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Mechanical Parts and Service

5050 Shaker, Gas & Steam Dryers

PELLERIN MILNOR CORPORATION **Post Office Box 400, Kenner, Louisiana 70063–0400, U.S.A.**

Contents

Figures

Tables

1 General Service & Safety Related Components

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PELLERIN MILNOR CORPORATION
LIMITED STANDARD WARRANTY

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 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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WE NEITHER ASSUME, NOR AUTHORIZE ANY EMPLOYEE OR OTHER PERSON TO ASSUME FOR US, ANY OTHER RESPONSIBILITY AND/OR LIABILITY IN CONNECTION WITH THE SALE OR FURNISHING OF OUR EQUIPMENT TO ANY BUYER.

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1.1 How to Get the Necessary Repair Components

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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: 504-712-7775
Fax: 504-469-9777
Email: parts@milnor.com

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1.2 Trademarks

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These words are trademarks of Pellerin Milnor® Corporation and other entities:

Table 1. Trademarks

AutoSpot™	GreenFlex™	MilMetrix®	PulseFlow®
CBW®	GearTrace™	MilTouch™	RAM Command™
Drynet™	GreenTurn™	MilTouch-EX™	Recirc*ONE*®
E-P Express®	Hydro-cushion™	MilRAIL®	RinSave®
E-P OneTouch®	Mentor®	Miltrac™	SmoothCoil™

Table 1 Trademarks (cont'd.)

E-P Plus®	Mildata®	MilVision™	Staph Guard®
Gear Guardian®	Milnor®	PBW™	

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1.3 Safety — Pass Through Dryer

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1.3.1 Safety Alert Messages—Internal Electrical and Mechanical Hazards

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

WARNING: 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: 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: 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.

1.3.2 Cylinder and Processing Hazards

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1.3.3 Safety Alert Messages—Unsafe Conditions

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1.3.3.1 Hazards Resulting from Inoperative Safety Devices

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WARNING: 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: 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: 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: 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: 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.

1.3.3.2 Hazards Resulting from Damaged Mechanical Devices

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WARNING: 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.

1.3.4 Careless Use Hazards

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

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WARNING: 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: Goods Damage and Wasted Resources — Entering incorrect cake data can cause improper processing, routing, and accounting of batches.

- Understand the consequences of entering cake data.

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

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WARNING: 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: 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: 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.

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1.4 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 1.4.5 : If Water Flow Occurs, page 18.

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 1.4.1 : Fire Safety Functions and Components, page 13. You can also start it manually. Pull the operation handle or use the control panel as told in Section 1.4.4 : How to Do a Test of the Fire Safety System, page 17. 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.

1.4.1 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 2. Fire Safety Functions for 6464_ and 7272_ Dryer Models

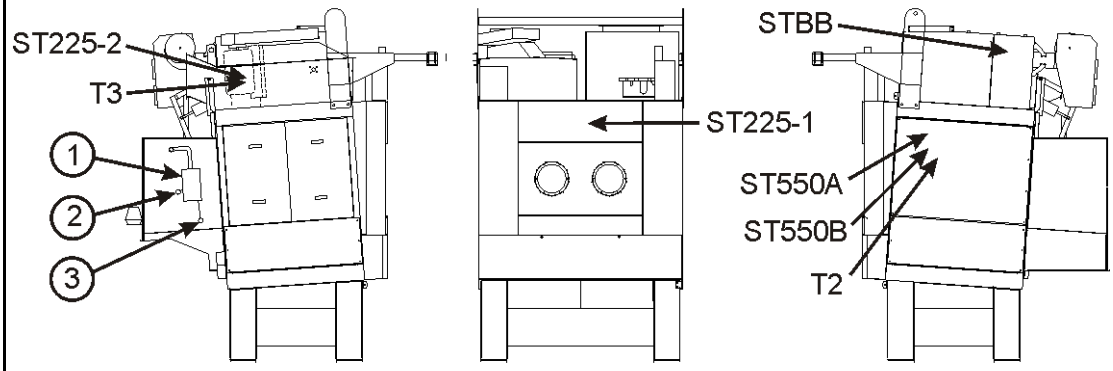
Sensor type	**Temperature switch (closes at specified temperature)**			**Thermocouple (gives continuous temperature data to the controller)**		
Sensor name	ST225-1 & 2	ST550A & B	STBB	T3		
Location	Basket/outlet duct (Figure 1, page 15, Figure 3, page 15, Figure 4, page 16)	Inlet duct Figure 1, page 15,Figure 2, page 15	At burner (Figure 1, page 15, Figure 5, page 16)	Outlet duct (Figure 3, page 15)		
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 1.4.5 : If Water Flow Occurs, page 18	If the error given in the line above this one occurs, see “Error Messages” in the operator guide.		See Section 1.4.2 : About the **Min Fire** and **Outlet Temperature Exceeded 220°** Faults, page 16		See Section 1.4.5 : If Water Flow Occurs, page 18

*** 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

Left, Front, and Right-side Views (model 6464TG1L shown)



Legend

ST225-1 . . Basket temperature switch (upstream of blower). The switch closes at 225° F (107° C).
ST225-2 . . Outlet temperature switch (downstream). The switch closes at 225°F (107°C).
ST550A . . Inlet temperature switch. This switch closes at 550° F (288° C).
ST550B . . Secondary inlet temperature switch. This switch closes at 550° F (288° C).
STBB . . Burner housing temperature switch. This switch closes at 175° F (79° C).
T2 . . Inlet temperature thermocouple. The fire safety system does not use this component.
T3 . . Outlet temperature thermocouple. This component gives temperature data to the controller.
1 . . . Sprinkler valve assembly
2 . . . Reset handle
3 . . . Operation handle

Figure 2. View of ST550A, ST550B and T2

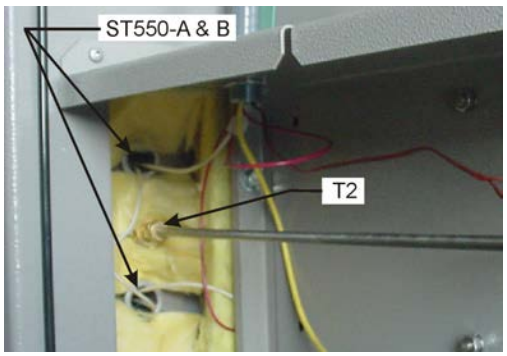


Figure 3. View of ST225-1

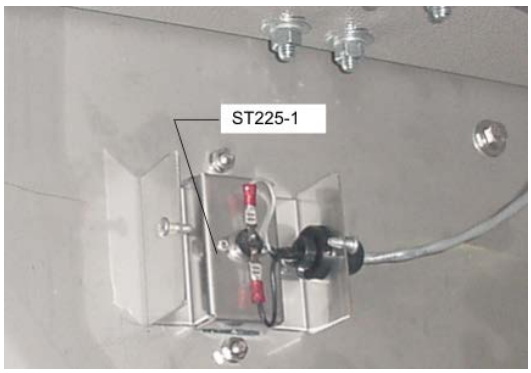


Figure 4. View of ST225-2 and T3

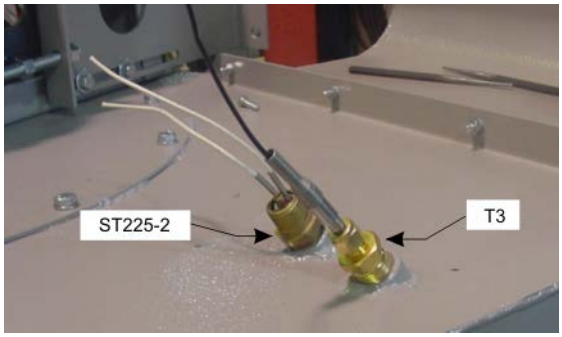
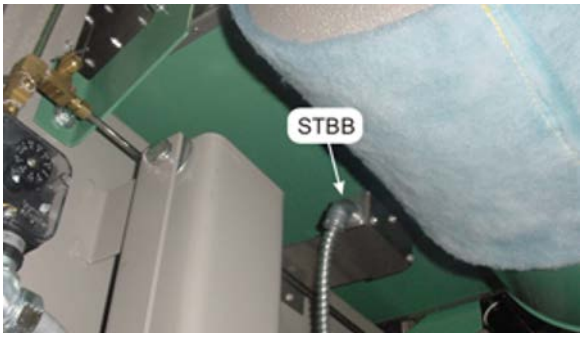


Figure 5. View of STBB



1.4.2 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®.

1.4.2.1 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.

1.4.2.2 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.

1.4.3 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 1.4.2.1 : Min Fire (MINF), page 16 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.

1.4.4 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. **Opereate 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.

1.4.5 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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Safety Placard Use and Placement

1 Sheet

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

NOTE: Replace placard immediately, if removed or unreadable. Approximate locations of placards are shown. If aluminum placard, mounting holes are provided on machine. Use #8 self-tapping screws.

