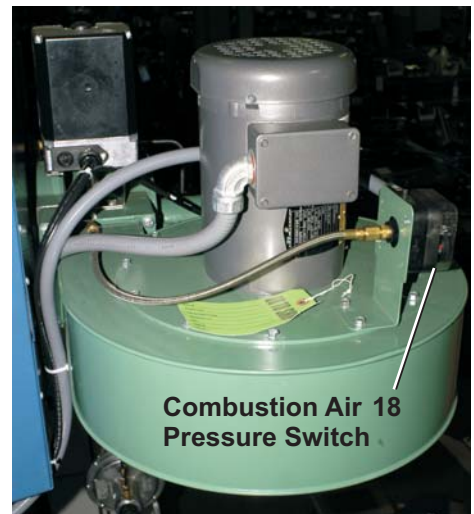


Temperature Sensors - Ratio Air

6458TG1L/R 6464TG1L/R 7676TG1L/R 8282TG1L/R

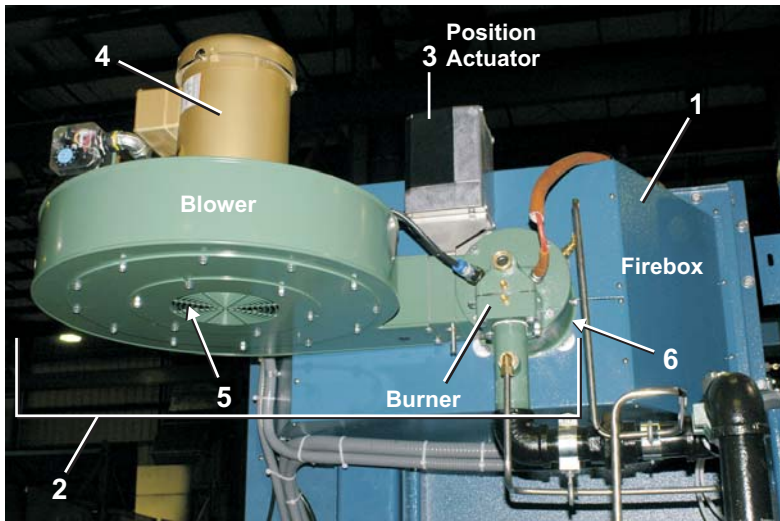


Ratio Air Burner



Firebox & Burner - Ratio Air

6458TG1L/R, 6446TG1L/R, 7676TG1L/R, 8282TG1L/R



Parts List—Firebox & Burner

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
	A B C D		-----REFERENCE-----	6458TG1L/R 6464TG1L/R 7676TG1L/R 8282TG1L/R
			-----COMPONENTS-----	
AB	1	A77FB005	6464 LEFT FIREBOX ASSY RA200	
AB	1	A77FB005A	6464 RITE FIREBOX ASSY RA200	
C	1	A79FB022	7676 LEFT FIREBOX ASSY	
C	1	A79FB022A	7676 RITE FIREBOX ASSY	
D	1	A82FB001	8282 LEFT FIREBOX ASSY	
D	1	A82FB001A	8282 RIGHT FIREBOX ASSY	
AB	2	25AB343BL	RATIO AIR 2MIL/COMB BLOWER	BURNER ASSEMBLY
AB	2	25AB343BR	RATIO AIR 2MIL/COMB BLOWER	BURNER ASSEMBLY
CD	2	25AB442BL	RATIO AIR 3MIL/COMB BLOWER	BURNER ASSEMBLY
CD	2	25AB442BR	RATIO AIR 3MIL/COMB BLOWER	BURNER ASSEMBLY
ABCD	3L	25AB442PBL	AIR POSITION ACTUATOR LEFT 12 SECOND	LEFT
ABCD	3R	25AB442PBR	AIR POSITION ACTUATOR RIGHT 12 SECOND	RIGHT
AB	4	25AB343CM	COMBUSTION MOTOR # 20548 FOR 25AB343BR/L	
CD	4	25AB442CM	COMBUSTION MOTOR THERMJET 3 MIL BURNER	
CD	5	25AB442B	BLOWER WHEEL FOR 442 BURNER FAN 22509	
AB	6	25AB343GA	BURNER GASKET Ra0200	

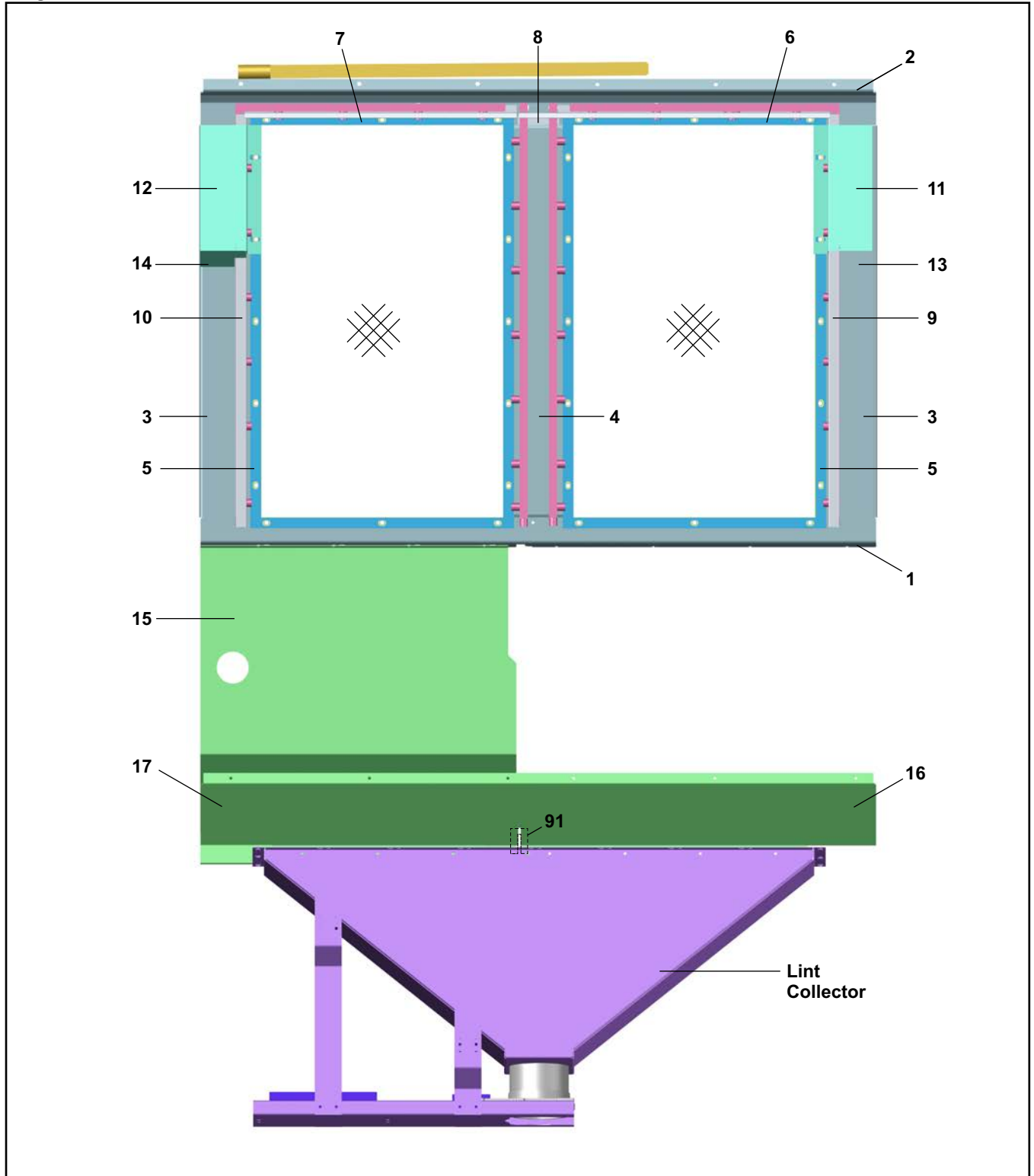
Pneumatics

6

Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

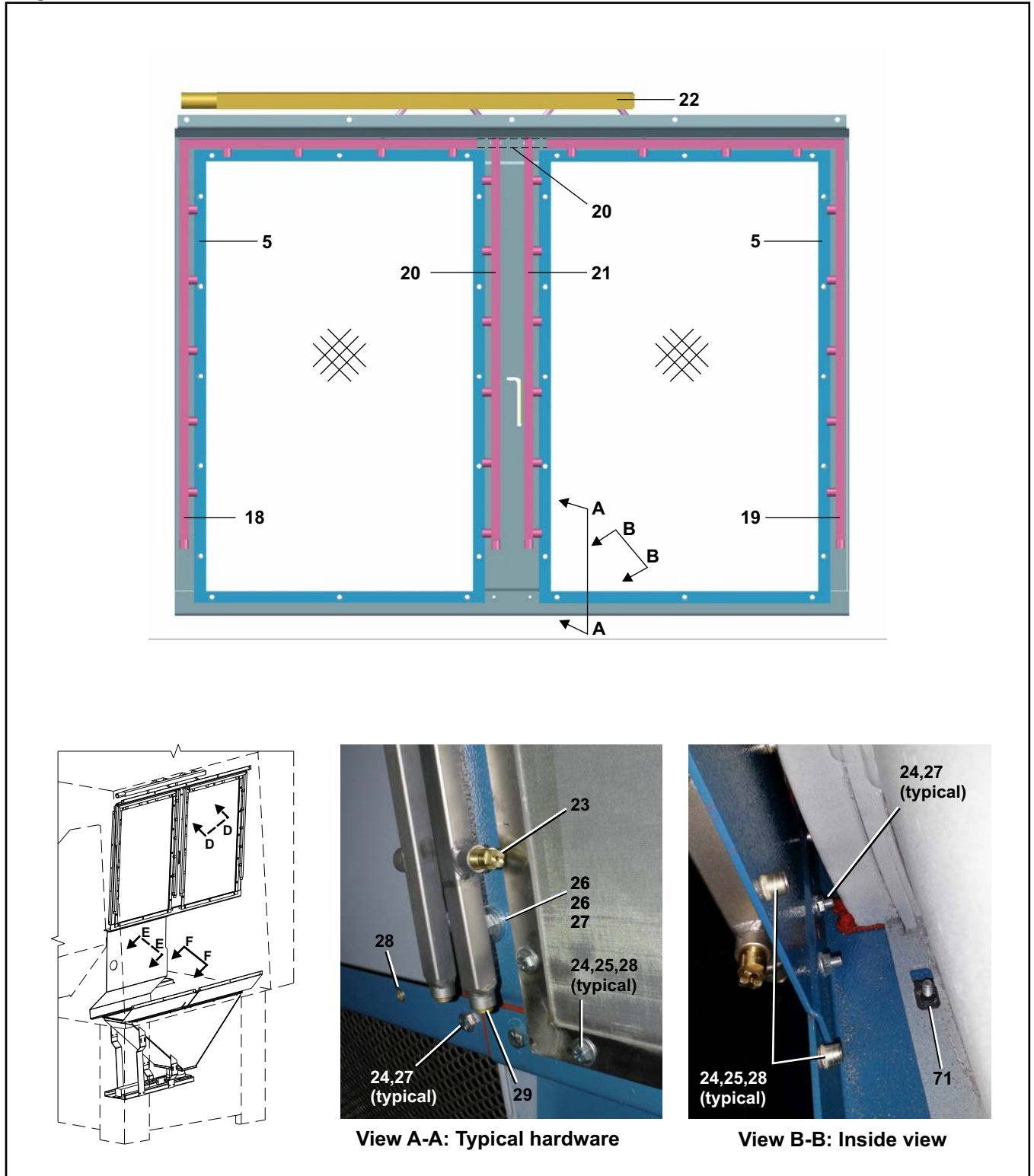
Figure 1: Installation Lint Screens



Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

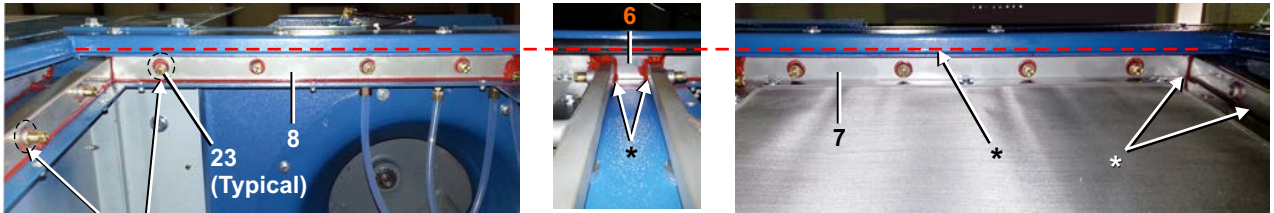
Figure 2: Air Nozzles, Hardware




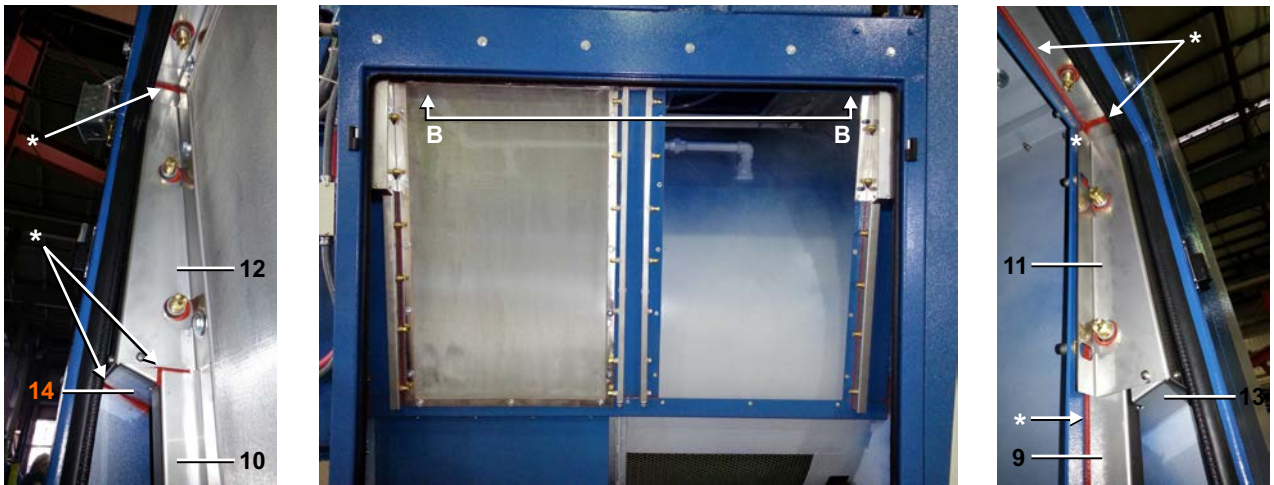
Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

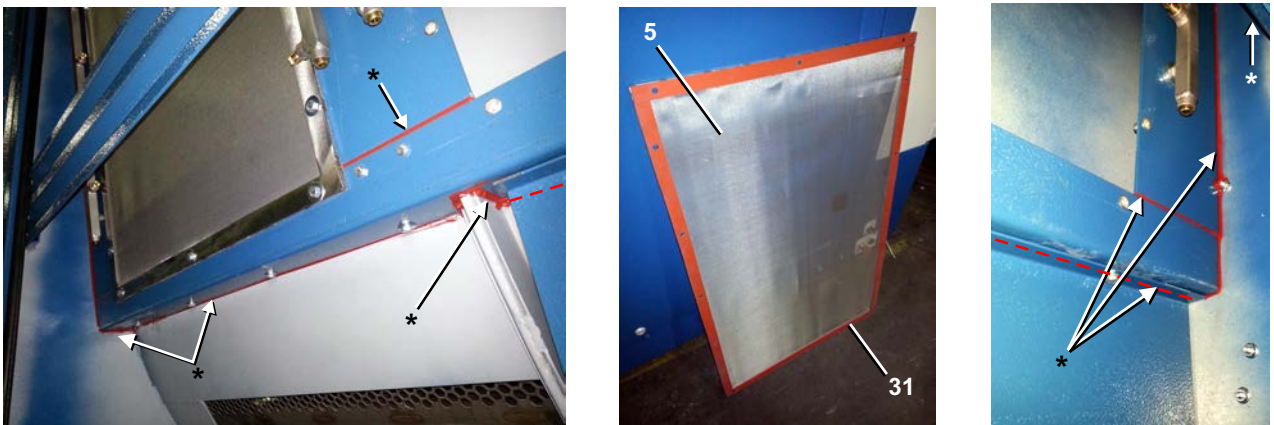
Figure 3: Silicone Sealing



 * Silicone washers (item 32) within. Adhered to manifold with silicone (item 33). (Typical 20 places)



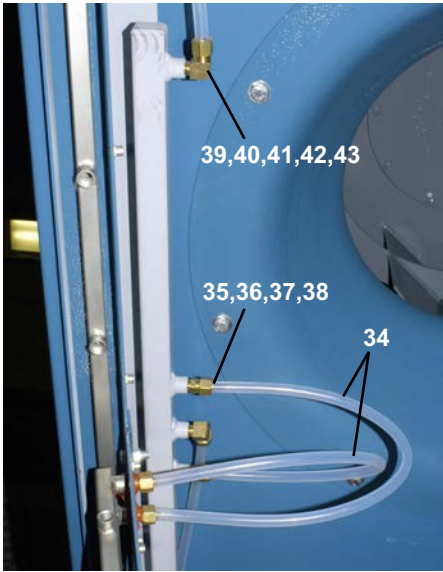
* Completely seal all seams And gaps with silicone (item 33) as shown.