Legend

A . . . Plan view – blower left and blower right, paired

B . . . Typical rear view

C . . . Left view service side of blower left model

D . . . Front view – blower left and blower right, paired

E . . . Right view service side of blower right model

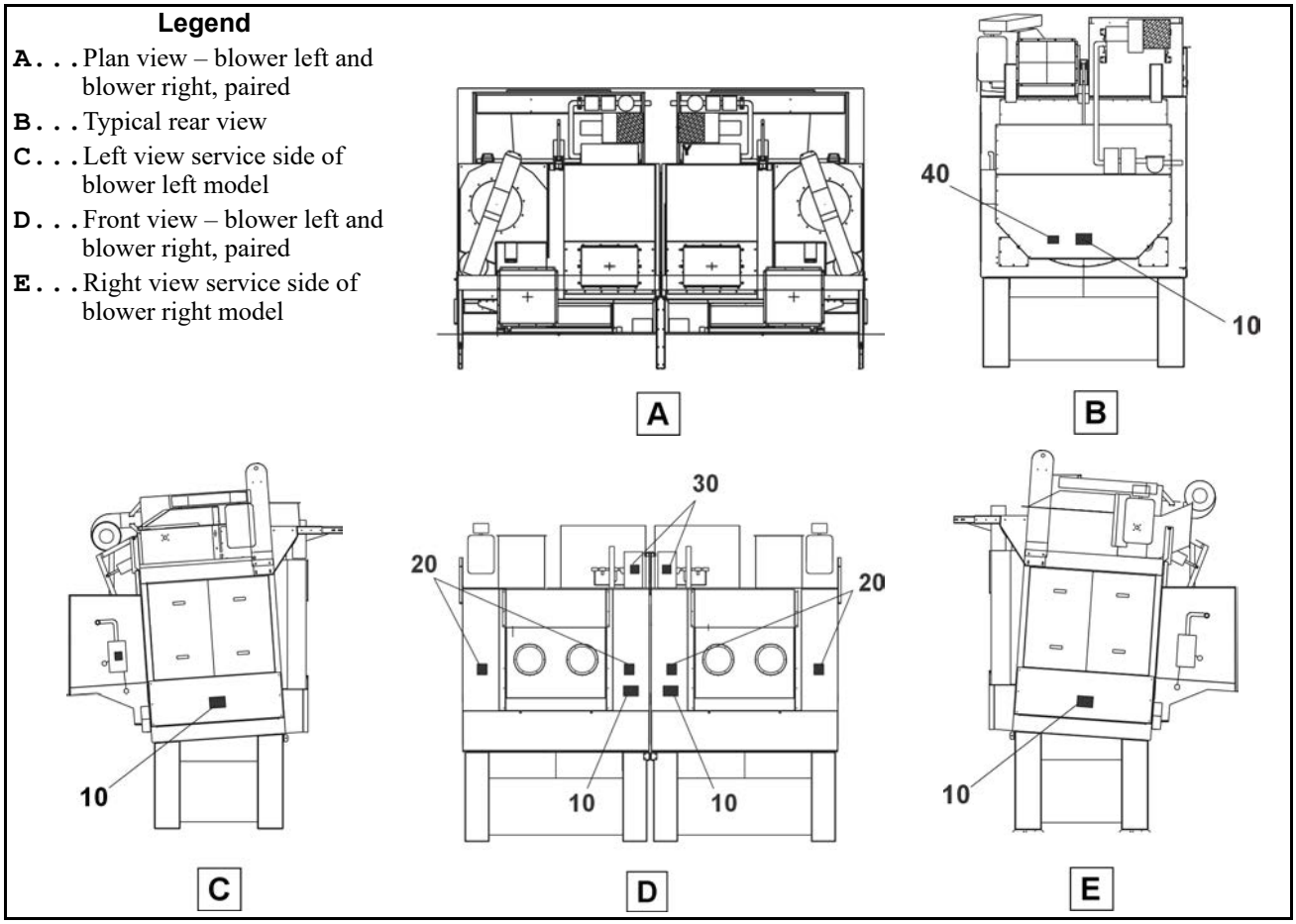

Table 3. Parts List—Safety Placard Use and Placement

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**
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	

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Safety Placard Use and Placement - ISO

1 Sheet

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

NOTE: Replace placard immediately, if removed or unreadable. Approximate locations of placards are shown. If aluminum placard, mounting holes are provided on machine. Use #8 self-tapping screws.

Legend

A . . . Plan view – blower left and blower right, paired

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D . . . Front view – blower left and blower right, paired

E . . . Right view service side of blower right model

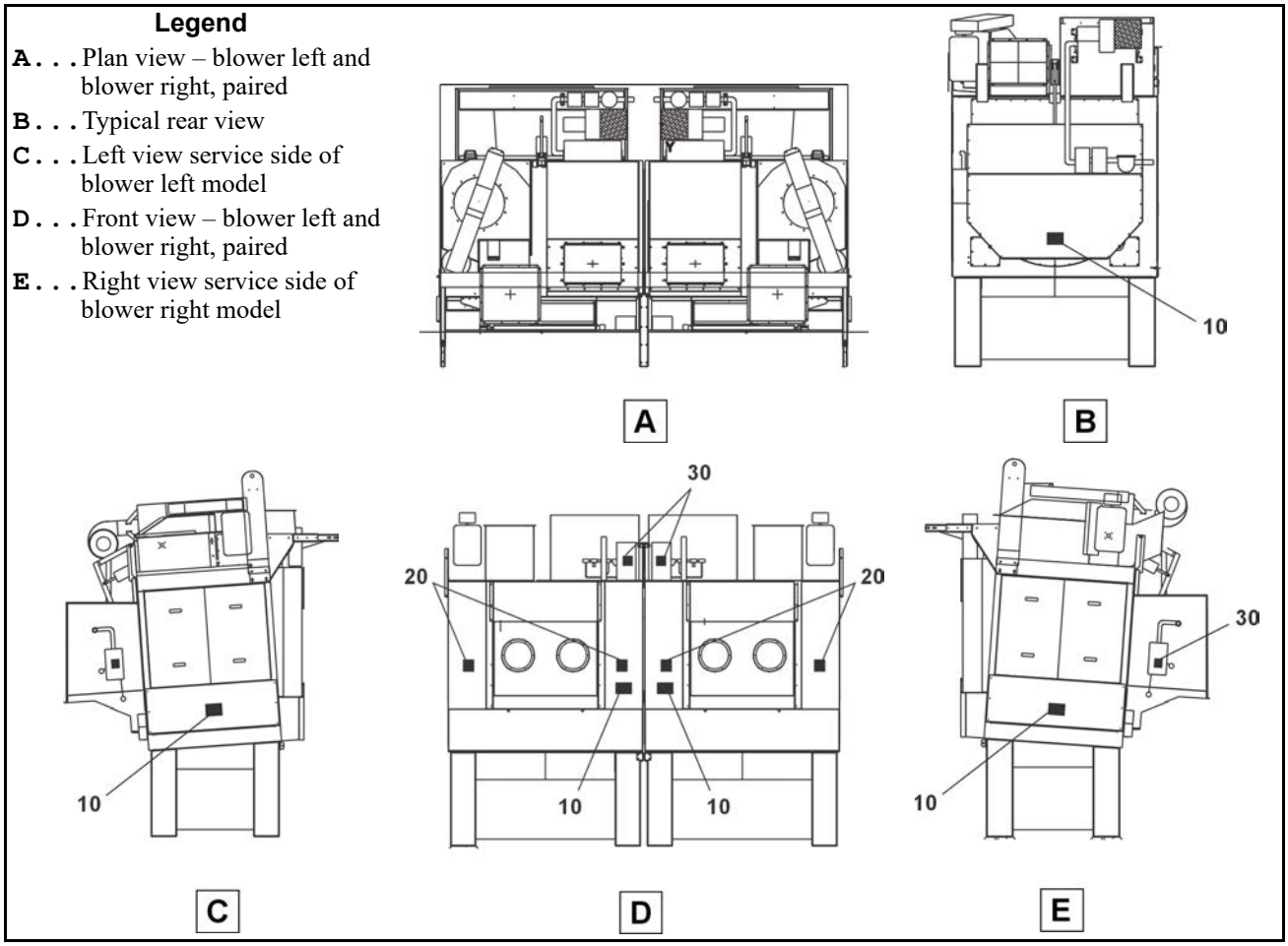

Table 4. Parts List—Safety Placard Use and Placement - ISO

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**
Components				
all	10	01 10451X	NPLT:DRYER WARNINGS -ISO	
all	20	01 10377	NPLTE:"WARNING" 4X4	
all	30	01 10375	NPLTE:"WARNING" 2X2	

2 Service & Maintenance

2.1 Set the Heating System—Air Heat Dryer

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This document applies to gas dryers with an *air heat* burner. See document BNDGUM02 for gas dryers with a *ratio air* burner.

2.1.1 About the Procedure

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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 5. 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 6. 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

2.1.2 Summary of Steps and Required Values (Air Heat)

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Values are displayed in inches of water (and millibar) except where indicated otherwise.

Table 7. Applicable Models

Step		Gauge Points [1]	5050TG_		6450TG_		6458TG_, 6464TG_		7272TG_	
			Fireye	L+G	Fireye	L+G	Fireye	L+G	Fireye	L+G
1	Static (incoming) gas pressure [2]	GGS	13.5 (33.6)	13.5 (33.6)	13.5 (33.6)	13.5 (33.6)	13.5 (33.6)	13.5 (33.6)	13.5 (33.6)	13.5 (33.6)
2	Combustion air pressure	GAC and GRC	0.4 (1)	0.14 (.35)	0.6 (1.5)	0.6 (1.5)	0.6 (1.5)	0.6 (1.5)	0.6 (1.5)	0.6 (1.5)
	Combustion air damper		full open	full open	0.9 (.22)	0.9 (.22)	0.9 (.22)	0.9 (.22)	0.9 (.22)	0.9 (.22)
3	Main air pressure test		—	—	1.6 (4)	1.6 (4)	1.6 (4)	1.6 (4)	1.6 (4)	1.6 (4)
	Main air pressure final	GAM	0.7 (1.7)	0.7 (1.7)	2.4 (6)	2.4 (6)	2.4 (6)	2.4 (6)	2.4 (6)	2.4 (6)
4	Pilot gas regulator	GGP	1.3 (3.2)	1.3 (3.2)	1.6 (4)	1.3 (3.2)	1.6 (4)	1.3 (3.2)	1.6 (4)	1.3 (3.2)

Table 7 Applicable Models (cont'd.)

Step		Gauge Points [1]	5050TG_		6450TG_		6458TG_, 6464TG_		7272TG_	
			Fireye	L+G	Fireye	L+G	Fireye	L+G	Fireye	L+G
	Pilot flame – natural gas		1 (2.5)	1 (2.5)	1 (2.5)	1 (2.5)	1 (2.5)	1 (2.5)	1 (2.5)	1 (2.5)
	Pilot flame – propane	n.a.	—	—	Turn adjusting screw one full turn.				—	—
	Outlet pressure spring – propane only	n. a.	—	—	1.3 (3.2)				—	—
5	**Gas regulator**	GGR	4.5 (11.2)	4.5 (11.2)	6.5 (16.2)	6.5 (16.2)	6.5 (16.2)	6.5 (16.2)	5.5 (13.7)	5.5 (13.7)
6	**Minimum fire temperature ABOVE AMBIENT**	n. a.	**Natural gas:** 70º F (21º C) to 80º F (27º C) (view on display)							
		n. a.	—	—	**Propane:** Set minimum fire (min Y) on the modulating gas valve to 17				—	—
	Damper setting	n. a.	Set damper position to 2							
7	**High gas pressure**	GGH	5.6 (14)	5.6 (14)	8.13 (20.3)	8.13 (20.3)	8.13 (20.3)	8.13 (20.3)	6.87" (17.1)	6.87" (17.1)
8	**Low gas pressure**	GGL	2.25 (5.6)	2.25 (5.6)	3.25 (8)	3.25 (8)	3.25 (8)	3.25 (8)	2.75 (6.8)	2.75 (6.8)
9	**Burner box pressure**	GAB	0.06 (0.15)	0.04 (1)	0.06 (0.15)	0.06 (0.15)	0.06 (0.15)	0.06 (0.15)	0.06 (0.15)	0.06 (0.15)
10	**Back 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)

1. The reference point is atmosphere unless two values are shown for the gauge point.
2. Must not exceed. A pressure that exceeds the maximum can damage the regulator.

2.1.3 Component Locations

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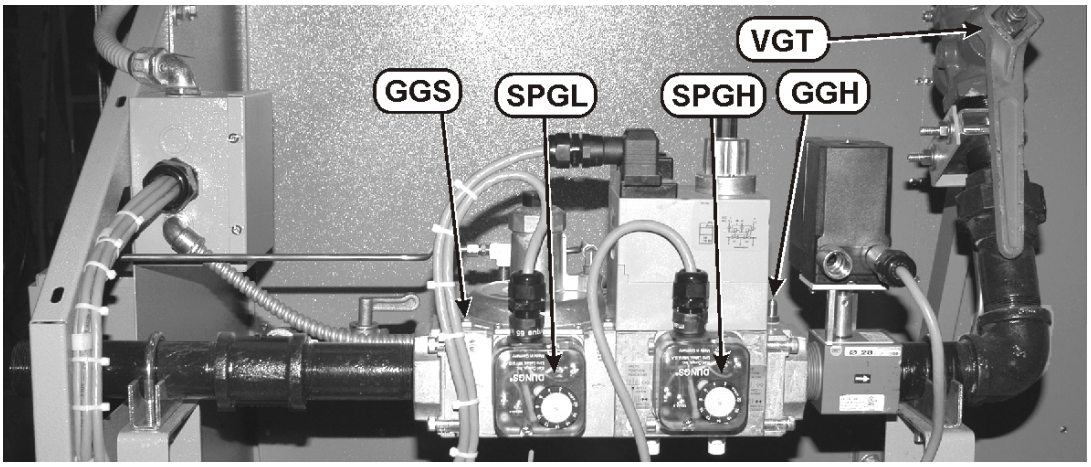
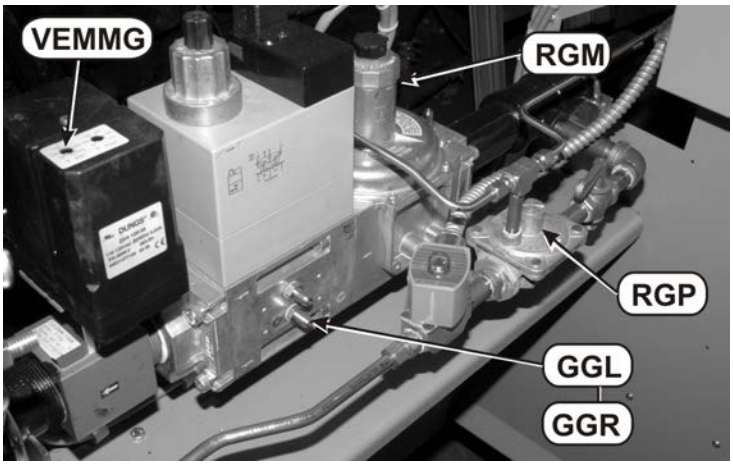
Figure 6. Gas Adjustment Components (5040TG2_ shown. Other models are similar.)

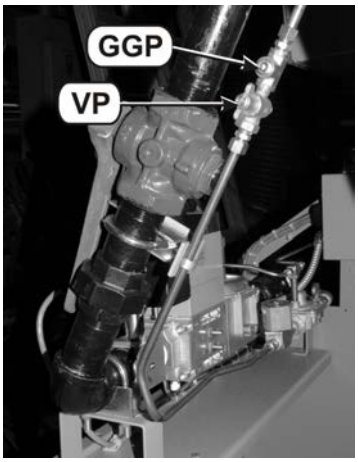
Front View



Rear View



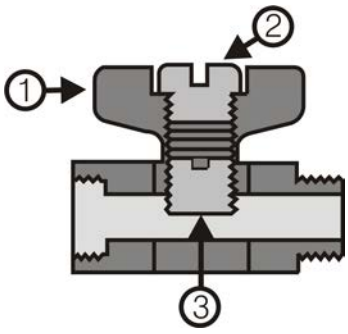
Pilot Line



Legend

1. Handle (shown in open position)
2. Cover screw
3. Adjustment screw
4. **GGS** - Static (incoming) gas pressure gauge point
5. **GGH** - Maximum main gas pressure gauge point
6. **GGL** - Minimum main gas pressure gauge point
7. **GGR** - Regulated main gas pressure gauge point
8. **GGP** - Pilot gas pressure gauge point
9. **RGM** - Main gas regulator
10. **RGP** - Pilot gas regulator
11. **SPGL** - Low gas pressure switch
12. **SPGH** - High gas pressure switch
13. **VEMMG** - Modulating gas valve (adjustment screw)

Pilot Gas Cock (VP)

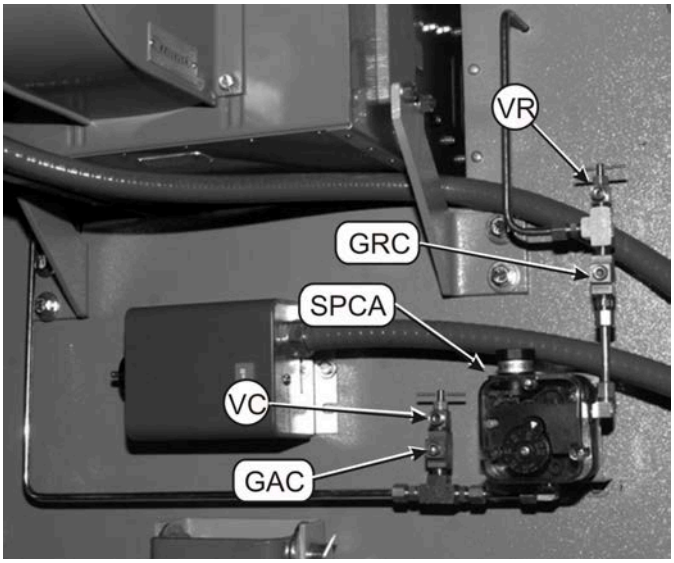


Gas Adjustment Components (5040TG2_ shown. Other models are similar.) (cont'd.)

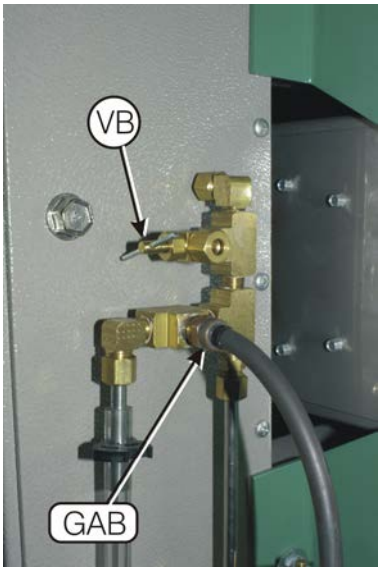
14. **VGT** - Manual test valve 15. **VP** - Pilot gas cock	

Figure 7. Air Adjustment Components (5040TG2_ shown. Other models are similar.)

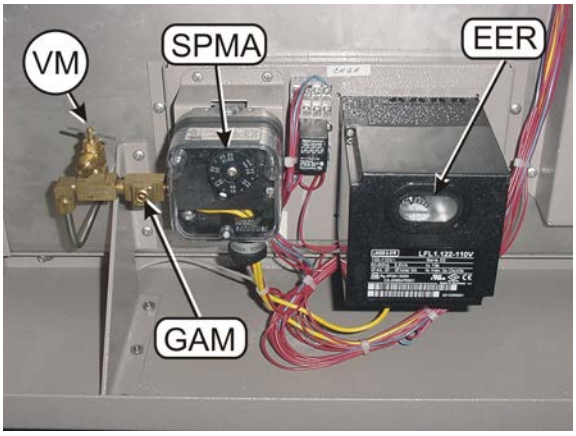
Combustion Air



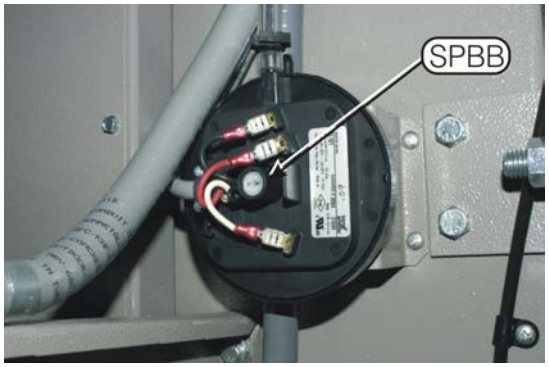
Burner Box Air



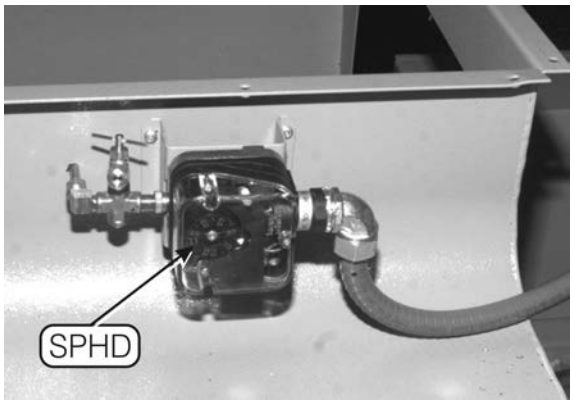
Main Air (Landis + Gyr shown)



Burner Box Pressure Switch



Back Pressure Switch



Legend

1. **GAB** - Burner box air pressure gauge point
2. **GAC** - Combustion air primary gauge point
3. **GRC** - Combustion air reference gauge point
4. **GAM** - Main air gauge point
5. **VB** - Burner box air pressure needle valve
6. **VC** - Combustion air primary needle valve
7. **VR** - Combustion air reference needle valve
8. **VM** - Main air needle valve
9. **SPBB** - Burner box pressure switch (adjustment screw)
10. **SPCA** - Combustion air pressure switch
11. **SPHD** - Back pressure switch
12. **SPMA** - Main air pressure switch
13. **EER** - Landis + Gyr flame control reset

2.1.4 Setup Methods—Fireye or Landis + Gyr Flame Control

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Do Step 1 (see Section 2.1.5 : Adjustment Steps, page 31) before you perform one of the setup methods described in this section. Perform the appropriate setup method before you start Step 2. If your machine has a Fireye flame control, use the **Setup mode** (see Section 2.1.4.1 : Setup Mode (Fireye flame control), page 29). If your machine has a Landis + Gyr flame control, use the **Manual method** (see Section 2.1.4.2 : Manual method (Landis + Gyr flame control), page 30).