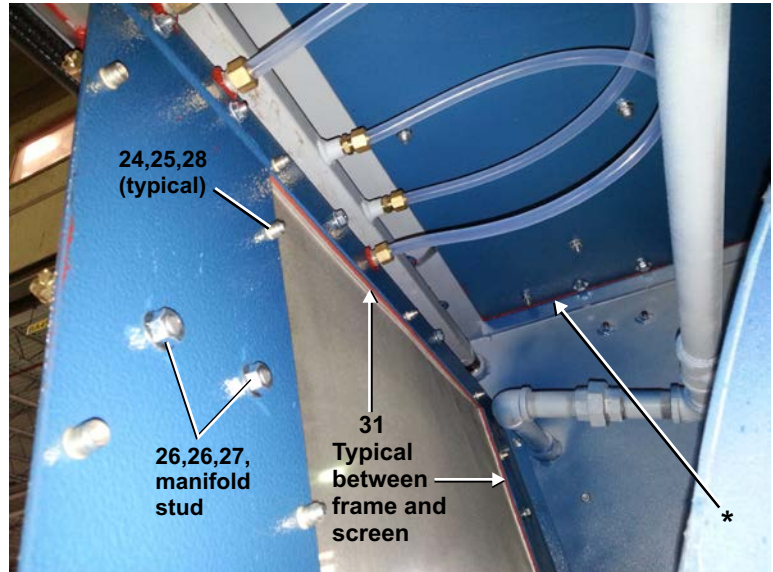
Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

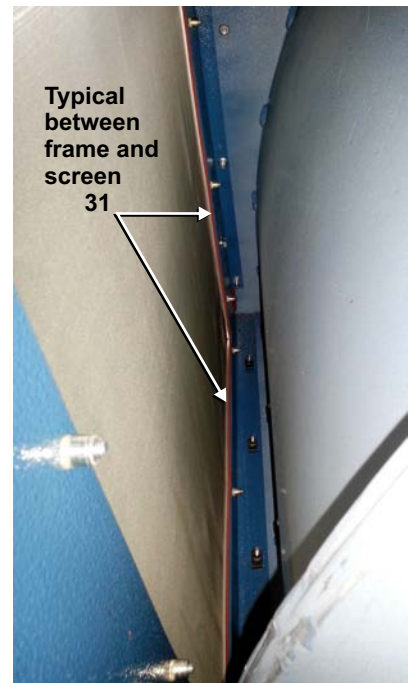
Figure 4: Lint Screens, Air Nozzles, Silicone Sealing



View D-D: Upper nozzle manifold (7676 Dryer shown)



View D-D: Inside view of upper nozzle and screen



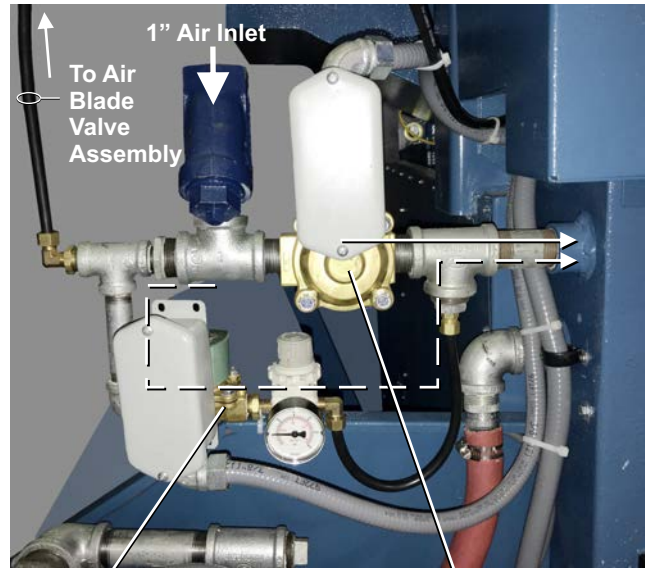
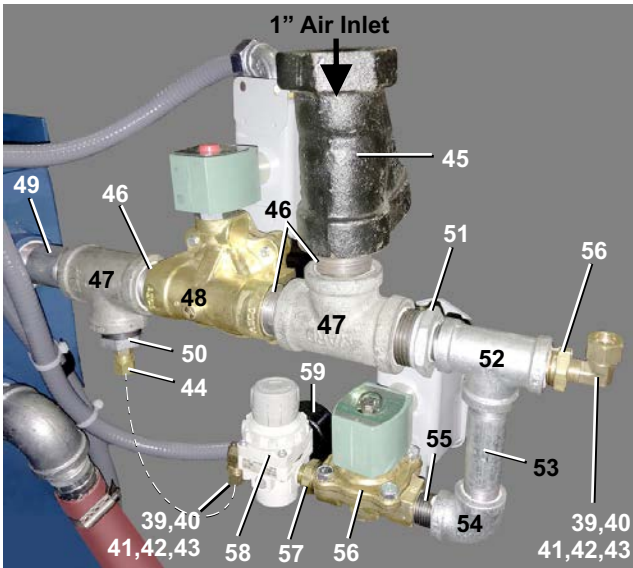
View E-E: Inside view bottom of screen

Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

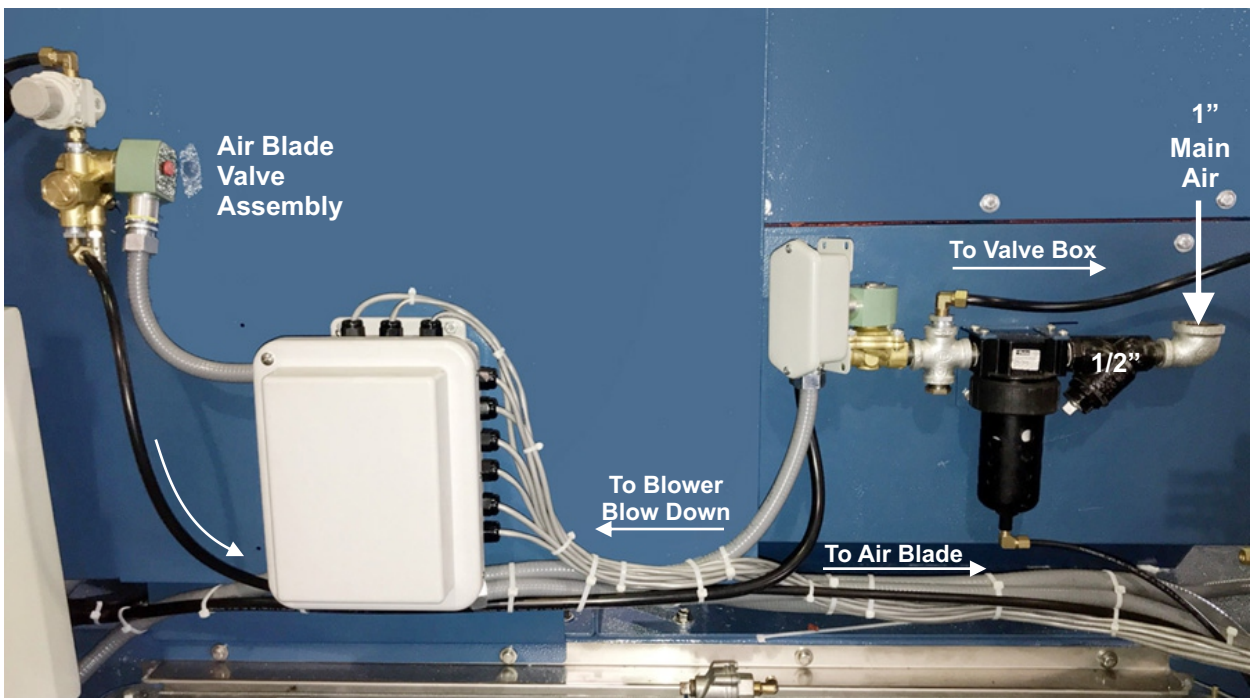
Figure 5: Internal Lint Air Inlet and Valves

Internal Lint Air Inlet



Nozzle Cleaning: low pressure air to the nozzles

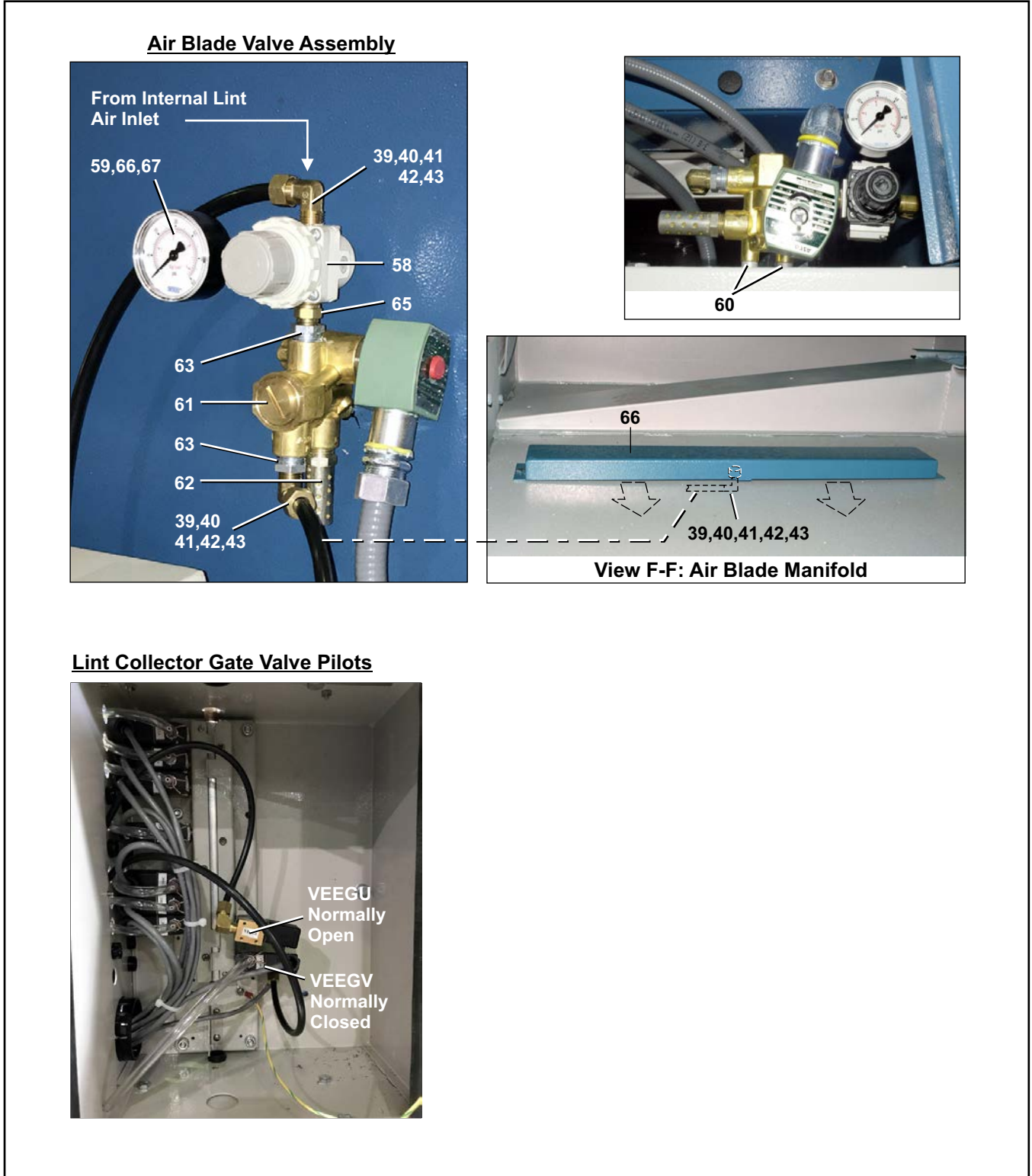
Screen Cleaning: high pressure air to the blow off the screens



Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

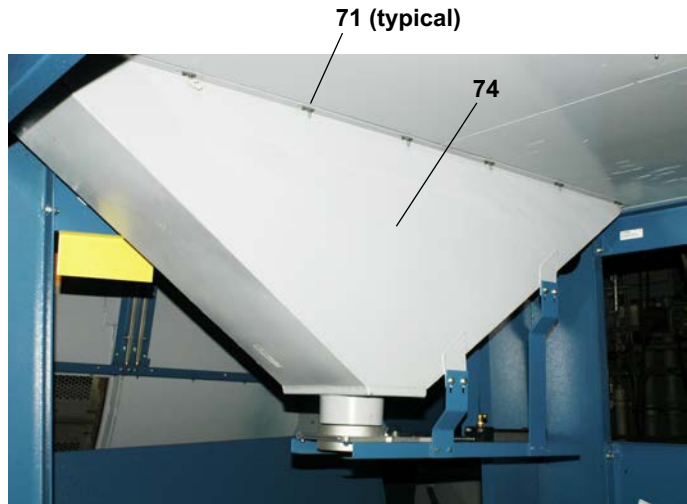
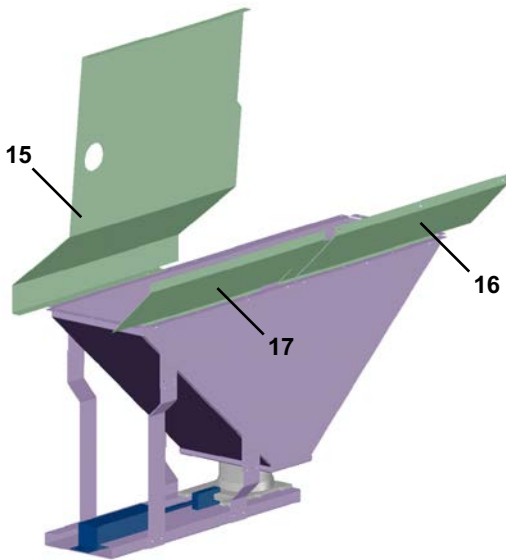
Figure 5: Air Blade Valve Assembly and Lint Collector Pilots



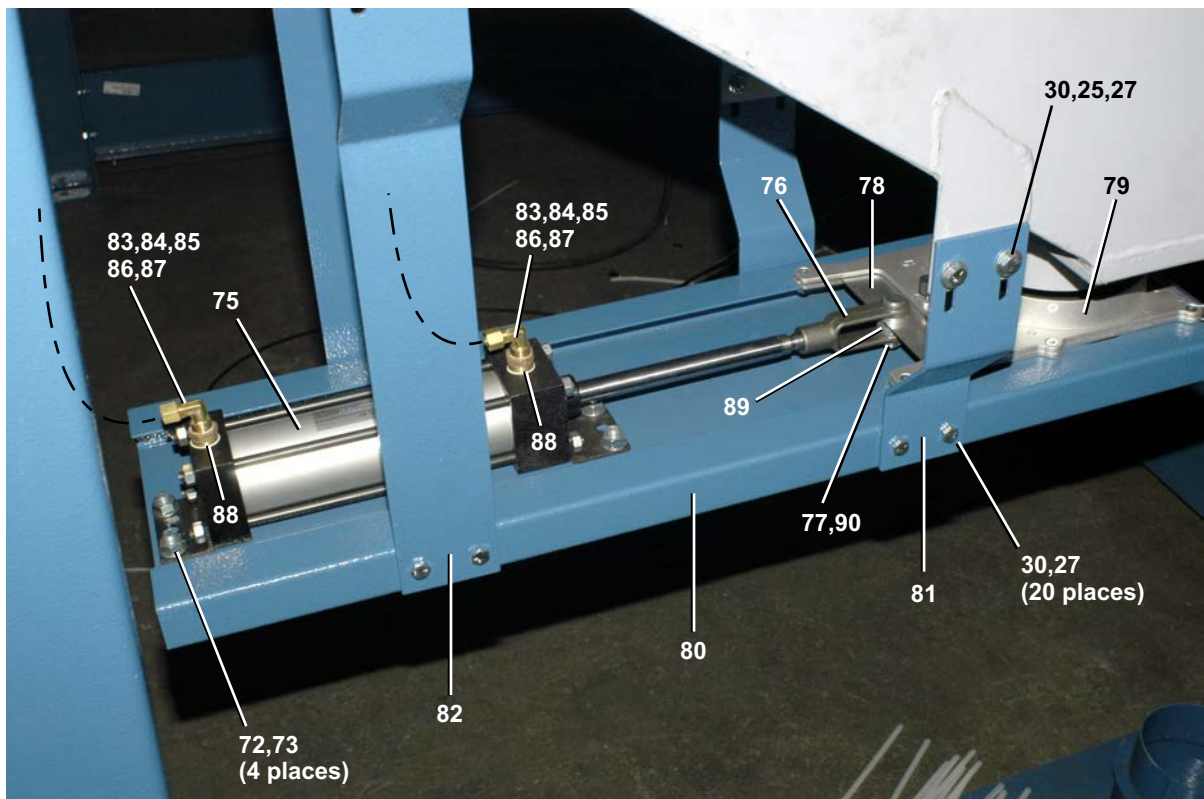
Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

Figure 6: Lint Collector



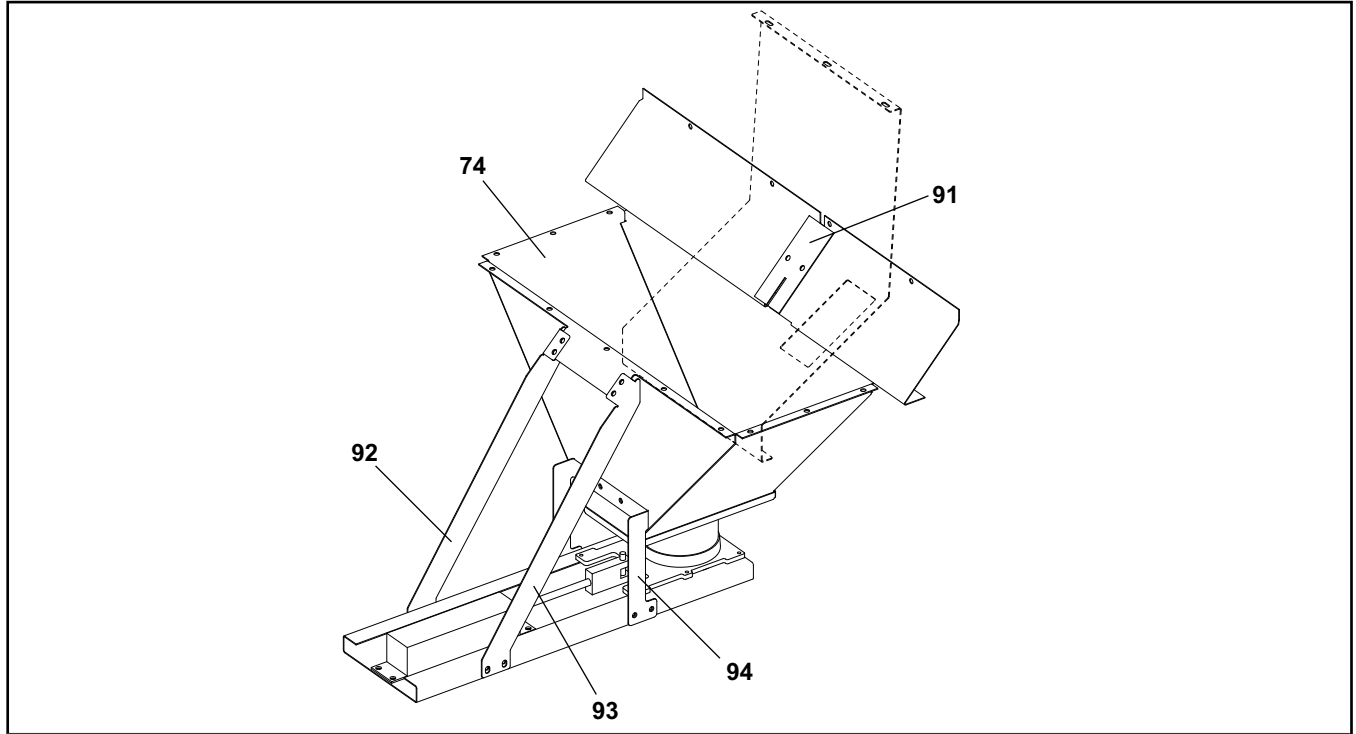
The Lint Collector is mounted under the Dryer at installation. The 6" flexible hose connection pipes to DRYVAC or lint collector by others.



Air Cylinder and Gate Valve

Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers



Parts List

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	G74LS001	5040 INTERNAL LINT SCREEN LEFT	5040 LEFT
	B	G74LS001A	5040 INTERNAL LINT SCREEN RIGHT	5040 RIGHT
	C	G77LS001B	INST=6458 NL INT LINT SCREEN LT	6458 LEFT
	D	G77LS001C	INST=6458 NL INT LINT SCREEN RT	6458 RIGHT
	E	G77LS002B	INST=6464 NL INT LINT SCR N LT	6464 LEFT
	F	G77LS002C	INST= 6464 NL INT LINT SCR N RT	6464 RIGHT
	G	G79LS001	INSTALL=7272L INTERNAL LINT SCREENS	7272 LEFT
	H	G79LS001A	INSTALL=7272R INTERNAL LINT SCREEN	7272 RIGHT
	J	G79LS021	INSTALL=7676 LEFT INTERNAL LINT SCREENS	7676 LEFT
	K	G79LS021A	INSTALL=7676 RITE INTERNAL LINT SCREENS	7676 RIGHT
	L	G82LS001	8282 LT LINT SCREEN INSTALL	8282 LEFT
	M	G82LS001A	8282 RT LINT SCREEN INSTALL	8282 RIGHT
-----COMPONENTS-----				
A	1	A74LS003	5040 LINT SCREEN RIVNUT BOTTOM	
B	1	A74LS003A	5040 LINT SCREEN RIVNUT BOTTOM RT	
C	1	A77RN001	ASSY=LOWER SCR N SUPPORT LEFT	
D	1	A77RN001A	ASSY=LOWER SCR N SUPPORT RIGHT	
E	1	A77RN005	ASSY=6464 LOWER SCREEN SUPPORT LF	
F	1	A77RN005A	ASSY=6464 LOWER SCREEN SUPPORT RT	
G	1L	A79RN002	ASSY=LF LS BTTM-LOAD SD	
H	1L	A79RN002A	ASSY=RT LS BTTM-LOAD SD	
J	1L	A79RN025	ASSY=7676 LEFT LINT SCREEN BRKT BTTM-REAR	
K	1L	A79RN022A	ASSY=7676 RITE LINT SCREEN BRKT BTTM-FRONT	

Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

Parts List				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
G	1R	A79RN006	ASSY=LF LS BTTM-UNLOAD SD	
H	1R	A79RN006A	ASSY=RT LS BTTM-UNLOAD SD	
J	1R	A79RN022	ASSY=7676 LEFT LINT SCREEN BRKT BTTM-FRONT	
K	1R	A79RN025A	ASSY=7676 RITE LINT SCREEN BRKT BTTM-REAR	
L	1	A82RN131	8282 LT LINT SCREEN LOWR SPPRT W/RVNT	
M	1	A82RN131A	8282 RT LINT SCREEN LOWR SPPRT W/RVNT	
AB	2	A74LS002	5040 LINT SCREEN RIVNUT TOP	
CD	2	A77RN002	ASSY=UPPER SCR N SUPPORT	
EF	2	A77RN006	ASSY=6464 UPPER SCREEN SUPPORT	
GH	2	A79RN001	ASSY=LF LS BRKT TOP	
J	2	A79RN021	ASSY=7676 LEFT LINT SCREEN BRKT TOP	
K	2	A79RN021A	ASSY=7676 RITE LINT SCREEN BRKT TOP	
LM	2	A82RN133	8282 SCREEN UPPER SUPPORT W/RIVNUT	
AB	3L	A74LS001	5040 LINT SCREEN RIVNUT LEFT	
CD	3	A77RN003	ASSY=SIDE SCREEN SUPPORT	
EF	3	A77RN007	ASSY=6464 SIDE SCREEN SUPPORT	
K	3L	A79RN026A	ASSY=7676 RITE LINT SCREEN BRKT VERT-REAR	
G	3L	A79RN007	ASSY=LF LS MNT-UNLOAD SD	
G	3R	A79RN003	ASSY=LF LS MNT-LOAD SD	
H	3L	A79RN007A	ASSY=RT LS MNT-UNLOAD SD	
J	3L	A79RN026	ASSY=7676 LEFT LINT SCREEN BRKT VERT-REAR	
AB	3R	A74LS001A	5040 LINT SCREEN RIVNUT RIGHT	
H	3R	A79RN003A	ASSY=RT LS MNT-LOAD SD	
J	3R	A79RN023	ASSY=7676 LEFT LINT SCREEN BRKT VERT-FRONT	
K	3R	A79RN023A	ASSY=7676 RITE LINT SCREEN BRKT VERT-FRONT	
LM	3	A82RN132	8282 SCREEN SIDE SUPPORT W/RIVNUT	
CDG	4L	A77RN004	ASSY=CENTER SCREEN SUPPOT LEFT	
H	4L	A79RN005A	ASSY=RT LS CENTER-UNLOAD SD	
CD	4R	A77RN004A	ASSY=CENTER SCREEN SUPPORT RIGHT	
H	4R	A79RN004A	ASSY=RT LS CENTER-LOAD SD	
EF	4	A77RN004B	ASSY=CENTER SCREEN SUPPORT NEW - LOOK	
JK	4	A79RN024	ASSY=7676 LINT SCREEN BRKT VERT-CENTER	
LM	4	A82RN130	8282 SCREEN CENTER SUPPORT W/RIVNUT	
AB	5	W7 44248	5040 LINT SCREEN	
CDEF	5	W7 71804	WLMT=54 MESH SCREEN FRAME	
GH	5L	W7 81590	7272 LINT SCREEN-LOAD SIDE	
JK	5L	W7 85590	WELD=7676 LINT SCREEN FRAME-FRONT	
GH	5R	W7 81591	7272 LINT SCREEN-UNLOAD SIDE	
JK	5R	W7 85591	WELD=7676 LINT SCREEN FRAME-REAR	
LM	5	W7 88134	8282 SCREEN WLMT	
C-F	6	07 71838	FILLER-SCREEN-TOP-UNLOAD SIDE	
C-F	7	07 71838A	FILLER-SCREEN-TOP-LOAD SIDE	
C-F	8	07 71839	FILLER-SCREEN-TOP-MID	
C-F	9	07 71846	FILLER=6464 LINT VERTICAL RIGHT	
C-F	10	07 71846A	FILLER=6464 LINT VERTICAL LEFT	
C-F	11	07 71856	LINT=CORNER FILLER LOAD	
C-F	12	07 71856A	LINT=CORNER FILLER UNLOAD	
C-F	13	07 71857	LINT=CORNER FILLER LOWER LOAD	

Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

Parts List				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
C-F	14	07 71857A	LINT=CORNER FILLER LOWER UNLOAD	
A	15L	07 44252	5040 LEFT LINT DEFLECTOR	
C	15L	07 71836	LINT BLOCKER UNLOAD LEFT	
E	15L	07 72054B	6464 LEFT REAR LINT BLOCKER	
G	15L	07 81565	7272 LINT DEFLECTOR UNLOAD LEFT	
H	15L	07 81565A	7272 LINT DEFLECTOR UNLOAD RIGHT	
J	15L	07 85565B	7676 LEFT LINT DEFLECTOR-REAR	
B	15R	07 44252	5040 LEFT LINT DEFLECTOR	
D	15R	07 71836A	LINT BLOCKER UNLOAD RIGHT	
F	15R	07 72054C	6464 RITE REAR LINT BLOCKER	
G	15R	07 81566	7272 LINT DEFLECTOR LEFT	
H	15R	07 81566A	7272 LINT DEFLECTOR RIGHT	
J	15R	07 85565C	7676 RITE LINT DEFLECTOR-REAR	
L	15	07 88139	8282 LT LINT BLOCKER UNLOAD	
M	15	07 88139A	8282 RT LINT BLOCKER UNLOAD	
A	16	07 44254	5040 LINT DEFLECTOR UNLOAD LF	
B	16	07 44254A	5040 LINT DEFLECTOR UNLOAD RT	
C	16	07 71831B	6458 NL LINT DIVERTER UNLOAD LT	
D	16	07 71831C	6458 NL LINT DIVERTER UNLOAD RT	
E	16	07 72052D	6464 NL LINT DIVERTER UNLOAD LT	
F	16	07 72052E	6464 NL LINT DIVERTER UNLOAD RT	
K	16	07 85566C	7676 RITE DEFLECTOR BTM CORNER	
L	16	07 88136	8282 LT LINT DIVERTER UNLOAD	
M	16	07 88136A	8282 RT LINT DIVERTER UNLOAD	
A	17	07 44253	5040 LINT DEFLECTOR LOAD LF	
A	17	07 44253A	5040 LINT DEFLECTOR LOAD RT	
C	17	07 71832B	6458 NL LINT DIVERTER LOAD SIDE LT	
D	17	07 71832C	6458 NL LINT DIVERTER LOAD SIDE RT	
E	17L	07 72053B	6464 LEFT REAR LINT DIVERTER	
F	17L	07 72053C	6464 RITE REAR LINT DIVERTER	
J	17L	07 85566B	7676 LEFT LINT DEFLECTOR BTM CORNER	
L	17	07 88137	8282 LT LINT DIVERTER LOAD SIDE	
M	17	07 88137A	8282 RT LINT DIVERTER LOAD SIDE	
AB	18	W7 44245	5040 LINT SCREEN JET WELDMENT	
CDEF	18	W7 71860A	WLMT=BLOW NOZZLE OUTER RIGHT	
GHF	18	W7 81561	WLMT=BLOW NOZZLE UNLOAD SIDE	
LM	18	W7 88147A	8282 BLOW NOZZLE OUTER WLMT RIGHT	
AB	19	W7 44245A	5040 LINT SCREEN JET WLEDMENT OPP	
CDEF	19	W7 71860	WLMT=BLOW NOZZLE OUTER LEFT	
GF	19	W7 81561A	WLMT=BLOW NOZZLE UNLOAD SIDE OPP	
LM	19	W7 88147	8282 BLOW NOZZLE OUTER WLMT LEFT	
CDEFGH	20	W7 71862	WLMT=BLOW NOZZLE INNER LEFT	
JK	20	W7 85562	WELD=7676 LINT SCREEN BLOW NOZZLE-REAR	
CDEFGH	20	W7 71862A	WLMT=BLOW NOZZLE INNER RIGHT	
JK	20	W7 85562A	WELD=7676 LINT SCREEN BLOW NOZZLE-FRONT	
L	20	W7 88149	8282 BLOW NOZZLE INNER WLMT LEFT	
M	20	W7 88149A	8282 BLOW NOZZLE INNER WLMT RIGHT	
GF	21	W7 81560	WLMT=BLOW NOZZLE TOP	
JK	21	W7 85560	WELD=7676 LINT SCREEN BLOW NOZZLE TOP	

Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

Parts List

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
A	22	W7 44247	5040 LINT SCREEN MANIFOLD WELDMENT	
CDEF	22	W7 71850	WLMT=LINT SCREEN MANIFOLD	
GF	22	W7 81569	WLMT=7272 LINT SCREEN AIR MANIFOLD	
JLM	22	W7 85569	WELD=7676 LINT SCREEN AIR MANIFOLD	
all	23	27A003	NOZZLE 1/4" BRASS SQUARE PATTE	
all	24	15K041	HXCAPSCR 1/4-2OUNC2AX1 GR 5 ZI	
all	25	15U185	FLATWASHER(USS STD) 1/4" ZNC P	
all	26	15U185A	FLTWSHR .750DX.312IDX.084TK ZI	
all	27	15G178	1/4"-20 HEXFLANGE NUT ZINC	
all	28	17N059	KNURRIVNUT 1/4-20 ZN.027"-.165	
all	29	07 71812	LINT MAIFOLD VENTED PLUG	
all	30	15K039	HXCAPSCR 1/4-20UNC2AX3/4 GR5 Z	
all	31	60A160	RED SILICONE STRIP 1/8" X 1" WITH P/S	
all	32	15U356	FLATWASHER SILICONE 1.50 O.D X .75 ID	
all	33	20C041	SUPRFLXSIL ADH SEAL RED 10.2OZ	
all	34	60E005H	TUBING PFA 3/8" ID X 1/2" OD HIGH-TEMP	
all	35	53ACM0KEBB	BODYMALCON.5T X.25MP #B68A-8B	
all	36	53A4000KB	TUBE INSERT 1/2"OD #60AE-8	
all	37	53A3000KB	SLEEVE 1/2"OD TUBE #60AP-8	
all	38	53A10SSKB	.5T COMPNUT 11/16-20 AND#61A-8	
all	39	53A043G	EL90 3/8X1/4COMP.AND#69A-6B	
all	40	53A511	SLEEVE DELRIN 3/8"OD#60PT-6	
all	41	53A512	TUBE INSERT 3/8"OD #63PT-6-62	
all	42	53A060C	NUT 3/8"COMP AND.#61A-6	
all	43	60E005B	TUBING NYL.3/8"OD X.275"ID	
all	44	53A023	MALECON3/8X.25COMP ANCHR#68-64	
all	45	51T040	Y STRAINER 1" CAST IRON 20 MESH	
all	46	5N1ACLSG42	NPT NIP 1XCLS TBE GALSTL Sk40	
all	47	5S1ANFA	NPT TEE 1" GALMAL 150#	
all	48	96TFC2AA37	1" N/C 2WAY 120V50/60C VALVE	
all	49	5N1A02AG42	NPT NIP 1X2"TBE GALSTL SK40	
all	50	5SB1A0ENFO	NPTHEXBUSH 1X1/4 GALMAL 150#	
all	51	5SB1A0KNFO	NPTHEXBUSH 1X1/2 GALMAL 150#	
all	52	5S0KNFA	NPT TEE 1/2" GALMAL 150#	
all	53	5N0K04AG42	NPT NIP 1/2X4 TBE GALSTL SK40	
all	54	5SL0KNFA	NPTLNB 90DEG 1/2 GALMAL 150#	
all	55	5N0KCLSG42	NPT NIP 1/2XCLS TBE GALSTLSK40	

Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

Parts List				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
all	56	96TDC2AA37	1/2"N/C2WY120V50/60C VLV	
all	57	5SB0K0EHEO	NPTHEXBUSH 1/2X1/4 STLZNC 125#	
all	58	96J019E	1/4"PRESSREG3-60#AR20-N02H-Z-A	
all	59	30N100	PRESSGAUGE 1/8"BACKCN.0-30PSI	
all	60	02 10456	BUSHING=SENSDEV PIVOTPIN	
all	61	96TCC3AA37	3/8" N/C 3WAY 120V50/60C VALVE	
all	62	27A005	MUFFLER 3/8" BANTAM B38	
all	63	5SB0G0EDEO	NPTHEXBUSH 3/8X1/4 GALCI 125#	
all	65	5N0ECLSBE2	NPT NIP 1/4XCLS TBE BRASS 125#	
all	66	5SL0CBEA	NPTELB 90DEG 1/8 BRASS 125#	
all	67	5N0CCLSB42	NPT NIP 1/8XCLS TBE BRASS STD	
all	68	07 71837	AIR BLADE MANIFOLD	
LM	68	07 88140	8282 AIR BLADE	
all	69	96R302B37	1/8"AIRPILOT 3W NO 120V50/60	
all	70	96R301B37	1/8"AIRPILOT 3W NC 120V50/60	
all	71	15G004HD	1/4-20 USHORT NUT P/R .025-.15	
all	72	15K085	HEXCAPSCR 3/8-16UNC2AX3/4 GR5	
all	73	15G198	HXFLGNUT 3/8-16 ZINC	
AB	74	W7 44250	5040 LINT COLLECTOR	
C	74	W7 71840	WLMT=LINT COLLECT LEFT	
D	74	W7 71840A	WLMT=LINT COLLECT RIGHT	
EF	74	W7 72050A	6464, 53.25" LINT COLLECT WLMT	
GH	74	W7 81567	WLMT=7272 LINT COLLECT	
JK	74	W7 85567B	WELD=7676 LINT COLLECT	
L	74	W7 88141	8282 LT LINT COLLECT WLMT	
M	74	W7 88141A	8282 RT LINT COLLECT WLMT	
all	75	27C217	AIR CYL 2"BORE X 6"STROKE	
all	76	17A019	YOKE END 1/2-20 STEEL	
all	77	17A040	CLEVIS PIN 1/2"X1+3/8" DRILLED	
all	78	07 71847	GATE VAVLE FLAP	
all	79	1.30E+07	BLAST GATE 6" SELF-CLEANING #06SGATE	
all	80	07 71848	GATE VAVLE CYLINDER MNT	
all	81	07 71852	GATE VALVE MNT SHORT	
A-K	82	07 71849	GATE VALVE MNT LONG	
LM	82	07 81568	GATE VALVE MNT LONG	
all	83	53A031XB	BODY-EL90MALE.25X25 #269C-4-4B	
all	84	60E004TE	1/4"OD X.170"ID NYL(BLK)TUBING	
all	85	53A059A	NUT 1/4"BR.HOLYOKE AND #61A-4	
all	86	53A500	SLEEVE DELRIN 1/4"OD#60PT-4	

Internal Lint Screens

50040, 64058, 64064, 72072, 76076, 82082 Dryers

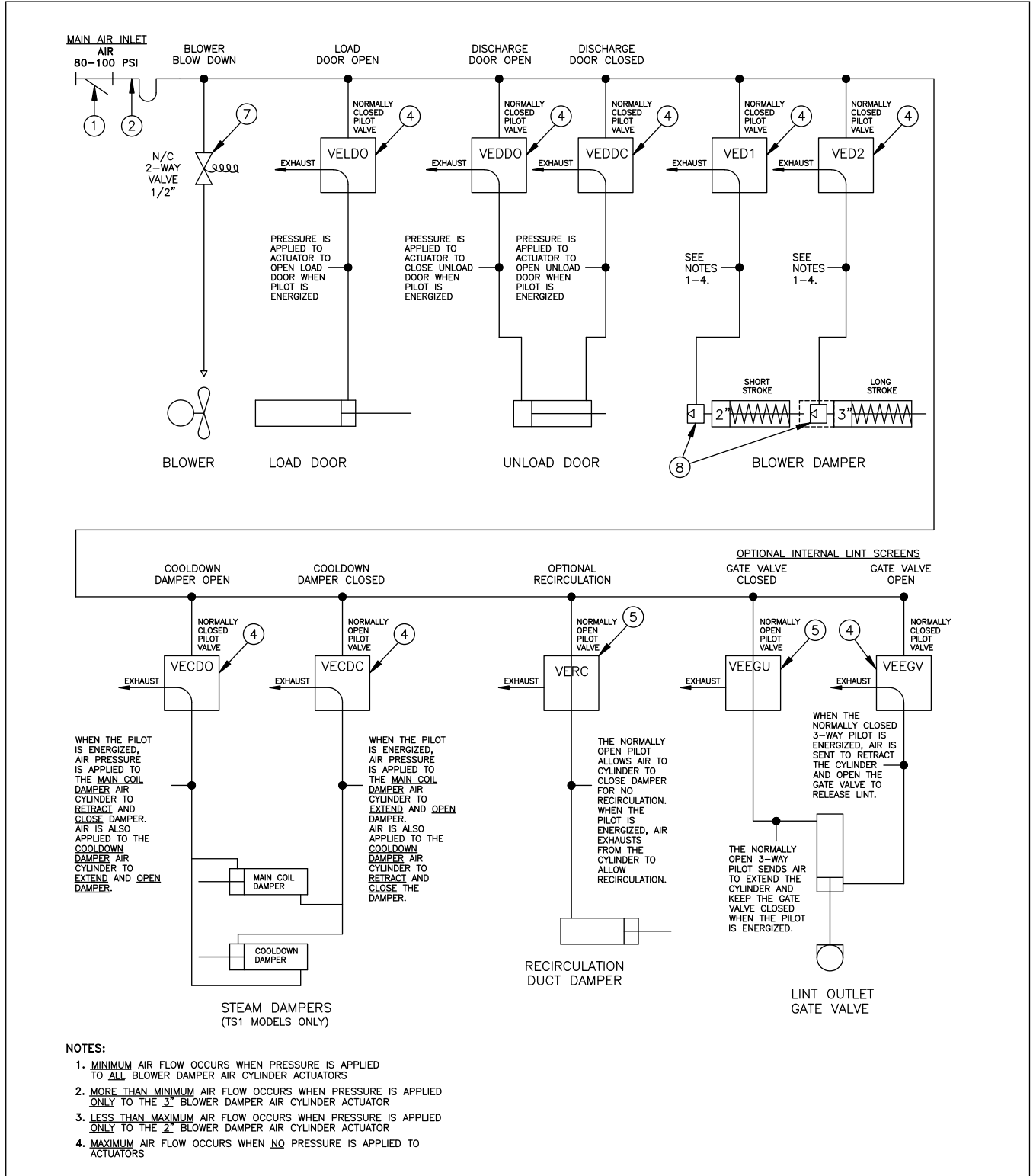
Parts List

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
all	87	53A501	TUBE INSERT .163"OD #63PT-4-40	
all	88	5SB0G0EBEO	NPTHEXBUSH 3/8X1/4 BRASS 125#	
all	89	15U243	FLTWASHER 7/8ODX33/64IDX16GA Z	
all	90	15H051	STDCOTTERPIN 1/8X1+1/2ZINCPL	
ABI	91	07 44255	5040 DEFLECTOR COVER	
JK	91	07 85564	7676 LINT BOTTOM CORNER COVER	
AB	92	07 44257	5040 LINT CYL ARM LF	
AB	93	07 44257A	5040 LINT CYL ARM RT	
AB	94	07 442565	5040 LINT SCREEN CYL BRKT	

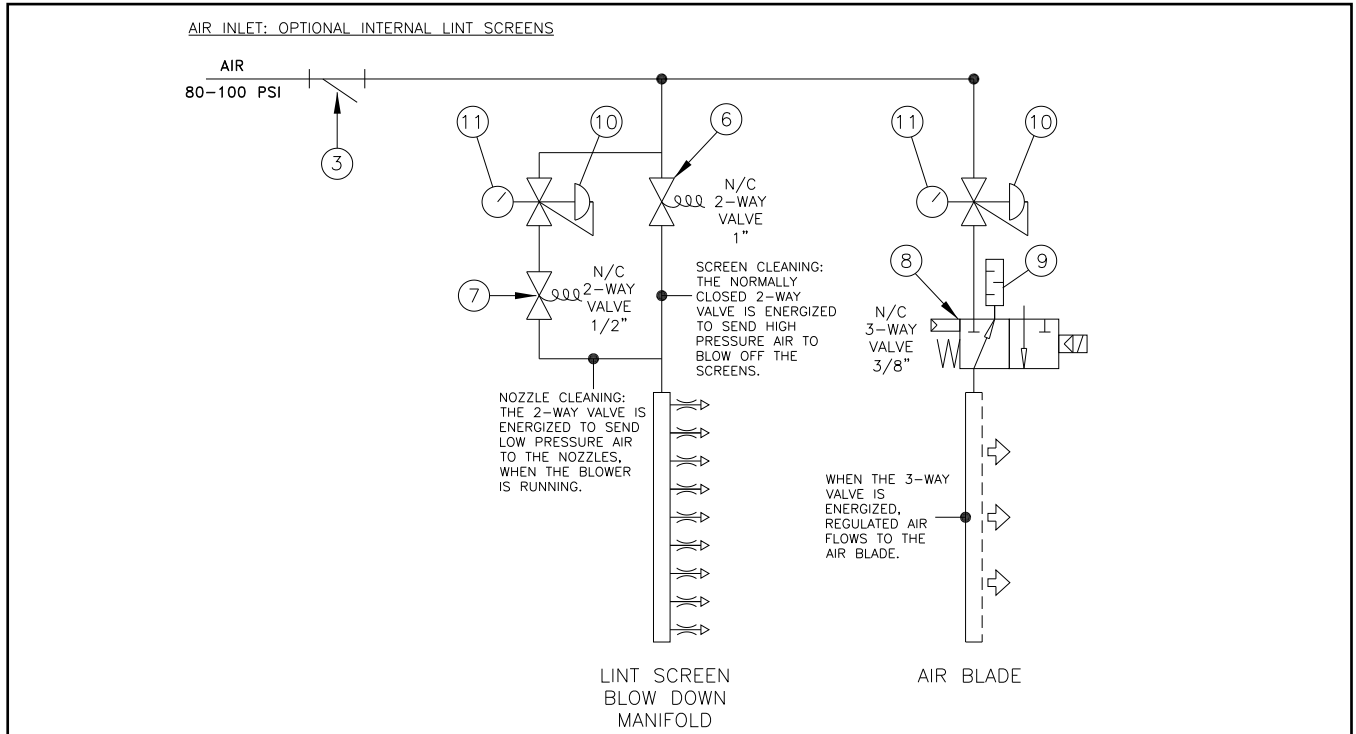
Pneumatic Schematic

5050TG1L/R, 5050TS1L/R, 6458TG1L/R, TS1L/R 6464TG1L/R, TS1L/R
7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R



Pneumatic Schematic

5050TG1L/R, 5050TS1L/R, 6458TG1L/R, TS1L/R 6464TG1L/R, TS1L/R
 7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R