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

- You must be an approved technician.
- Make sure you can quickly shut off gas at an external valve.

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

- Leave electrical power disconnected from the machine while you work on it, except where stated otherwise in this document.
- Use extreme caution when you work around moving components.

2.1.4.1 Setup Mode (Fireye flame control)

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Display or Action	Explanation
WAITING FOR LOAD **********	The display after the power up sequence
MANUAL	Accesses **manual mode** menu (press CANCEL to return to automatic).
RETURN TO AUTOMATIC 00	Shows the display in **manual mode**
1 2	Selects the **setup procedure**
SETUP PROCEDURE 12	
ENTER	Accesses **setup mode A** (or the next mode in sequence)

Whenever the next setup mode is required, press ENTER and resulting display will be shown.

For a **quick return to run** mode from **setup procedure**

ENTER, ENTER, etc.	Advances through each of the six setup modes. Note, however, that the control requires waiting eight seconds in **mode C** and five seconds in **mode D**.
SETUP PROCEDURE 12	Resulting display

0, 0	Selects “RETURN TO AUTOMATIC”
ENTER	Returns to the run mode

2.1.4.2 Manual method (Landis + Gyr flame control)

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If your machine has a Landis + Gyr flame control, run a dry code manually and set the damper position to 2, as explained below.

Display or Action	Explanation
WAITING FOR LOAD **********	The display after the power up sequence.
MANUAL	Accesses the **manual load** menu
SELECT DRY CODE 00 REDRY	
ENTER	Accepts the default dry code 00 and prompts for load size
ENTER LOAD SIZE 0 FULL LOAD	
ENTER	Accepts the default load size (full load).
LOAD DRYER WITH REDRY	Ignore this prompt.
ENTER	Starts the cycle.
LOADING	This display appears.
00F TIC TOC 000 VP xx xxxAxxx xxx xxx	This display appears. The VP value alternates with an air value.

Wait for the burner to ignite.

MANUAL	Stops the timer and accesses the manual control panel for temperature, damper and basket rotation.
TICHTOC LDA MVP BSPD xxx+xxx x0x 0x xxxx	
DAMPER + ↑	Sets the damper position. Hold the keys until the damper position (D) = 2.
TICHTOC LDA MVP BSPD xxx+xxx x2x xxx 000	
MOD VALVE POSITION + ↓	Closes the modulating gas valve (position). Hold the keys until MVP = 000.
TICHTOC LDA MVP BSPD xxx+xxx x2x 000 xxxx	

The burner will remain on at minimum fire (MVP=000) until commanded to return to automatic. Start Step 2 here. Upon completion of the steps,

CANCEL Returns to automatic

2.1.5 Adjustment Steps

BNDGUM01.C07 0000337473 A.3 A.4 D.2 4/6/21, 11:59 AM Released

Refer to Section 2.1.2 : Summary of Steps and Required Values (Air Heat), page 24 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.

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

- Work with electrical power removed from the machine, except where stated otherwise in this document.
- Use extreme caution when you work near moving components.

2.1.5.1 Step 1: Static (incoming) gas pressure

BNDGUM01.C08 0000337472 A.3 A.4 D.2 3/24/21, 9:39 AM Released

1. Remove electrical power and gas from the machine.
2. Look at Figure 6, page 26. Attach one side of the manometer to gauge point **GGS** (the higher pressure). Leave the other side open to the atmosphere.
3. Supply gas to the machine.
4. Adjust the incoming gas (upstream from dryer) as close as possible to the maximum static gas pressure listed in Section 2.1.2 , page 24. This pressure is necessary for further adjustments. Pressures higher than specified can damage the regulator.

2.1.5.2 Step 2: Combustion air pressure

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Fireye Start the Setup procedure and select SETUP MODE A (Section 2.1.4.1 , page 29) . The combustion air motor runs. The main air pressure switch, modulating gas valve and the two main gas valves are disabled.

Landis + Gyr Start the Manual method (Section 2.1.4.2 , page 30). If the flame control trips during this procedure, press = and ✂ to reset it.

In this step, you will measure a small differential pressure. It is necessary to mount the manometer near horizontal and use the low pressure scale.

1. Look at Figure 7, page 28. Turn the dial on **SPCA** counterclockwise to the lowest value.

2. Attach one end of the manometer to the gauge point **GAC** (the higher pressure). Attach the other side to the gauge point **GRC** (the lower pressure).
3. Adjust **VR** until the manometer displays the value shown in Section 2.1.2 , page 24. If you cannot get the required value with **VR** wide open, slowly open **VC** until you get the required value.
4. Look at the burner box pressure light ( ) on the status light panel. Slowly turn the dial **SPCA** clockwise:

Fireye Stop when the light illuminates.
Landis + Gyr Stop when **SPCA** trips and the burner extinguishes. The light should illuminate momentarily, but this may be too quick to see. Press and to reset the flame control.

5. Close **VR** and **VC** fully.

2.1.5.3 Step 3: Main air pressure

BNDGUM01.T02 0000337470 A.4 D.2 5/12/21, 2:30 PM Released

Fireye machines Select SETUP MODE B (see Section 2.1.4.1 , page 29). The damper will fully open.
Landis + Gyr machines Set the damper fully open (D=0). See Section 2.1.4.2 , page 30.

1. Look at Figure 6, page 26. Turn the dial on **SPMA** counterclockwise, to the lowest value
2. Attach one side of the manometer to **GAM** (the lower pressure). Leave the other side open to the atmosphere (the higher pressure).
3. Adjust **VM** until the manometer displays the test value shown in Section 2.1.2 , page 24.
4. Look at the burner box pressure light ( ) on the status light panel. Very slowly turn the dial on **SPMA** clockwise:

Fireye machines Stop when the light illuminates.
Landis + Gyr machines Stop when **SPMA** trips and the burner extinguishes. The light should illuminate momentarily, but this may be too quick to see. Press and to reset the flame control.

5. Close **VM** fully. The manometer should display the final value shown in Section 2.1.2 , page 24.

2.1.5.4 Step 4A: Regulated pilot gas pressure

BNDGUM01.T03 0000338555 A.3 A.4 D.2 3/24/21, 9:39 AM Released

Fireye machines Select SETUP MODE C (see Section 2.1.4.1 , page 29). This turns on the **pilot gas valve**. After about eight seconds, the pilot flame should ignite.
Landis + Gyr machines No action is necessary. The pilot flame should be lit.

Explosion and Fire Hazard Improper procedures can release gas.

- Follow instructions carefully.

1. Look at Figure 6, page 26. Attach one side of the manometer to **GGP** (the higher pressure). Leave the other side open to the atmosphere.

2. Remove the cover screw (2) from **VP**.
3. 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.**
4. Adjust **RGP** until the manometer displays the value specified Section 2.1.2 , page 24.

2.1.5.5 Step 4B: Pilot flame gas pressure

BNDGUM01.T04 0000338566 A.2 A.4 D.2 3/24/21, 9:39 AM Released

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

1. Look at Figure 6, page 26. Leave the manometer connected to **GGP** and to the atmosphere.
2. Close **VGT**.
3. Turn the adjustment screw (3) on **VP** clockwise, until the manometer shows the value specified in Section 2.1.2 , page 24.
4. Replace the cover screw (2) in **VP**.
5. Open **VGT**.

2.1.5.6 Step 5: Regulated main gas pressure

BNDGUM01.T05 0000338565 A.3 A.4 D.2 3/24/21, 9:39 AM Released

Make adjustment quickly. The machine will reach the maximum permitted temperature quickly and shut-off the burner. If a switch trips during this step, press and .

Fireye Select SETUP MODE D (see Section 2.1.4.1 , page 29). This turns on the **two main gas valves**. The **modulating gas valve** opens and modulates to position 100.

Landis + Gyr Set the modulating gas valve to position 100 (MVP=100). See Section 2.1.4.2 , page 30.

1. Make sure **VGT** is open fully
2. Look at Figure 6, page 26. Attach one side of the manometer to **GGR** (the higher pressure). Leave the other side open to the atmosphere.
3. Turn the dial on **SPGL** counterclockwise to the lowest value. Turn the dial on **SPGH** clockwise to the highest value.
4. Adjust **RGM** until the manometer displays the value specified in Section 2.1.2 , page 24.

If you are performing the entire adjustment procedure, you will set **SPGH** and **SPGL** in steps 7 and 8 respectively. If you performed this step as part of a component replacement, do steps 7 and 8 as well.

2.1.5.7 Step 6: Low fire temperature

BNDGUM01.T06 0000338564 A.3 A.4 D.2 3/24/21, 9:39 AM Released

Fireye machines Select SETUP MODE E (see Section 2.1.4.1 , page 29). This sets the modulating gas valve to 000 and displays the inlet temperature.

Landis + Gyr machines Set the modulating gas valve to position 000 (MVP=000). See Section 2.1.4.2 , page 30.

1. Look at Figure 6, page 26. Turn the adjustment screw on **VEMMG** (arrow points to this screw) fully counterclockwise.
2. **In small increments** turn the screw clockwise until the control panel display shows a temperature in the range specified in Section 2.1.2 , page 24. It is necessary to wait for the display to settle after each adjustment. This task can take several minutes due to the lag time between when you make the adjustment and when the change in temperature appears on the display.

2.1.5.8 Step 7: High gas pressure

BNDGUM01.T07 0000338595 A.3 A.4 D.2 4/5/21, 4:26 PM Released

Fireye machines Select SETUP MODE E (see Section 2.1.4.1 , page 29). This sets the modulating gas valve to 000 and displays the inlet temperature.

Landis + Gyr machines Set the modulating gas valve to position 000 (MVP=000). See Section 2.1.4.2 , page 30.

1. Look at Figure 6, page 26. Turn the dial on **SPGH** clockwise to the highest value.
2. Attach one side of the manometer to **GGH** (the higher pressure). Leave the other side open to the atmosphere.
3. Start with **VGT** open. Slowly close **VGT** until the manometer displays the value specified in Section 2.1.2 , page 24.
4. Look at the gas pressure high light ( ) on the status panel. Slowly turn the dial on **SPGH** counterclockwise (lower). Stop when the switch trips and the burner extinguishes.

Fireye machines The status light illuminates briefly, then blinks. Open the manual test valve again. The burner will ignite as soon as pressure is restored. Press and to extinguish the status light.

Landis + Gyr machines The status light should illuminate momentarily, but this may be too quick to see. The flame control automatically resets and attempts to ignite the burner.

5. Verify the proper adjustment: Open **VGT** fully. Watch the manometer. Slowly close **VGT**. **SPGH** should trip when the set value is reached.
6. Open **VGT** fully.

2.1.5.9 Step 8: Low gas pressure

BNDGUM01.T08 0000338608 A.4 D.2 4/5/21, 4:27 PM Released

Fireye machines Select SETUP MODE E (see Section 2.1.4.1 , page 29). This sets the modulating gas valve to 000 and displays the inlet temperature.

Landis + Gyr machines Set the modulating gas valve to position 000 (MVP=000). see Section 2.1.4.2 , page 30.

1. Look at Figure 6, page 26. Turn the dial on **SPGL** counterclockwise to the lowest value.
2. Attach one side of the manometer to **GGL** (the higher pressure). Leave the other side open to the atmosphere.
3. Start with the **external gas shut-off valve** open. Slowly close this valve until the manometer displays the value specified in Section 2.1.2 , page 24.

4. Look at the gas pressure low light ( ) on the status light panel. Slowly turn the dial on **SPGL** clockwise (higher). Stop when **SPGL** trips and the burner extinguishes.
5. Open **external gas shut-off valve** fully.

Fireye machines The status light illuminates briefly, then blinks. The burner should ignite as soon as pressure is restored. Press and to extinguish the status light.

Landis + Gyr machines The status light should illuminate momentarily, but this may be too quick to see. The flame control automatically resets and attempts to ignite the burner.

2.1.5.10 Step 9: Minimum burner box air pressure

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Fireye machines Select SETUP MODE E (see Section 2.1.4.1 , page 29). This sets the modulating gas valve to 000 and displays the inlet temperature.

Landis + Gyr machines Set the modulating gas valve to position 000 (MVP=000). See Section 2.1.4.2 , page 30.

1. Look at Figure 7, page 28. Attach one side of the manometer to **GAB** (the lower pressure) and leave the other side open to the atmosphere.
2. Remove the cover from **SPBB**. Carefully turn the center adjustment screw (white potentiometer that the arrow points to) counterclockwise until the top of the screw is level with the collar. **Do not allow the adjustment screw to come out of the switch. The screw is spring loaded.**
3. Adjust **VB** until the manometer shows the value specified in Section 2.1.2 , page 24.
4. Look at the burner box pressure light ( ) on the status light panel. Slowly turn the adjustment screw on **SPBB** clockwise until the status light illuminates and the burner extinguishes.
5. Close **VB** fully.

2.1.5.11 Step 10: Maximum back (air) pressure

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The dial on **SPHD** (see Figure 7, page 28) is set at the factory to the value specified in Section 2.1.2 , page 24. 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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2.2 About The Steam and Hot Oil Control Systems for Milnor® Dryers

BNDTUM01.C01 0000532848 A.1 B.2 A.4 11/14/22, 8:50 AM Released

Milnor® steam dryers are available with an optional y-type on/off steam valve. Milnor® hot oil dryers use a modulating oil inlet/bypass valve.

2.2.1 How to Protect Steam Coils from Water Hammer Damage

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Steam coils can be damaged when steam pressure is suddenly applied to a water (condensate) filled coil, or when the steam is "wet" with a high water content. The damage occurs because the condensate is forced through the coils with great speed causing a water hammer condition which can be likened to many jack hammers inside the coil. The result will be damaged coils, especially at the ends where the water must turn quickly.

CAUTION: Steam coils making a popping sound or cracking sound — are in grave danger of serious water hammer damage. Steam coils that have been damaged by water hammer are not warrantied.

- Maintain the bypass piping (machines with optional on/off valve, Figure 8: Standard Steam Piping, page 38) in good working order, to prevent cracking and popping sounds when steam is turned on. Do not operate dryer unless bypass piping is in good working order.
- If a steam trap must be replaced, be sure the pressure rating of the replacement trap is suitable for the steam pressure in your plant and that the replacement trap's capacity is equivalent to the original equipment.

CAUTION: Dryers with steam traps rated 85-180 psi (6-12 atu) will not operate properly below 60 psi (4 atu). Steam traps rated 160-225 psi (11-15 atu) will not operate properly below 115 psi (8 atu). These pressure ranges refer only to the range of pressures through which the trap may be reasonably expected to operate properly. They are not necessarily an indication of the safe operating pressure for the steam coil. Always refer to the nameplate for the specific dryer to determine the maximum permissible pressures.

2.2.2 About The Standard Steam Control System

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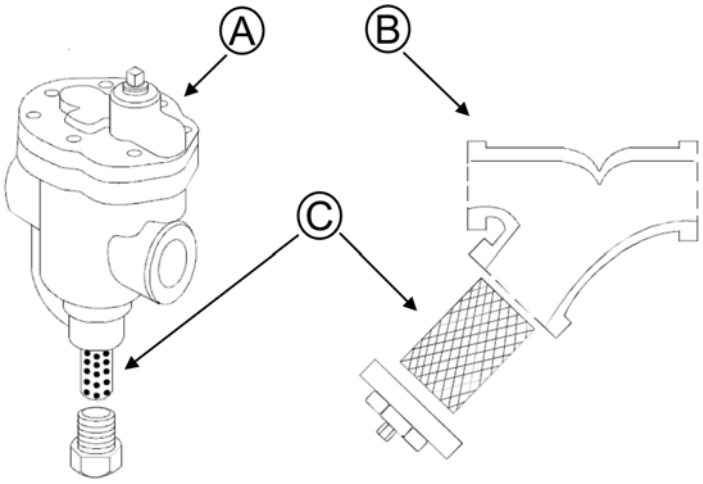
Each dryer has a strainer and steam trap (Figure 8: Standard Steam Piping, page 38), to handle steam that condenses in the coil as it heats the passing air which dries the goods.

CAUTION: Clean and "blow down" steam trap and strainer screens after 40 hours of operation and periodically thereafter. Clogged strainer screens will cause longer drying times.



Legend

A . . . Steam trap
B . . . Condensate Y strainer
C . . . Remove screen and clean

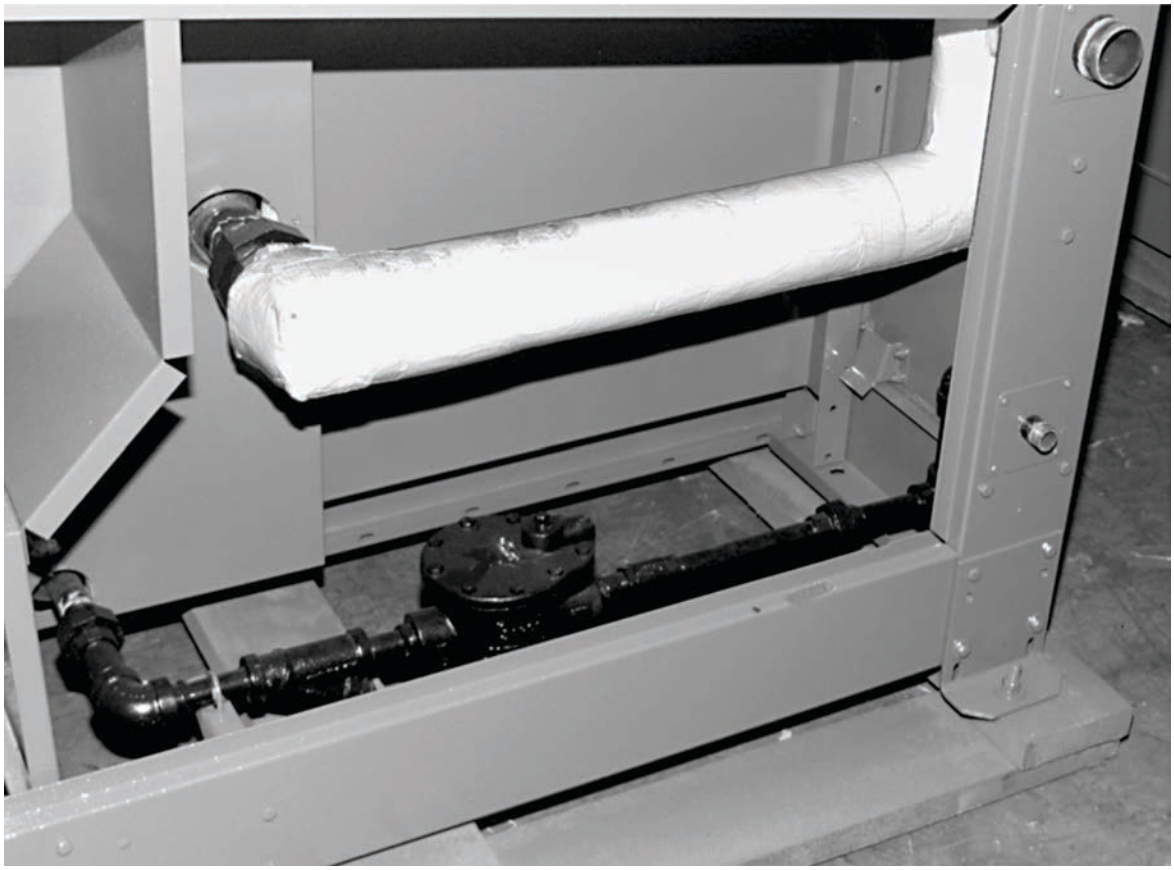
2.2.3 About The Optional On-Off Steam Control System with Y-Type, Air Operated Valve

BNDTUM01.C04 0000532845 B.2 A.4 6/5/25, 9:46 AM Released

In addition to the steam trap and strainer, dryers equipped with the optional main steam inlet on/off valve are fitted with:

1. A steam inlet valve which is open whenever the dryer is drying (whenever the cooldown by-pass damper is closed). This normally closed (air-to-open) valve shuts off the flow of steam to the dryer during cooldown, if the dryer master switch is off, and whenever the dryer is not being used.
2. Bypass piping to keep coils warm and condensate minimized while the main steam inlet valve is off, but machine is in standby, with steam provided to the machine.