Parts List—Pneumatic Schematic

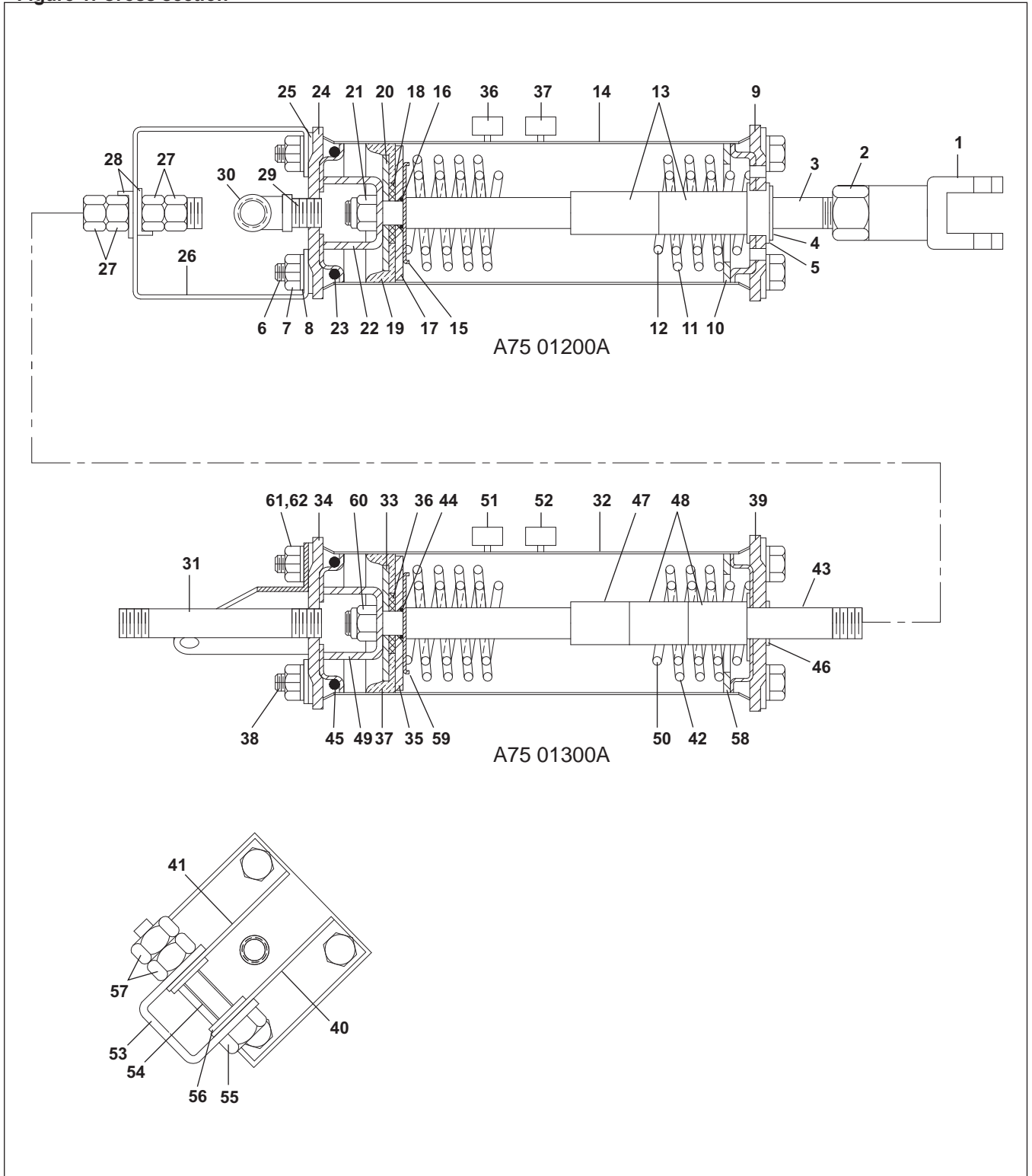
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	AVA712DT37	VALVE ASSY 64" DRYER OL	
-----COMPONENTS-----				
all	1	51T025	Y-STRAINER 1/2" CAST IRON	
all	2	30N601	1/2"AIRLINE FILTER # 07F36AC	
all	3	51T040	Y STRAINER 1" CAST IRON 20 MESH	
all	4	96R301B37	1/8"AIRPILOT 3W NC 120V50/60	
all	5	96R302B37	1/8"AIRPILOT 3W NO 120V50/60	
all	6	96TFC2AA37	1" N/C 2WAY 120V50/60C VALVE	
all	7	96TDC2AA37	1/2"N/C2WY120V50/60C VLV	
all	8	96TCC3AA37	3/8" N/C 3WAY 120V50/60C VALVE	
all	9	27A005	MUFFLER 3/8" BANTAM B38	
all	10	96J019E	1/4"PRESSREG3-60#AR20-N02H-Z-A	
all	11	30N101	PRESSGAUGE 1/8"BACKCN.0-60PSI	

Blower Main Damper Air Cylinders

5040, 5050, 6458, 6464, 7272, 7676 and 8282 Dryers

Figure 1: Cross section



Blower Main Damper Air Cylinders

5040, 5050, 6458, 6464, 7272, 7676 and 8282 Dryers

Parts List—Blower Main Air Damper Air Cylinders				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
			-----ASSEMBLIES-----	
	A	A77AC003	6458 MAIN DAMP CYL ASSY	CONTAINS B & C
	B	A75 01200A	6458 AIR CYL. DAMP=3" STROKE	
	C	A75 01300A	6458 AIR CYL. DAMP=2"STROKE	
			-----COMPONENTS-----	
all	1	17A020	ADJ CLEVIS MACHINED 1/2-13 ZIN	
all	2	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	3	02 18650	STEM=2 WAY AIRCYLINDER BRAKE	
all	4	17B012	EXTRETRING IND#1000-50-ST-ZD Z	
all	5	54E220	NYLNR 8L2FF BUSH 1/2X9/16X.140	
all	6	02 10585E	TIE BOLT=5/16-18X8.25LG PLTD	
all	7	15G185	HXNUT 5/16-18UNC2B SAE ZINC GR	
all	8	15U210	LOKWASHER MEDIUM 5/16 ZINCPL	
all	9	02 02546	CYLINDER HEAD=SLIDE STEM	
all	10	15U520	FLATWASHER 2+3/8X1+41/64X12GA	
all	11	02 15881	SPRING=BRAKE2.1OD11FL15.5#/"	
all	12	02 15880	SPRING=BRAKE1.5OD10.3FL17#/"	
all	13	27B250	SPCRROLL.5ID1.5L.062T STLZNC	
all	14	02 02068	AIRCYL-STAINLESS=DUMP VALVE	
all	15	02 18651	WASHER=2 WAY BRAKE CYL	
all	16	60C106	ORING 5/16ID 1/16CSBUNA70#011	
all	17	02 02105B	2.38"ACYL BRASS PISTONCUP WSHR	
all	18	02 02185	WASHER=PISTON CUP COMP LIMIT	
all	19	02 02194	PISTON CUP=DUMPVALVE 2+3/8"	
all	20	02 02085	UP WASHER=2"OD=PISTON CUP	
all	21	15G220	NUTLOK THINHX 3/8-24 SS/NYL	
all	22	03 01313	STOP=AIR CYL W/2+11/16STROKE	
all	23	60C132	ORING 2"IDX3/16CS BUNA70 #329	
all	24	02 02101	CYLHEAD W/TAPPED HOLE	
all	25	15U185	FLATWASHER(USS STD) 1/4" ZNC P	
all	26	07 50331	AIR CYL. BRKT.= DAMPER	
all	27	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	28	07 50331B	LOCKING WASHER AIRCYL SHAFT	
all	29	5N0ECL3G42	NPT NIPPLE 1/4XCLS TBE GALSTL	
all	30	5SLOEBEA	NPTELB 90DEG 1/4 BRASS 125#	

Blower Main Damper Air Cylinders

5040, 5050, 6458, 6464, 7272, 7676 and 8282 Dryers

Parts List—Blower Main Air Damper Air Cylinders				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
all	31	5N0ECLSBE2	NPT NIP 1/4XCLS TBE BRASS 125#	
all	32	02 02068	AIRCYL-STAINLESS=DUMP VALVE	
all	33	02 02085	UP WASHER=2"OD=PISTON CUP	
all	34	02 02101	CYLHEAD W/TAPPED HOLE	
all	35	02 02105B	2.38"ACYL BRASS PISTONCUP WSHR	
all	36	02 02185	WASHER=PISTON CUP COMP LIMIT	
all	37	02 02194	PISTON CUP=DUMPVALVE 2+3/8"	
all	38	02 10585E	TIE BOLT=5/16-18X8.25LG PLTD	
all	39	02 02546	CYLINDER HEAD=SLIDE STEM	
all	40	02 02547	BRKT=AIRCYL-LFT ZINC/CAD	
all	41	02 02550	BRKT=AIRCYL-RIGHT ZINC/CAD	
all	42	02 15881	SPRING=BRAKE2.1OD11FL15.5#/"	
all	43	02 18650A	STEM-AIRCYL.UPLOCK PRESS	
all	44	60C106	ORING 5/16ID 1/16CSBUNA70#011	
all	45	60C132	ORING 2"IDX3/16CS BUNA70 #329	
all	46	54E220	NYLNR 8L2FF BUSH 1/2X9/16X.140	
all	47	27B240	SPCRROLL.5ID.813L.062T STLZNC	
all	48	27B250	SPCRROLL.5ID1.5L.062T STLZNC	
all	49	03 01313	STOP=AIR CYL W/2+11/16STROKE	
all	50	02 15880	SPRING=BRAKE1.5OD10.3FL17#/"	
all	51	20L601A	ID TAG NAT'L#1614 ALUM EMB "A"	
all	52	20L601E	ID TAG NAT'L#1614 ALUM EMB "E"	
all	53	02 02556	SUPPORT=AIRCYL 12GA ZINC PLT	
all	54	27B2750LOT	SPC RROLL.562ID.937L.048T ZNK	
all	55	15K206	HEXCAPSCR 9/16-12X2.5 ZC GR5	
all	56	15U311A	FLTWASHER9/16 ASME/B18.22.1TYP	
all	57	15G235F	HXFNJAMNUT 9/16-12UNC2B ZINC G	
all	58	15U520	FLATWASHER 2+3/8X1+41/64X12GA	
all	59	02 18651	WASHER=2 WAY BRAKE CYL	
all	60	15G220	NUTLOK THINHX 3/8-24 SS/NYL	
all	61	15G185	HXNUT 5/16-18UNC2B SAE ZINC GR	
all	62	15U210	LOKWASHER MEDIUM 5/16 ZINCPL	
Xx				
Xx				

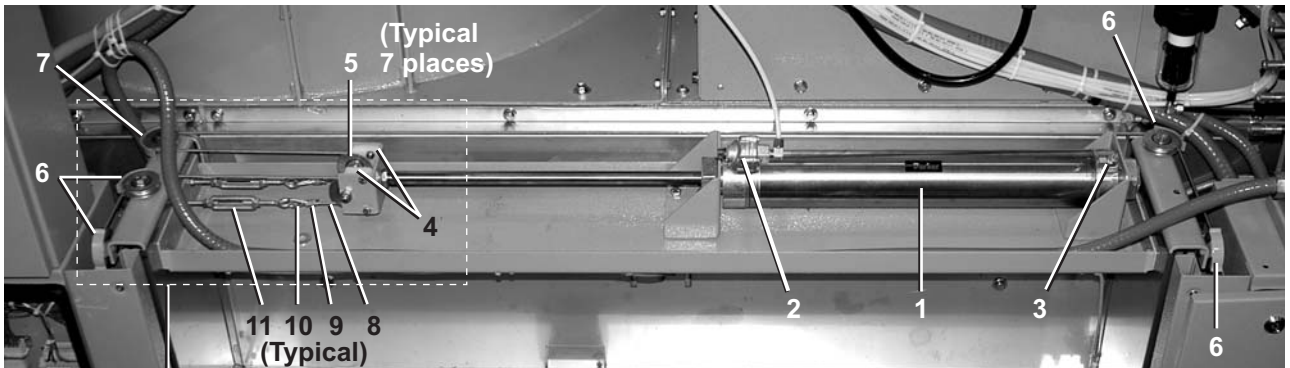
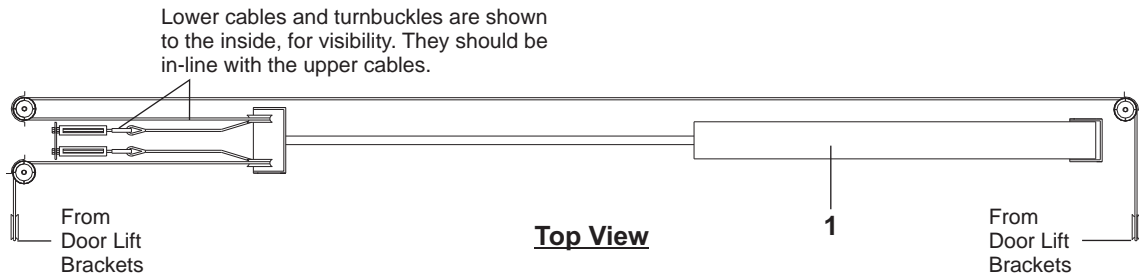
Door Assemblies

7

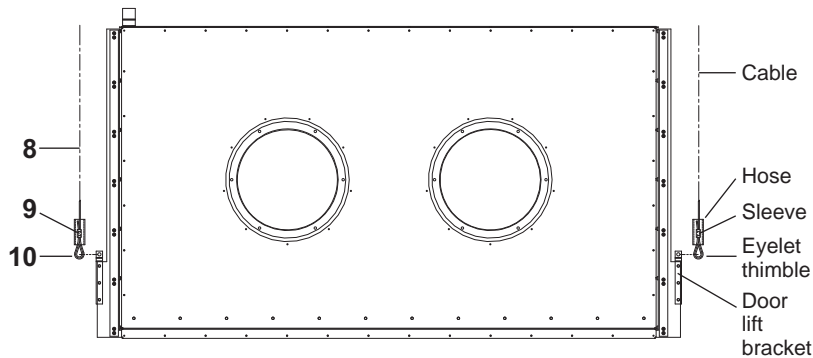
Load Door Installation

6458TG1L/R, TS1L/R 6464TG1L/R, TS1L/R 7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R

Figure 1: Door Installation



For 7676 & 8282 See Detail A



Removing Load Door:

Cut the cables to the load door, unthread the pulleys and lift the door up and out of the door channel.

To save the cables, another method is to disconnect the turnbuckles, unbolt and remove all seven (7) pulleys, lift the door up and out of the door channel.

Reinstalling Load Door:

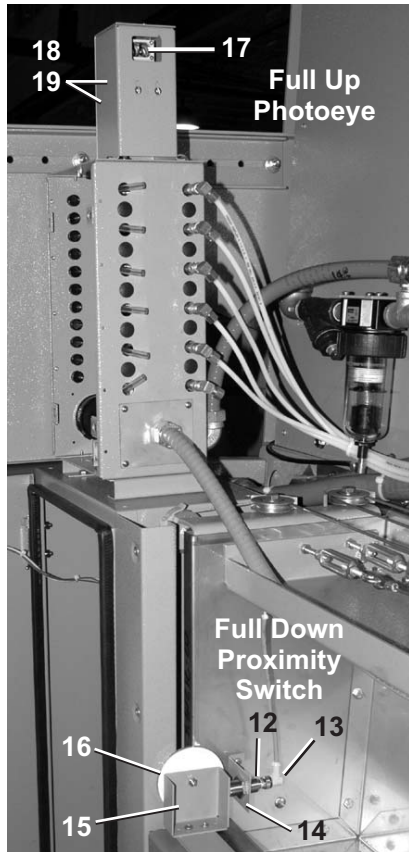
Feed new cable through eyelet thimbles and sleeves and crimp. Slide the pieces of 1" braided hose down the cable and over the thimbles. Lower the door into the door channel, keeping tension on the cables. Thread the cables up through the pulleys as shown in Top View. When attaching cables to turnbuckles or adjusting turnbuckles, make sure the door is fully closed and the cylinder is fully extended.

If the pulleys were removed, reinstall pulleys as shown in Top View. Adjust cable tension with turnbuckles.

Load Door Installation

6458TG1L/R,TS1L/R 6464TG1L/R,TS1L/R 7272TG1L/R,TS1L/R 7676TG1L/R 8282TG1L/R

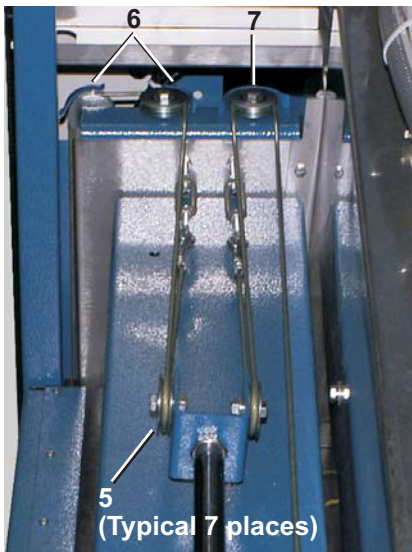
Figure 2: Detail, Switches and targets



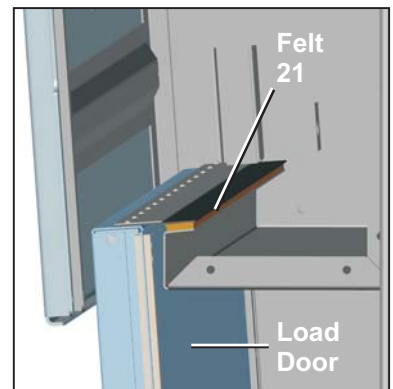
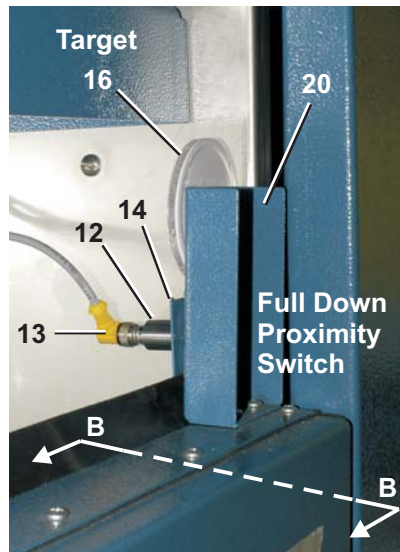
6458 models built prior to 2014



6458 models built 2014 & 6464, 7272, 7676, 8282 models



Detail A: 7676, 8282 Dryers



Section B-B:
Load door upper rest

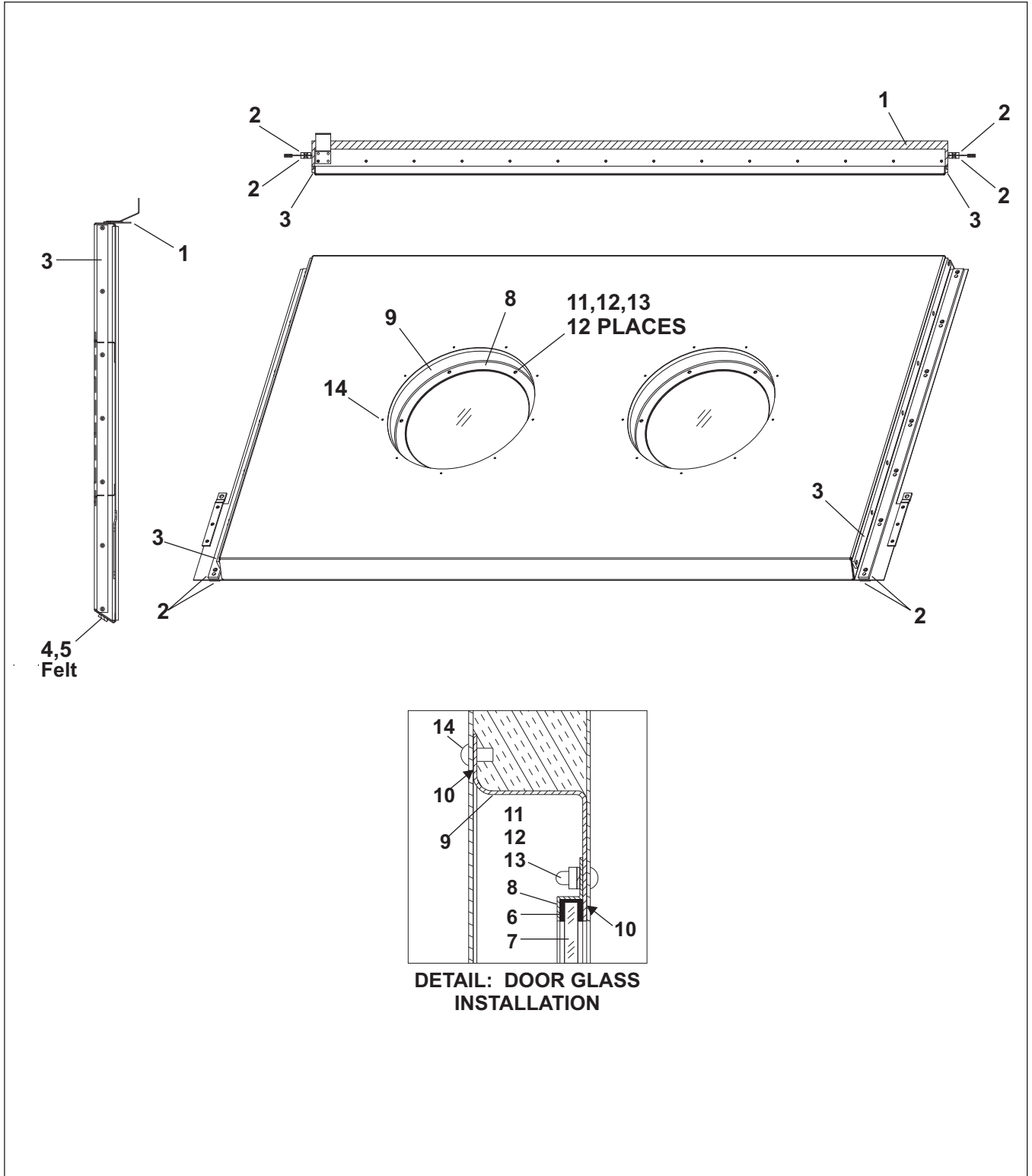
Load Door Installation

6458TG1L/R,TS1L/R 6464TG1L/R,TS1L/R 7272TG1L/R,TS1L/R 7676TG1L/R 8282TG1L/R

Parts List—Load Door Installation				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	G77LD001D	6458 WIDE LOAD COSM INSTALL	6458 & 6464 DRYERS
	B	G79LD001	7272 LOAD COS INSTALL BLW LF	7272 DRYERS
	C	G79LD020	7676 LOAD COSM INSTALL	7676 DRYERS
	D	G82LD001	8282 LOAD COSMETIC INSTALL	8282 DRYERS
-----COMPONENTS-----				
A	1	27C316	AIRCYL.3"BOREX16.5X.75PIVOT MT	
BCD	1	27C416	AIR CYL 4"X16.5" STROKE	
all	2	96M055	DELTROL QUICK EXHAUST VLV.1/4"	
all	3	96H018	ANGLE NEEDLE VLV 1/4" T X 1/8MP	
AB	4	07 40937	UHMW PULLEY GUIDE AIRCYL	
all	5	27A965	PULLEY ZINC PLATE #CPS6150	
all	6	W7 71197	6458 90 DEG PULLEY GRD WELD	
all	7	W7 71199	6458 180 DEG PULLEY GRD WELD	
A	8	27A964B	CABLE 3/32" 3095GN4 GALVANIZED	
BCD	8	27A964	CABLE #3126-G-N-6	
A	9	27A963B	LOOP SLEEVE 3/32" 7092A	
BCD	9	27A963	LOOP SLEEVE #7125-A	
A	10	27A962B	THIMBLE SS 3/32 AN100-4	
BCD	10	27A962	THIMBLE #AN100-6	
all	11	17A074	TURNBKLE 1/4X4 EYE+EYE ZINC	
AB	12	09RPS30ADS	PROX SW QK CONN 30M NO-DC SHLD	
CD	12	09RPS18ADU	PRXSW QK CONN 18M NO-DC UNSHLD EUROFAST	
all	13	09RPSDC095	CON.90DEG FEMALE DC 3A300V 5M	
all	14	03 BL2X2A	BRACKET:PHOTOEYE 6458 DRYER	
all	15	07 80422	BRKT=LOAD DR PHOTO-PROX	
all	16	09RPE001A	REFLECTOR 3"DIA CLEAR	
all	17	09RPE011	PHOTOEYE VALU-BEAM 10-30DC	
all	18	03 E3X6A	ENCL:PHOTOEYE MOUNTING BOX	
all	19	03 E3X6B	PHOTOEYE COVER	
all	20	07 85422	7676 BRKT FOR LOAD DOOR PHOTO/PROX	
All	21	27A682	FELT 3/8"THK X 1"W SAE F-7	LOAD DOOR UPPER REST

Load Door

6458TG1L/R, TG1L/R 6464TG1L/R, TS1L/R 7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R



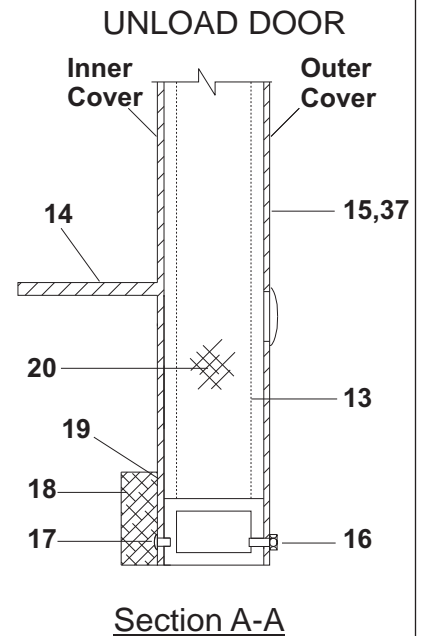
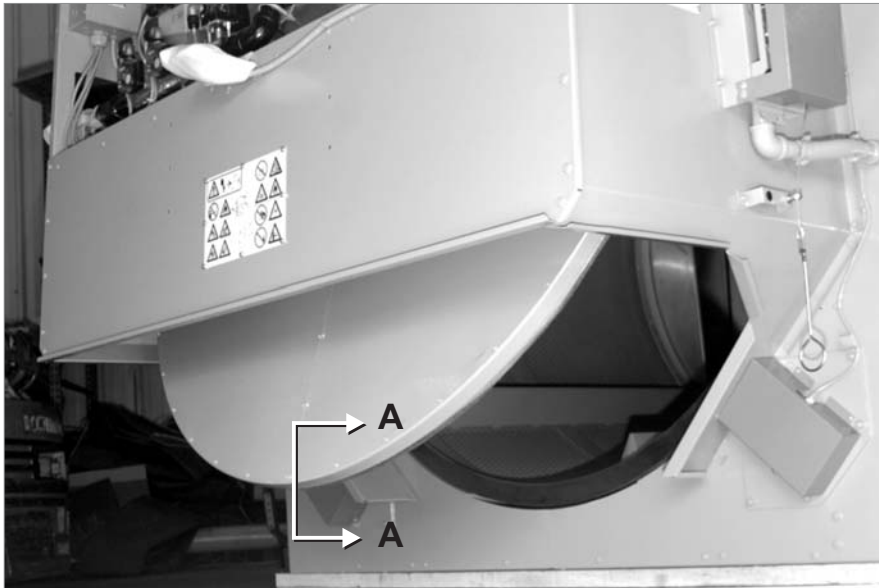
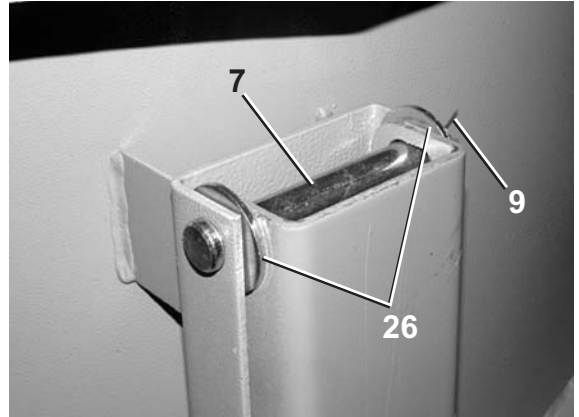
Load Door

6458TG1L/R, TG1L/R 6464TG1L/R, TS1L/R 7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R

Parts List—Load Door				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	A77LD001W	6458 LOAD DOOR-WIDE	6458TG1L/R, TS1L/R 6464TG1L/R, TS1L/R
	B	A79LD002	7272 LOAD DOOR ASSY	7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R
-----COMPONENTS-----				
A	1	07 71195A	6458 WIDE LOAD DOOR TOP SEAL	
B	1	07 81195	7272 LOAD DOOR TOP SEAL	
A	2	07 81224A	7272 LD DR NYLON STRIP=SIDE	
B	2	07 81224	7272 LOAD DOOR NYLON STRIP	
all	3	07 81224A	7272 LD DR NYLON STRIP=SIDE	
all	4	27A682	FELT 3/8"THK X 1"W SAE F-6	
all	5	20C044	RUB/GASKET ADH 3M#EC1300 PINTS	
all	6	02 02366A	GASKET DOORGLASS = DRYER	
all	7	02 09215	DRGLASS 12 3/8DIA SS STAMPED	
all	8	07 50057	RING=SIGHGLASS LOAD DOOR	
all	9	07 71222	6458 LOAD DR SIGHT RING	
all	10	20C040B	SUPERFLEX CLR RTV SIL 10.2OZ	
all	11	15K031	BUTSOKCAPSCR 1/4-20X1/2 SS18-8	
all	12	15U181	LOCKWASHER MEDIUM 1/4 SS18-8	
all	13	15G140S	HEXCAPNUT(ACORN) 1/4-20 SS 18-	
all	14	15P050	TRDCUT-F PANHD 10-32X3/4 SS410	

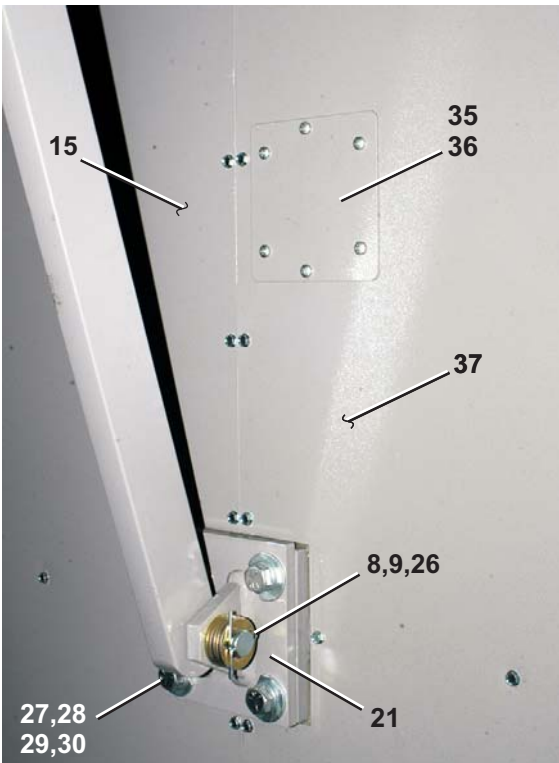
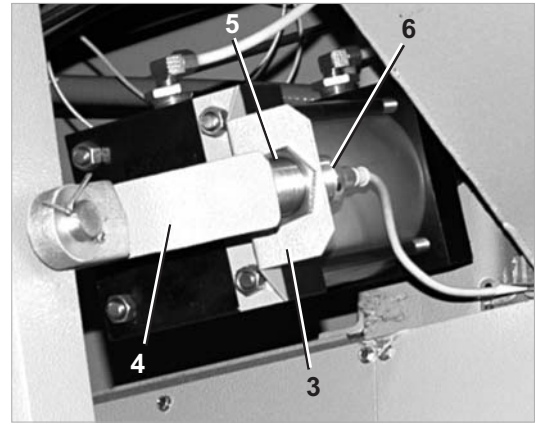
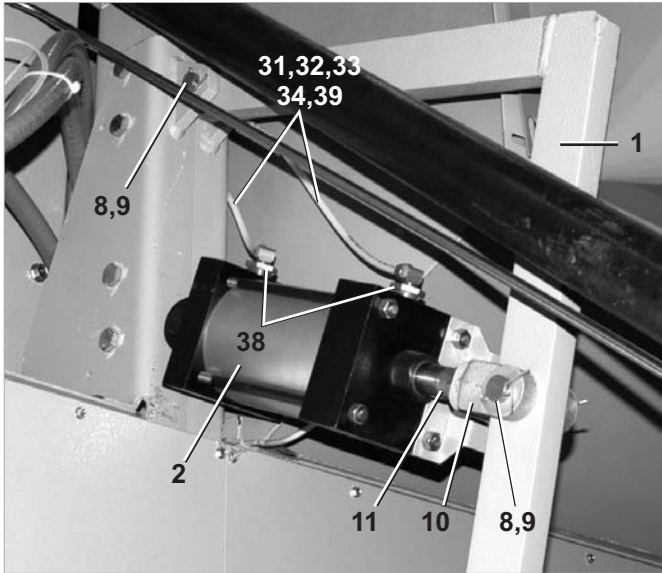
Unload Door & Installation

6458TG1L/R, TS1L/R 6464TG1L/R, TS1L/R 7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R