Figure 8. Standard Steam Piping



2.2.4 About the Modulating Hot Oil Valve

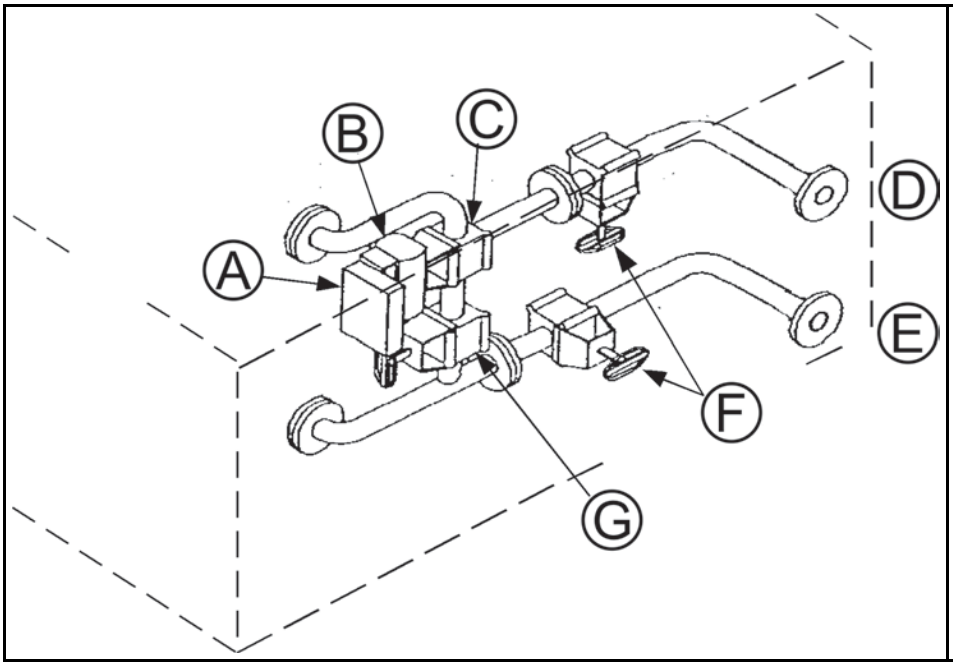
BNDTUM01.C05 0000532844 A.3 B.2 A.4 6/5/25, 9:46 AM Released

2.2.4.1 How Modulated Hot Oil Works

BNDTUM01.C06 0000532843 B.2 A.4 6/5/25, 9:46 AM Released

Hot air inlet and outlet temperatures are monitored by the dryer control. When the dryer control detects actual temperatures that are either under or over the desired value, it signals the hot oil positioner and valve to change the percent of pressurized hot oil sent to the dryer heating coil, versus the percent that bypasses the heating coil. All oil is returned to the oil heater.

Figure 9. Hot Oil Piping



Legend

A . . . Valve positioner
B . . . Valve actuator
C . . . Hot oil modulating valve
D . . . In
E . . . Out
F . . . Shut off valves (if so equipped)
G . . . Bypass

2.2.4.2 How to Manually Command a Modulating Valve Position

BNDTUM01.C07 0000532842 A.3 B.2 A.4 6/5/25, 9:46 AM Released

This procedure applies to hot oil machines.

1. Shut off oil to dryer.
2. Turn dryer on.

Display or Action	Explanation
WAITING FOR LOAD **********	After the power-up sequences, the display shows this screen.
SELECT DRYCODE 00 REDRY	MANUAL LOAD Accesses manual load menu

For Quick Return to Automatic from Manual Load menu

WAITING FOR LOAD *	CANCEL, ESCAPE, CANCEL, ESCAPE **etc** Returns to automatic
ENTER LOAD SIZE 0 FULL LOAD	ENTER NEXT **Accepts the default drycode 00** and prompts for load size.
LOAD DRYER WITH REDRY	ENTER NEXT **Accepts the default load size** (full load) and prompts the operator to load dryer. Ignore this prompt.
LOADING	ENTER NEXT **Starts the cycle.** When loading sequence ends, display appears as shown below.

00F TIF TOF 000 VP XXX XXXAXXX XXX XXX	Alternates with . . .
00F TIF TOF 0021 AIR XXX XXXDXXX XXX	
TIFHTOF LDA MVP BSPD XXX+XXX XXX XXX XXXX	MANUAL **Stops the timer and accesses the manual control panel** for temperature, damper, and basket rotation.
hold MOD VALVE POSITION + ↓	Closes modulating valve position. Hold keys until MVP=000.
TIFHTOF LDA MVP BSPD XXX+XXX XXX 000 XXXX	Dryer will continue at minimum valve position until commanded to return to automatic.
CANCEL ESCAPE	Returns to automatic.

Follow the step-by-step procedure to set the system components.

2.2.4.3 When Recalibration is Required

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The hot oil positioner and valve are calibrated prior to shipping, replacing either component necessitates re-calibration. To recalibrate:

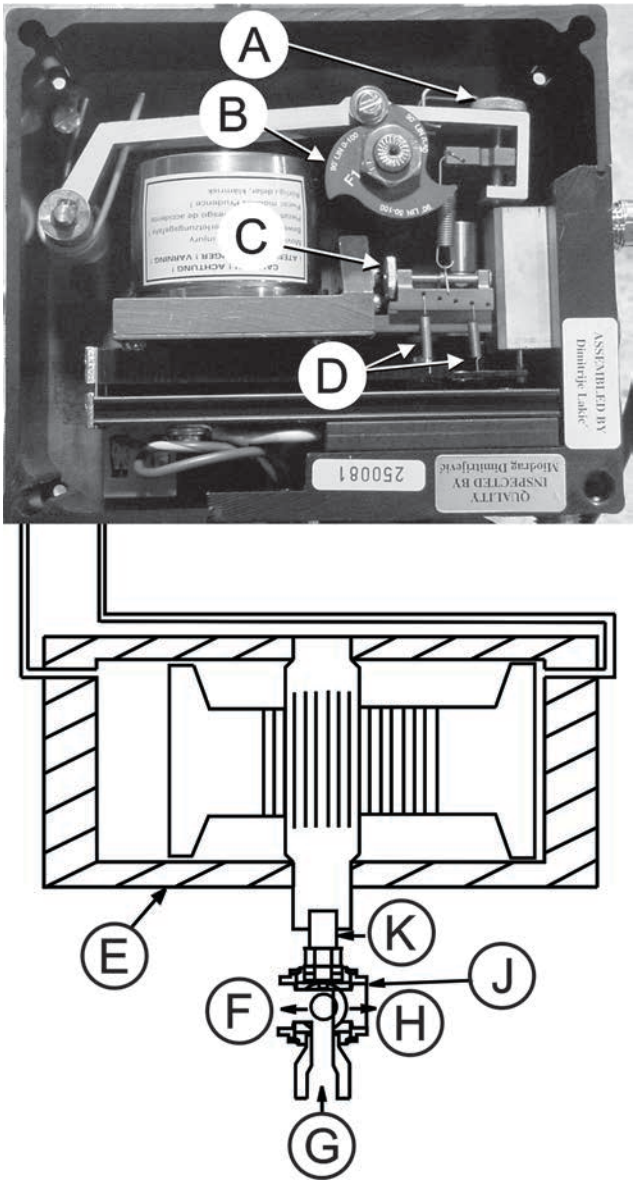
DANGER: Shock Hazard — Electrical power can cause death or severe injury. Lock off and tag out power to the dryer main bus at the wall disconnect before servicing.

1. Turn machine off, lock off and tag out.

WARNING: Burn Hazard — Hot surfaces will cause severe burns. Shut off and tag out hot oil flow to dryer at external shut-off valve and allow piping to cool before servicing.

2. Shut off the hot oil to the dryer, tag out external valve.
3. Remove the valve positioner covers and the position indicator dial.
4. Verify that the lower arm bearing rests on the portion of the cam labeled 0-100%. See Figure 11: Cam Setting at Modulating Valve Position 000, page 42 .
5. Check that two gain suppression springs are mounted in positions 1 and 4 (as shown in Figure 10: Hot Oil Modulating Valve and Positioner, page 41).

Figure 10. Hot Oil Modulating Valve and Positioner



Legend

A . . . Zero adjustment
B . . . Cam (under dial)
C . . . Range adjustment
D . . . Gain suppression springs
E . . . Valve actuator
F . . . Bypass
G . . . Hot oil
H . . . Coil
J . . . Modulating valve
K . . . Valve flats (shown fully diverted)

2.2.5 Calibrating the Hot Oil Positioner/Valve

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The positioner cam must be adjusted so that the valve travels from fully diverted to fully open as the modulating valve position varies from 000 to 255. Refer to Section 2.2.4.2 : How to Manually Command a Modulating Valve Position, page 39 elsewhere in this section then follow the step by step procedures below.