Unload Door & Installation

6458TG1L/R, TS1L/R 6464TG1L/R, TS1L/R 7272TG1L/R, TS1L/R 7676TG1L/R 8282TG1L/R



Optional IR Sensor

Unload Door & Installation

6458TG1L/R,TS1L/R 6464TG1L/R,TS1L/R 7272TG1L/R,TS1L/R 7676TG1L/R 8282TG1L/R

Parts List—Unload Door & Installation				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
-----ASSEMBLIES-----				
	A	A77SD010B	6458 UNLOAD DOOR ASSY	6458,6464
	B	A79SD010	7272 UNLOAD DOOR ASSY	7272
	C	A79SD010A	7272 IR UNLOAD DOOR ASSY	7272 W/IR SENSOR
	D	A79UD020	7676 IR UNLOAD DOOR ASSY	7676
	E	A82UD001	8282 IR UNLOAD DOOR ASSY	8282
-----COMPONENTS-----				
A	1	W7 71288	6458 UNLD DOOR HINGE ARM WELD	
B	1	W7 81288	7272 UNLD DOOR HINGE ARM WELD	
D	1	W7 85288	7676 UNLD DOOR HINGE ARM WELD	
E	1	W7 88065	8282 UNLOAD DOOR HINGE ARM WELD	
AD	2	27C404	AIR CYL 4"X4.5"X1" CLEVIS MT.	
B	2	27C650	AIR CYL 4"X3.5"X1" CLEVIS MNT.	
C	2	27C504	AIR CYL 5"X4.5"X1" CLEVIS MT	
all	3	07 71132	6458 UNLOAD DOOR PROX BKT	
D	3	07 85132	7676 UNLOAD DOOR PROX BKT	
E	3	07 71132A	8282 UNLOAD DOOR PROX BKT	
all	4	07 71133	6458 UNLOAD DOOR PROX TARGET	
all	5	09RPS30CAS	PROXSW QK CONN 30M NO-AC SHLD	
all	6	09RPTAC005	CONN.ST.FEM 3-PIN AC 3A 5M	
all	7	17A044A	CLEVISPIN 3/4X5+21/32 ZNC"SPEC	
all	8	17A045	CLEVIS PIN 3/4"X 3" DRILLED +	
all	9	15H051	STDCOTTERPIN 1/8X1+1/2ZINCPL	
all	10	17A049	YOKE END 3/4-16UNF HARD CHROME	
all	11	15G239S	HEXJAMNUT 3/4-16UNF2 SS18-8	
A	13	W7 71125A	6458 UNLOAD DR FRAME WELD	
BC	13	W7 81125A	7272 UNLOAD DOOR FRAME WELD	
D	13	W7 85125	7676 UNLOAD DOOR FRAME WELD	
E	13	W7 88055	8282 UNLOAD DOOR FRAME WLMT	
A	14	W7 71126B	6458 UNLD DOOR INNER SKIN WELD IR	
B	14	W7 81126A	7272 UNLD DOOR INNER SKIN WELD	
C	14	W7 81126B	7272 UNLD DR IR INNER SKIN WELD	
D	14	W7 85126B	7676 UNLD DR INNER SKIN WELD	
E	14	W7 88063	8282 UNLOAD DOOR INNER SKIN WELD	
A	15	07 71127	6458 INSL COVER UNLOAD DOOR	
BC	15	07 81127	7272 INSL COVER UNLOAD DOOR	
D	15	07 85127	7676 INSL COVER UNLOAD DOOR	

Unload Door & Installation

6458TG1L/R,TS1L/R 6464TG1L/R,TS1L/R 7272TG1L/R,TS1L/R 7676TG1L/R 8282TG1L/R

Parts List—Unload Door & Installation				
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.				
Used In	Item	Part Number	Description	Comments
E	15	07 88056	8282 UNLOAD DOOR INS COVER RIGHT	
all	16	15P059	SCRHXSELFDR:10-16X1/2 #2 ZINC	
A	17	15P052	10X3/4"PPHTEK/2410/NYL.PATCH	
BCD	17	15P053	8-18X3/4 PPHTEKSSW/MICROSPHERE	
all	18	27A682	FELT 3/8"THK X 1"W SAE F-6	
all	19	20C044	RUB/GASKET ADH 3M#EC1300 PINTS	
all	20	98P030	INSUL.FIBRGLS.24X48X1+1/2E=1SH	
all	21	W7 50047A	*LINKAGE ARM BASE BRKT WLMT	
all	22	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	23	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	24	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	25	15U343	FLATWASH 1X25/64X1/8 ZINC	
all	26	15U321H	FLTWASH 3/4 HARD ASTM F436	
all	27	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	28	15K173A	HXCAPSCR 1/2-13UNC2AX1.75 GR5	
all	29	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	30	15U280C	FLATWASH(US STD)1/2"CLIP+ZNC	
all	31	53A059A	NUT 1/4"BR.HOLYOKE AND #61A-4	
all	32	53A500	SLEEVE DELRIN 1/4"OD#60PT-4	
all	33	53A513	TUBE INSERT .123"ODX.444LG.	
all	34	60E004NTN	TUBING NYL(NAT)1/4"ODX.127ID	
all	35	07 44260	IR INNER UNLOAD DOOR COVER	
all	36	07 44261	IR OUTER UNLOAD DOOR COVER	
A	37	07 71127A	6458 INSL COVER UNLOAD DOOR IR	
C	37	07 81127A	7272 INSL COVER UNLOAD DOOR IR	
D	37	07 85127A	7676 INSL COVER UNLOAD DOOR IR	
E	37	07 88056A	8282 UNLOAD DOOR INSUL COVER LEFT	
all	38	5SB0K0EBEO	NPTHEXBUSH 1/2X1/4 BRASS 125#	
all	39	53A031XB	BODY-EL90MALE.25X25 #269C-4-4B	

Water Assemblies

8

Sprinkler Assembly

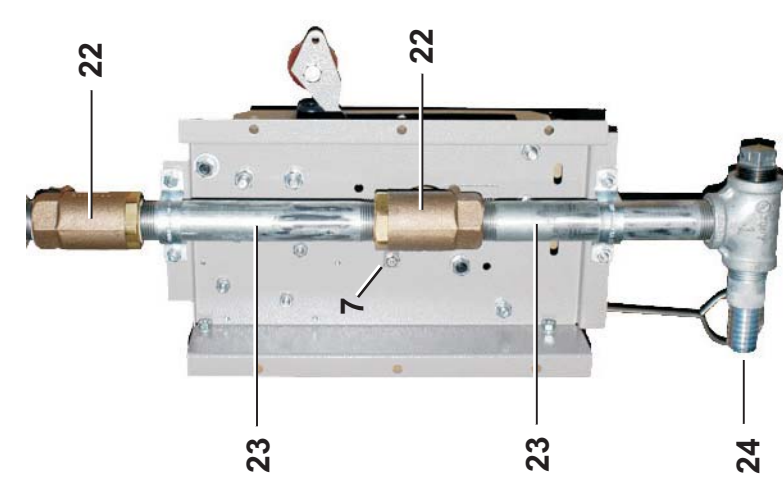
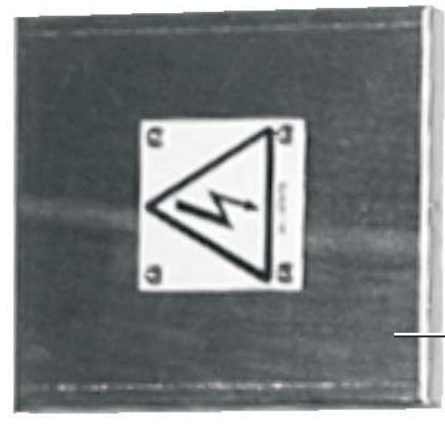
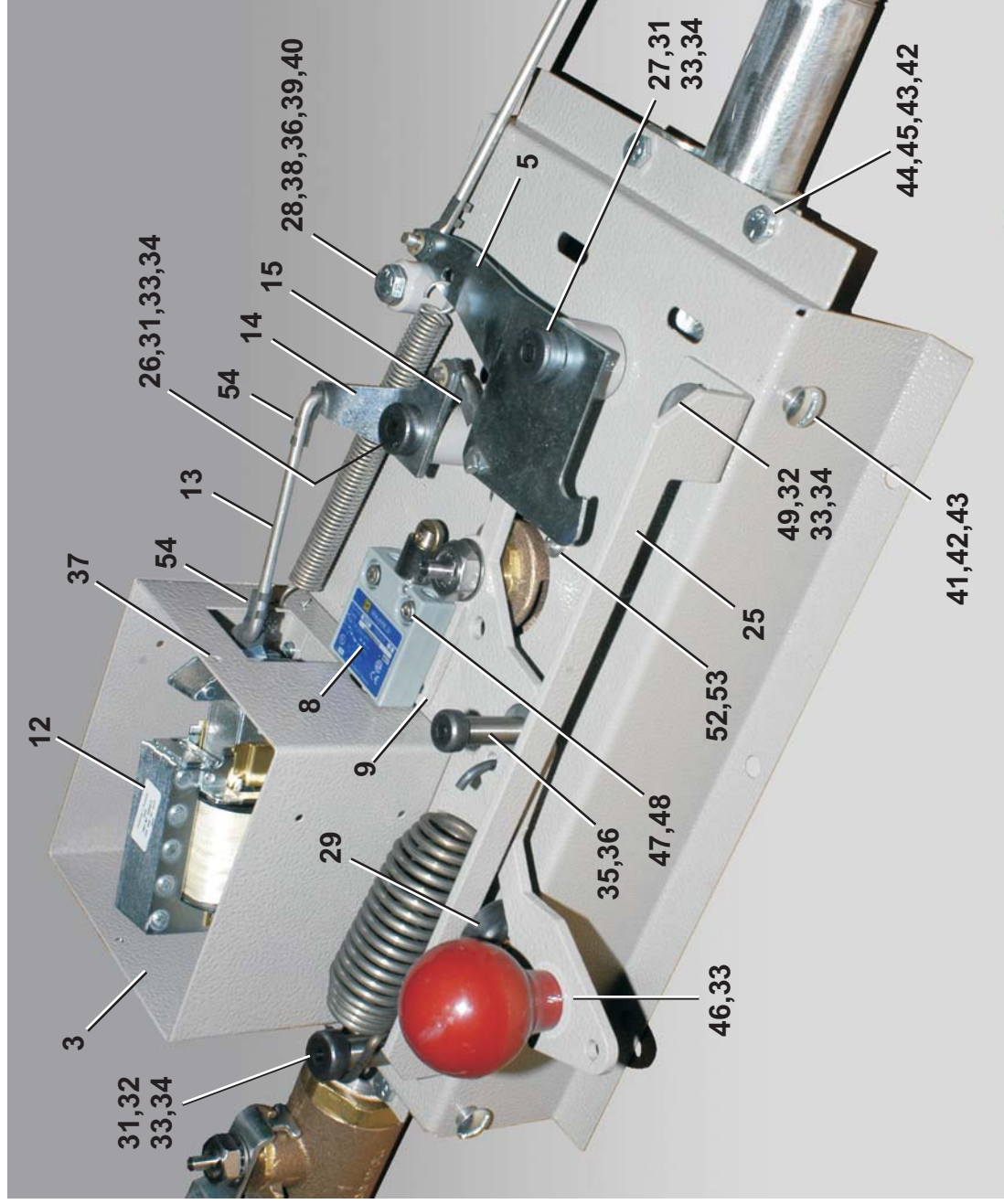
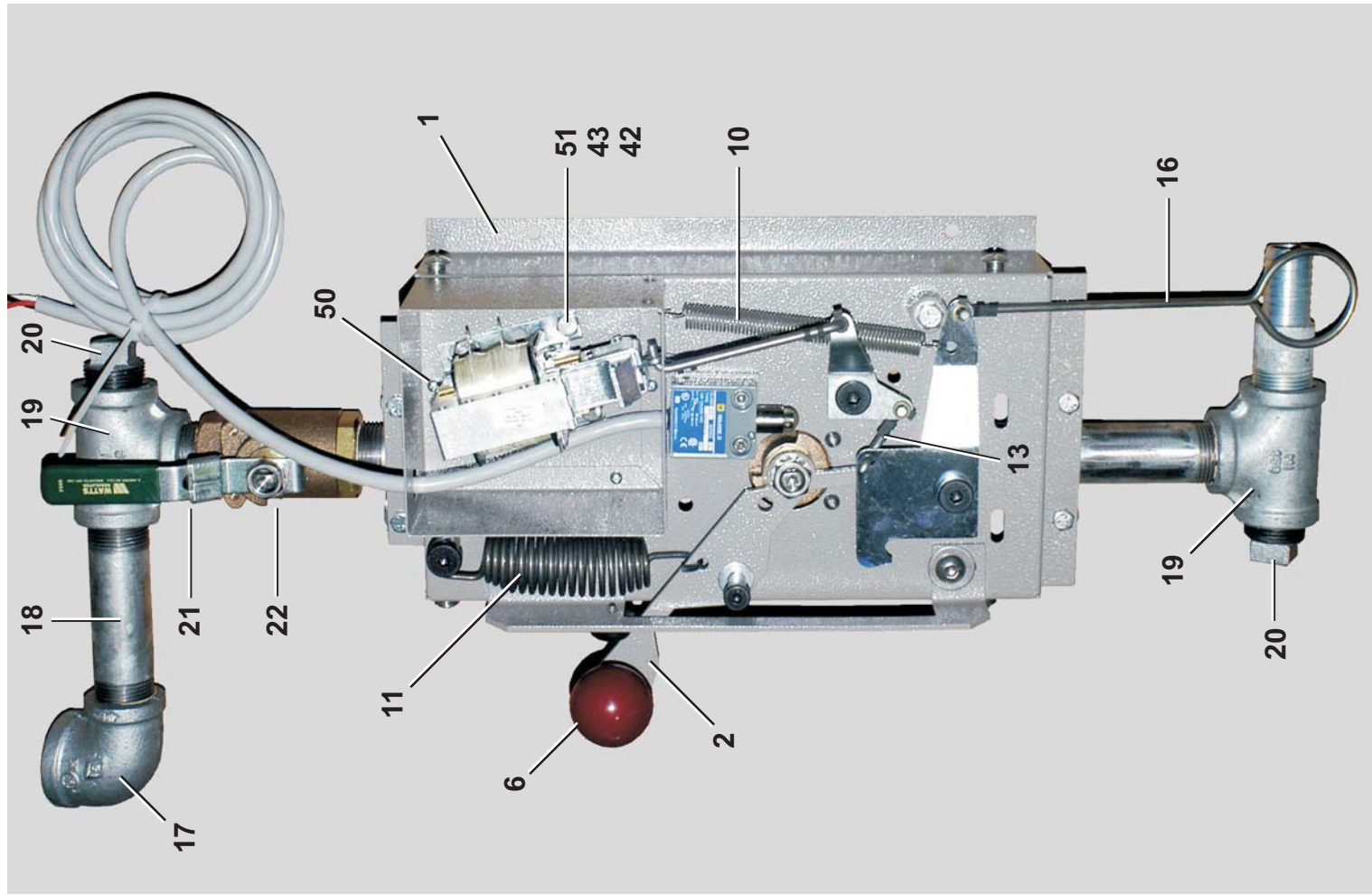
All Dryers

BMP100017/2010096B
(Sheet 1 of 2)



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Litho in U.S.A.