WARNING: Electric shock hazard — machine power is on and positioner covers removed for the following procedures. Exposed terminals are energized at 120vac or higher. You can be killed or severely injured by contact with these terminals. Do not touch any wire terminals when calibrating or verifying settings.

- Calibrating the positioner/valve for minimum temperature

2.2.5.1 Calibrating the Positioner/valve for Minimum Temperature

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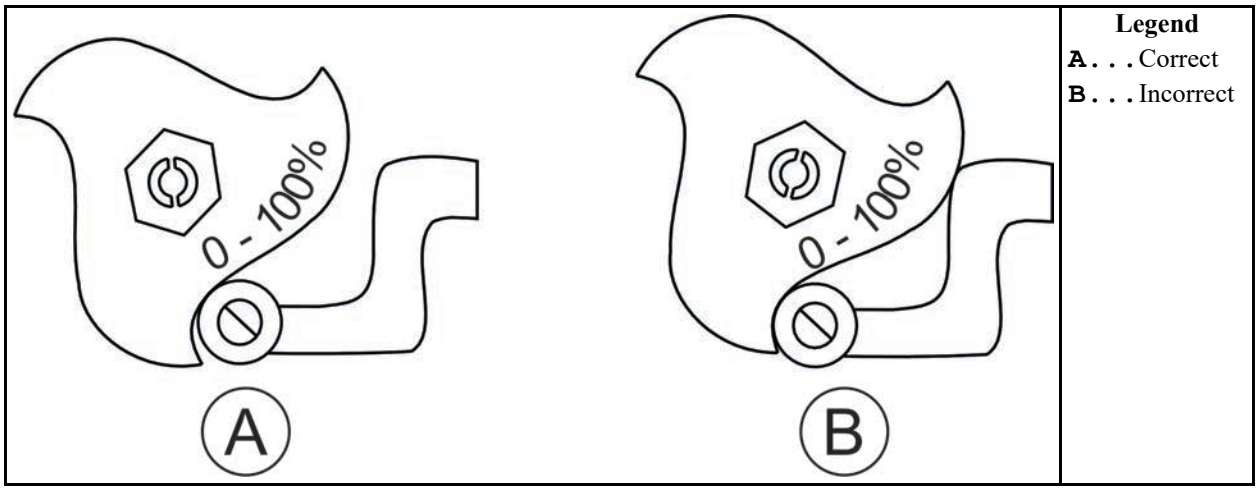
Display or Action	Explanation
TIFHTOF LDA MVP BSPD XXX+XXX XXX 000 XXXX	**hold** MOD VALVE POSITION + ↓ Closes modulating valve. Hold keys until MVP=000.

1. Check that the lower arm ball bearing rests near the deepest part of the cam curve as shown on Figure 11, page 42. If not, move the zero adjustment thumbwheel (Figure 10: Hot Oil Modulating Valve and Positioner, page 41) until the ball bearing is in this position. If this cannot be achieved, loosen the cam retaining nut, move the cam, then use the zero adjustment thumbwheel for adjustment (the cam may rotate slightly with the nut as it is tightened, be sure to allow for this).
2. After setting, check that the modulating valve flats are aligned at a 90 degree angle to the modulating valve (Figure 10: Hot Oil Modulating Valve and Positioner, page 41 and Figure 13: Modulating Valve Flats, page 44). This ensures no hot oil reaches the dryer heating coil. All of the hot oil is returned to the heater.

Display or Action	Explanation
TIFHTOF LDA MVP BSPD XXX+XXX XXX 255 XXXX	**hold** MOD VALVE POSITION + ↑ Opens modulating valve. Hold keys until MVP=255

NOTE: Due to mechanical considerations, settings past 200 have a very minor effect on the valve.

Figure 11. Cam Setting at Modulating Valve Position 000



2.2.5.2 Calibrating the Positioner/Valve For Maximum Temperature

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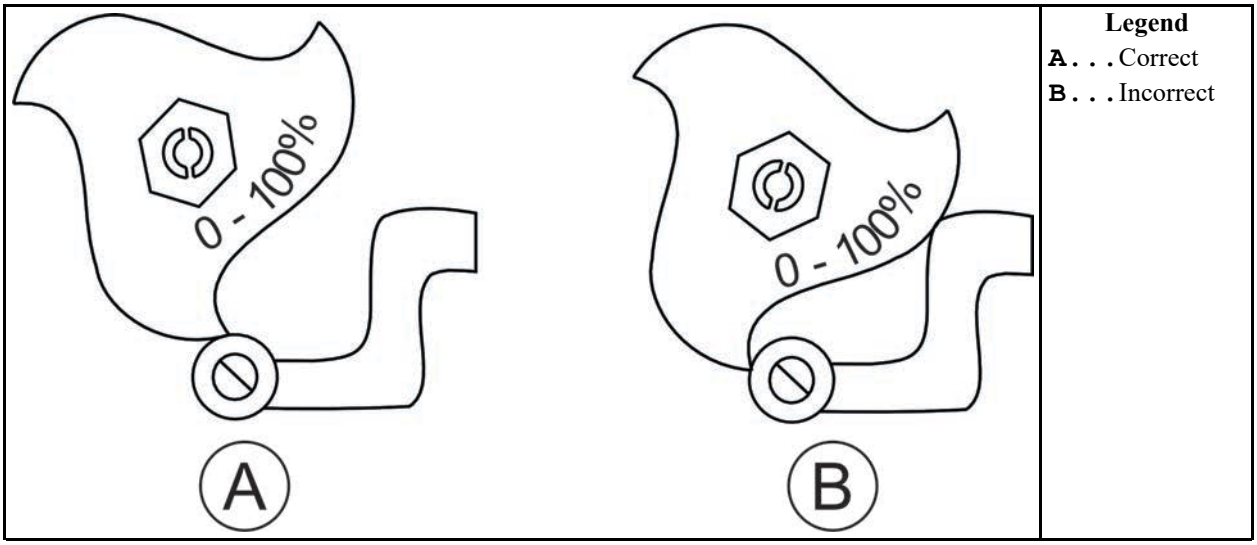
1. Check that the lower arm ball bearing rests on the highest part of the cam curve (Figure 12: Cam Setting at Modulating Valve Position 255, page 43). If the ball bearing is not at the tip, turn the range adjustment (Figure 10, page 41).
2. After setting, check that the diverter valve flats are aligned exactly parallel to the diverter valve, permitting full flow to the dryer heating coil.

Figure 12. Cam Setting at Modulating Valve Position 255



2.2.5.3 Verifying Positioner/Valve Settings

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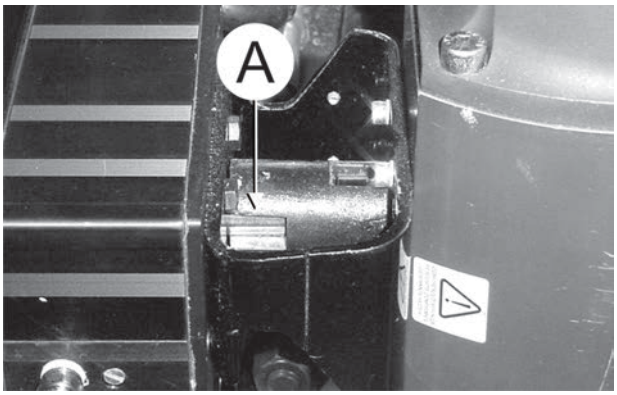
Display or Action	Explanation
TIFHTOF LDA MVP BSPD XXX+XXX XXX 200 XXX	**hold** MOD VALVE POSITION + ↓ Closes modulating valve. Hold until MVP= 200, verify settings then repeat for 150, 100, 050, and 000.

Since the zero and range adjustments affect each other, verify that for each of the five MVP's commanded, the valve moves approximately 1/5 of the way from fully open to fully diverted, and:

- The ball bearing follows the cam slope evenly.
- The cam zero and range settings are correct for fully open and fully diverted positions.

Figure 13. Modulating Valve Flats



Legend

A . . . Valve flats (shown in fully diverted position)

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2.3 Torque Requirements for Fasteners

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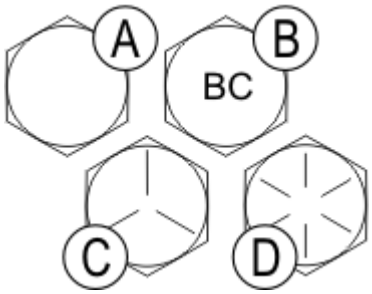
The document about the assembly gives the torque requirements for other fasteners. **If fastener torque specifications or threadlocker requirements in an assembly document are different from this document, use the assembly document.**

Figure 14. The Bolts in Milnor® Equipment

The Marks on Bolt Heads



Legend

A . . . SAE Grades 1 and 2, ASTM A307, and stainless steel

B . . . Grade BC, ASTM A354

C . . . SAE Grade 5, ASTM A449

D . . . SAE Grade 8 and ASTM A354 BD

2.3.1 Torque Values

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

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

2.3.1.1 Fasteners Made of Carbon Steel

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2.3.1.1.1 Without a Threadlocker

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Table 8. Torque Values for Standard Fasteners with Maximum 5/16-inch Diameters and No Lubricant

	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
Dimension	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	–	–

Table 9. Torque Values for Standard Fasteners Larger Than 5/16-inch Diameters and No Lubricant

	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
Dimension	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
3/14 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 10. Torque Values for Plated Fasteners with Maximum 5/16-inch Diameters and No Lubricant

	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
Dimension	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 11. Torque Values for Plated Fasteners Larger Than 5/16-inch Diameters and No Lubricant

	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
Dimension	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
3/14 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	–	–

2.3.1.1.2 With a Threadlocker

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Table 12. Threadlocker by the Diameter of the Bolt (see below Note)

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: 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.

Table 13. 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 14. 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 15. 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 16. 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 17. 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	–	–

2.3.1.2 Stainless Steel Fasteners

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Table 18. 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 19. 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

2.3.2 Preparation

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WARNING: 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: 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.