Used In	Item	Part Number	Description	Comments
	A	A77SM005	ASSY=SPRINKLER 6458 LEFT	
			ASSEMBLIES-----	
			COMPONENTS-----	
all	1	07 50276A	SPRINKLER BASE PLATE MOD	
all	2	07 50277A	SPRINKLER HANDLE-STAMPING	
all	3	07 50278A	SOLENOID BOX=SPRINKLER MOD	
all	4	07 50280	COVER FOR SOLENOID BOX	
all	5	07 50281	LATCH ARM FOR SPRINKLER	
all	6	12P100	BALLKNOB RD PLASTIC DAVIES#45H	
all	7	07 50449	MICROSWITCH BACKPLATE	
all	8	09RM01209S	CAPSW 9FT 180DEG ROLLER SILVER	
all	9	07 50285	SWITCH MOUNT SPACER PLATE	
all	10	07 50293	SPRING.500 0DX4.00LGX.049EXT	
all	11	00 06102B	SPRING=1.35 O.D/4.49 LONG	
all	12	09K061D	SOLENOID 120V 60C #8940	
all	13	07 50401	SOLENOID LINKAGE ROD	
all	14	07 50402	TRIP LINK FOR SPRINKLER	
all	15	07 50400	LATCH ARM LINKAGE ROD	
all	16	07 50436	MANUAL TRIP HNDL 8.75" LONG	
all	17	5SL1ENFA1A	NPTLNB 90DEG 1.25X1 GALM 150#	
all	18	5N1A05AG42	NPT NIPPLE 1X5 TBE GALSTL SK40	
all	19	5S1ANFA	NPT TEE 1" GALMAL 150#	
all	20	5SP1ADESC	NPT PLUG 1" SQ CORED GAL CI	
all	21	5N1ACLSG42	NPT NIP 1XCLS TBE GALSTL SK40	
all	22	96D085WEXS	BALVAL 1"BRZWATTB6400SSZ1070SP	
all	23	5N1A08AG42	NPT NIP 1X8 TBE GALSTL SK40	
all	24	51E099SP	DIXON1"KINGCOMBNIP PLTD.#STC10	
all	25	07 50860	+SPRINKLER RESET HANDLE STOP	
all	26	07 50299	DRYER SPRINKLER SPACER	
all	27	07 50300	.884 LONG SPRINKLER SPACER	
all	28	07 50301	.75 LONG SPRINKLER SPACER	

Parts List, cont.—Sprinkler Assembly				
Used In	Item	Part Number	Description	Comments
all	29	60C001	RUBBER BUMPER-BLKWW/WASHER #698	
all	31	15C061	HXSOKSTRIPBLT 1/2X1X3/8-16	
all	32	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	33	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	34	15G205	HXNIUT 3/8-16UNC2B ZINC GR2	
all	35	15C048	HXSOKSTRIPBLT 3/8X1X5/16-18	
all	36	15U200	FLATWASHER(USS STD) 5/16"ZNC P	
all	37	15P002	TRDCUT-F PAN HD 6-32UNC2AX1/4"	
all	38	15K070	HXCAPSCR 5/16-18 UNC2A X1.5 GR	
all	39	15U210	LOKWASHER MEDIUM 5/16 ZINCPL	
all	40	15G185	HXNIUT 5/16-18UNC2B SAE ZINC GR	
all	41	15N162A	TRUSMACSCR 1/4-20UNC2AX1/2 ZIN	
all	42	15G165	HXNIUT 1/4-20UNC2BSAE ZC GR2	
all	43	15U180	LOCKWASHER MEDIUM 1/4 ZINCPL	
all	44	27A019	1"PIPESTRAP 2HOLE STAMPED GALV	
all	45	15K039	HXCAPSCR 1/4-20UNC2AX3/4 GR5 Z	
all	46	15K086D	HXCAPSCR 3/8-16 UNC2A X 7/8" 1	
all	47	15K021A	SOKCAPSCR 10-24UNCX1" LG S/S	
all	48	15G126	HXLOCKNIUT NYLON 10-24 UNC SS N	
all	49	15K091	BTNHDSOKCAPSCR 3/8-16NCX1 GR5	
all	50	15N036	PANMACHSCR SEM 6-32UNC2AX1/4 Z	
all	51	15K030	HEXCAPSCR 1/4-20UNC2X1/2 GR5 Z	
all	52	15N130	RDMACSCR 10-24UNC2A X 1/2 SS18	
all	53	15U150	LOCKWASHER MEDIUM #10 ZINCPL	
all	54	17N300	3/16" ROD CLIP 4L FMP#85303	

Watts Ball Valves and Repair Kits



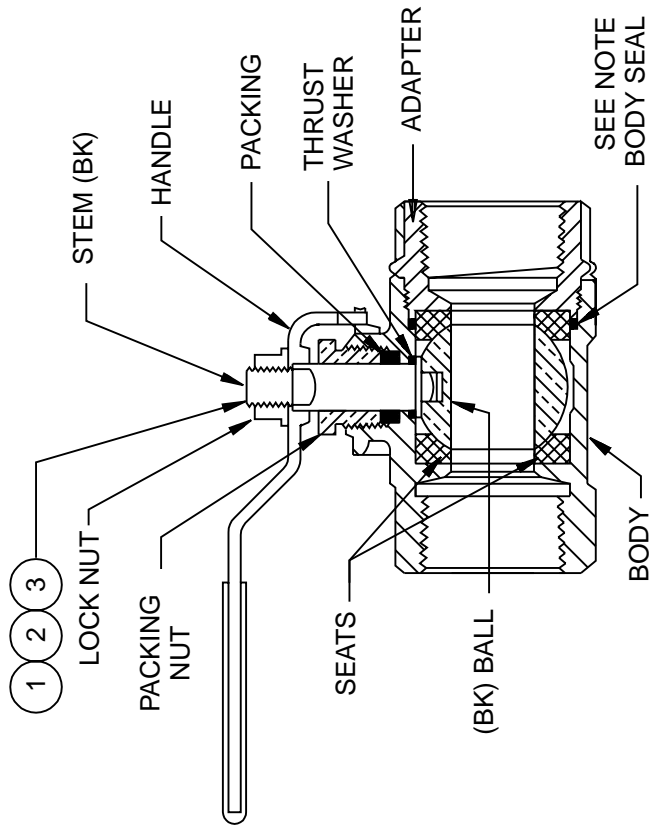
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BMP920007/96067V (1 of 2)

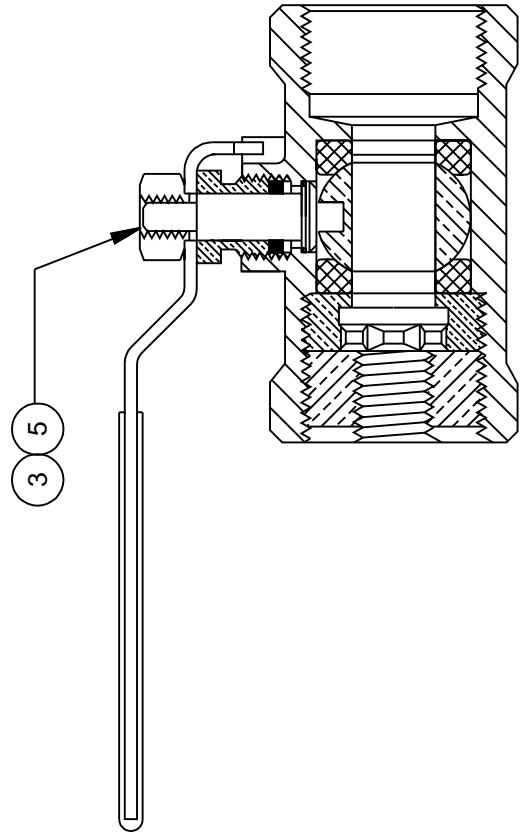
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BMP920007/96067V
(Sheet 1 of 2)

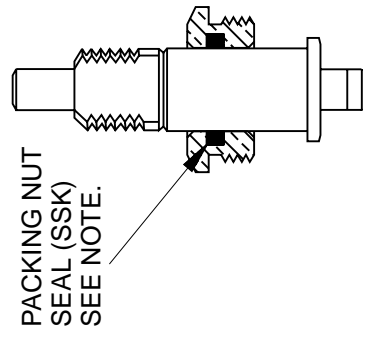
BALL VALVES WITHOUT ACTUATOR PADS FOR MANUAL OPERATION



1/2" BRONZE OR 1/2", 3/4" STAINLESS
NO REPAIR KITS

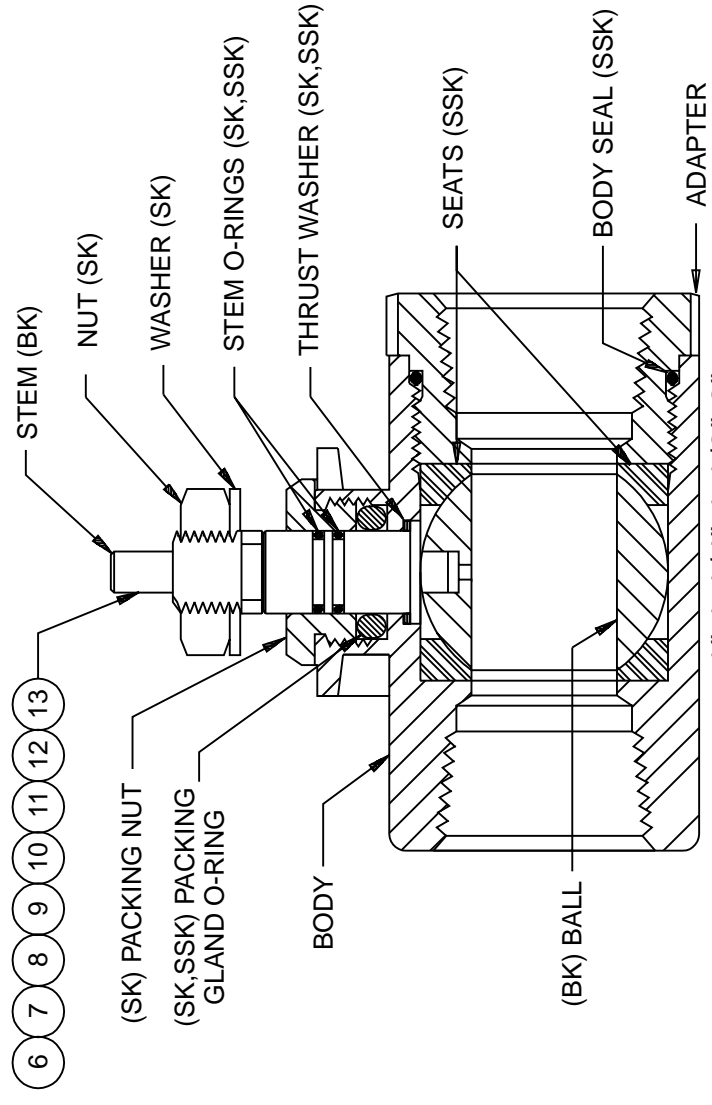


3/4", 1"
BRONZE
NO REPAIR KITS



DETAIL
OLD STYLE STEM

AIR OPERATED BALL VALVES



1", 1-1/4", 1-1/2", 2"
BRONZE & STAINLESS

(For Bracketry and Mounting Hardware, See BMP920005. For Air Cylinders that Operate Watts Ball Valves, See BMP920006.)

HOW TO USE THIS DRAWING:

The ball valves are separated by size, material, and type of operation. Find the cross section which shows your ball valve (example 1-1/2" bronze air operated). See the parts list for the item number which represents your ball valve (1-1/2" bronze air operated would be item 10 on the parts list). For valves that offer repair kits the internal parts are labeled and marked as to which kit they are found in:

- (BK) part of Ball Kit
- (SK) part of Stem Kit
- (SSK) part of Seat/Seal Kit

For the part number of the Seat/Seal Kit for item 10 (1-1/2" bronze air operated valve) see the parts list and look for item 10SSK, likewise the Stem Kit will be 10SK.
NOTE:

AIR OPERATED VALVES: (SSK) kits for air operated ball valves include all parts required to repair either our old style or new style stems. A packing nut seal is provided to repair our old style stems which had a seal in the packing nut (see Detail). Our new style stem uses a double o-ring design.



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BMP920007/96067V (2 of 2)

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Parts List—Watts Ball Valves and Repair Kits
Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.

Used In	Item	Part Number	Description	Comments
			ASSEMBLIES	
			none	
			COMPONENTS	
all	1	96D034	04Z BALLVALVE 1/2" WATTS #6400-SS	1/2"BRONZE-MANUAL, NO KITS
all	2	96D040WSS	01Z 1/2" BALLVALVE S/S WATTS#S-8000	1/2"STAINLESS-MANUAL
all	002BK	96V040BK	BALL KIT WATTS #BV4SSA6	
all	002SSK	96V040SSK	01Z REPKIT 1/2"VAL WATTS#3SSK-02-RK	
all	3	96D050A	01Z 3/4"BALLVALVE BRZ WATTS#B6100	3/4"BRONZE-MANUAL, NO KITS
all	4	96D055WSS	01Z 3/4"BALLVALVE S/S WATTS#S-8000	3/4"STAINLESS-MANUAL
all	004BK	96V055BK	BALL & STEM KIT WATTS #4BSK-SSRK	
all	004SSK	96V055SSK	01Z REPKIT 3/4"VAL WATTS#4SSK-02-RK	
all	5	96D084	01Z BALL VALVE 1" WATTS#B6100 BRZ	1" BRONZE-MANUAL , NO KITS
all	6	96D085WEXS	07Z BALVAL 1" BRZ WATTS#B6400SSZ107	1" BRONZE-AIR OPERATED
all	006BK	96V085BK	BALL KIT WATTS #1-BALL-RK-Z107	
all	006SK	96V085SK	02Z STEM KIT 1" WATTS#1-ST-RK-Z107	
all	006SSK	96V085SSK	02Z REPKIT 1"BALVAL#1SSK-02-KK-Z107	
all	7	96D085WSS	07Z BALVAL 1" SS WATTS S8000-Z107	1" STAINLESS-AIR OPERATED
all	007BK	96V085BK	BALL KIT WATTS #1-BALL-RK-Z107	
all	007SK	96V085SK	02Z STEM KIT 1" WATTS#1-ST-RK-Z107	
all	007SSK	96V085SSK	02Z REPKIT 1"BALVAL#1SSK-02-KK-Z107	
all	8	96D086WEXS	08Z BAVAL 1+1/4BRZ WATTS#B6400SSZ107	1-1/4"BRONZE-AIR OPERATED
all	008BK	96V086BK	BALL KIT WATTS #1.25-BALL-RK-Z107	
all	008SK	96V086A7SK	02Z STEMKIT 1.25-1.5-ST-RK-Z107	

Parts List, cont.—Watts Ball Valves and Repair Kits				
Used In	Item	Part Number	Description	Comments
all	008SSK	96V086SSK	02Z REPKIT 1.25BALVALSSK-02-RK-Z107	1-1/4"STAINLESS-AIR OPER.
all	9	96D086WSS	08Z BAVAL 1+1/4"SS WATTS S8000-Z107	
all	009BK	96V086BK	BALL KIT WATTS #1.25-BALL-RK-Z107	
all	009SK	96V086A7SK	02Z STEMKIT 1.25-1.5-ST-RK-Z107	
all	009SSK	96V086SSK	02Z REPKIT 1.25BALVALSSK-02-RK-Z107	
all	10	96D087WEXS	09Z BAVAL 1+1/2BRZ WATTS#B6400SSZ107	1-1/2"BRONZE-AIR OPERATED
all	010BK	96V087BK	BALL KIT WATTS #1.5-BALL-RK-Z107	
all	010SK	96V086A7SK	02Z STEMKIT 1.25-1.5-ST-RK-Z107	
all	010SSK	96V087SSK	02Z REPAIR KIT 1.5" BALL VALVE	
all	11	96D087WSS	08Z BAVAL 1+1/2"SS WATTS S8000-Z107	1-1/2"STAINLESS-AIR OPER.
all	011BK	96V087BK	BALL KIT WATTS #1.5-BALL-RK-Z107	
all	011SK	96V086A7SK	02Z STEMKIT 1.25-1.5-ST-RK-Z107	
all	011SSK	96V087SSK	02Z REPAIR KIT 1.5" BALL VALVE	
all	12	96D088WEXS	09Z BALVAL 2" BRZ WATTS#B6400SSZ107	2"BRONZE-AIR OPERATED
all	012BK	96V088BK	BALL KIT WATTS #2-BALL-RK-Z28	
all	012SK	96V088SK	03Z STEM KIT 2" WATTS#2-ST-RK-Z107	
all	012SSK	96V088SSK	02Z REPKIT 2"VAL WATZSSK-02-RK-Z107	
all	13	96D088WSS	09Z BALVAL 2" SS WATTS S8000-Z107	2"STAINLESS-AIR OPERATED
all	013BK	96V088BK	BALL KIT WATTS #2-BALL-RK-Z28	
all	013SK	96V088SK	03Z STEM KIT 2" WATTS#2-ST-RK-Z107	
all	013SSK	96V088SSK	02Z REPKIT 2"VAL WATZSSK-02-RK-Z107	