2.3.3 How to Apply a Threadlocker

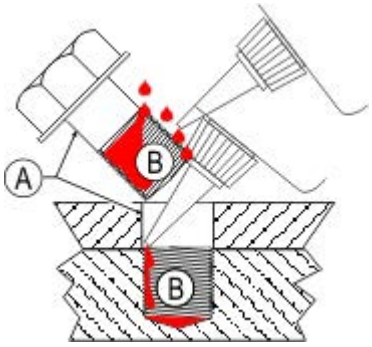
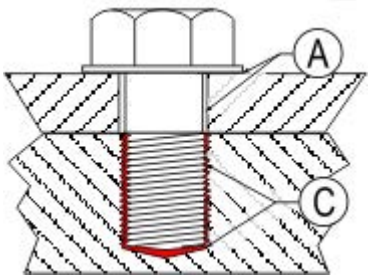
BNUUUN02.T02 0000222508 B.2 B.3 A.4 4/20/23, 9:09 AM Released

CAUTION: 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 15. Apply Threadlocker in a Blind Hole

Application	Coverage
	

Legend

A . . . No threadlocker here
B . . . Apply here
C . . . Fill all space with threadlocker

2.3.3.1 Blind Holes

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1. Apply the threadlocker down the threads to the bottom of the hole.
2. Apply the threadlocker to the bolt.

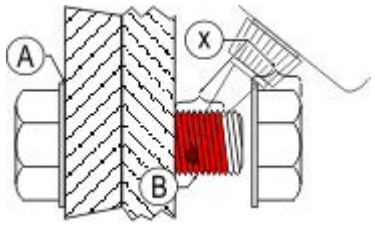
3. Tighten the bolt to the value shown in the correct table (Table 12: Threadlocker by the Diameter of the Bolt (see below Note), page 47 to Table 18: Torque Values for Stainless Steel Fasteners 5/16-inch and Smaller, page 49).

2.3.3.2 Through Holes

BNUUUN02.T04 0000222506 A.3 B.3 A.4 11/26/19, 2:51 PM Released

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 12: Threadlocker by the Diameter of the Bolt (see below Note), page 47 to Table 18: Torque Values for Stainless Steel Fasteners 5/16-inch and Smaller, page 49).

Figure 16. Apply Threadlocker in a Through Hole

Application	Legend
	**A . . .** No threadlocker here **B . . .** Apply the threadlocker to this area **X . . .** Nut depth

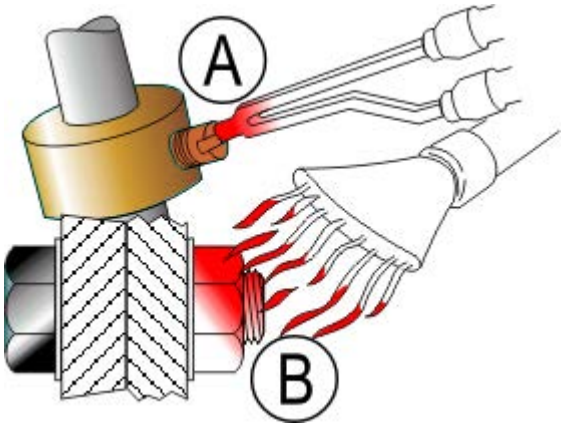
2.3.3.3 Disassembly

BNUUUN02.C07 0000222444 A.3 B.3 A.4 11/26/19, 2:59 PM Released

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 17. Use heat for disassembly of fasteners with threadlocker.

Apply Heat to a Small Area	Legend
	**A . . .** How to apply heat to a small fastener **B . . .** How to apply heat to a large fastener

3 Covers & Shipping Brackets

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Lifting Brackets

2 Sheets

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

Figure 18. 5050, 6450, 6458, 6464, 7676, and 8282 Dryers (7676 Shown)

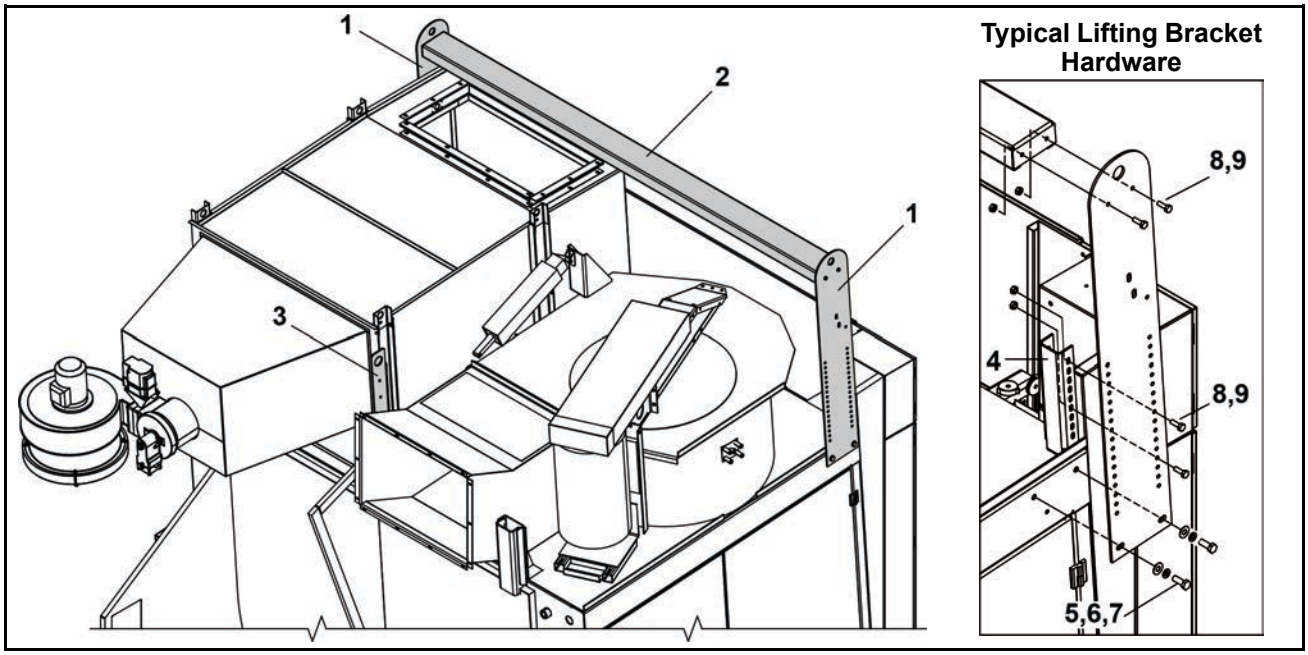
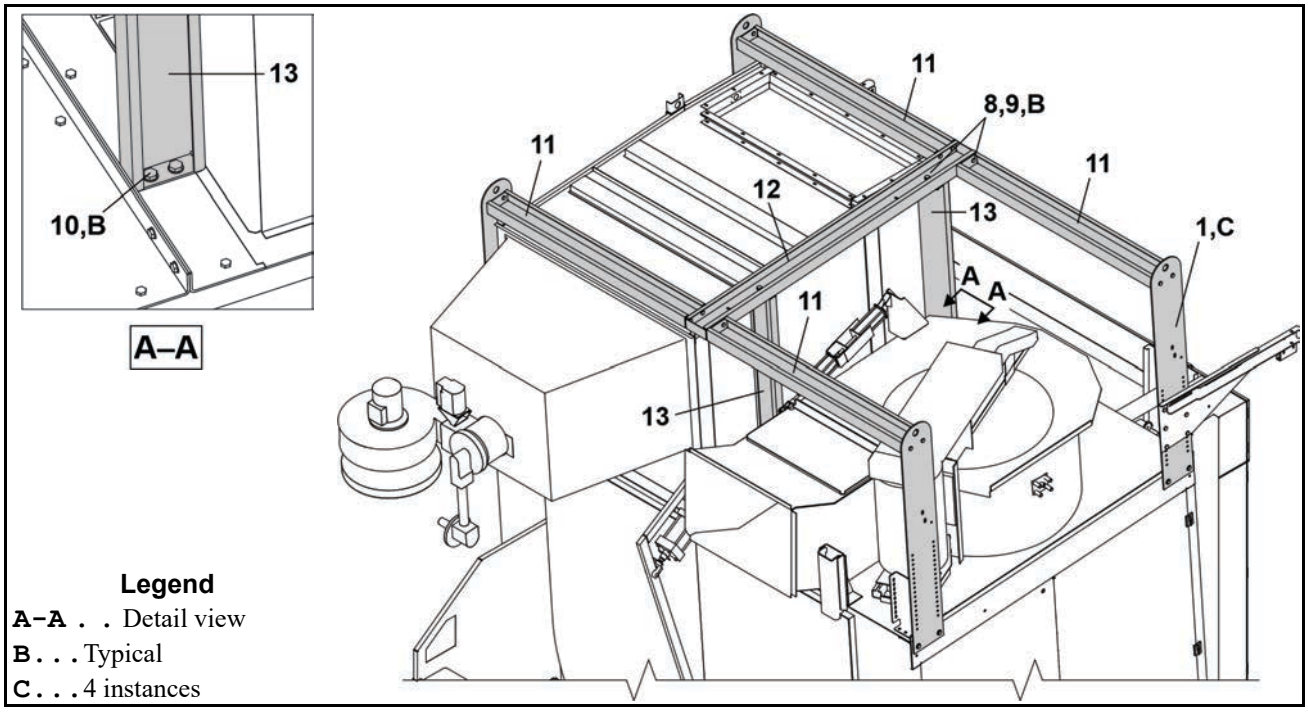


Figure 19. 8282 Dryers



Lifting Brackets

2 Sheets

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

Table 20. Parts List—Lifting Brackets

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				
B			5050 DRYERS	
C			6450 DRYERS	
D			6458 DRYERS	
E			6464 DRYERS	
G			7676 DRYERS	
H			8282 DRYERS	
Components				
BDE	1	07 71315	DRYER LIFT BRKT STANDARD=41.50	
C	1	07 71315B	6450 DRYER LIFT BRKT=44.50	
G	1	07 85315A	DRYER LIFT BRKT TALL=51.50	
H	1	07 88092	8282 DRYER LIFT BRKT	
B	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	
B	3	07 44076	5040 REAR LIFTING BRACKET	
CDE	3	07 71183A	6458A REAR LIFTING BRACKET	
G	3	07 71183B	DRYER REAR CHANNEL LIFTING BRACKET	
H	3	07 88096	8282 VT LIFTING BRKT	
B-H	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	

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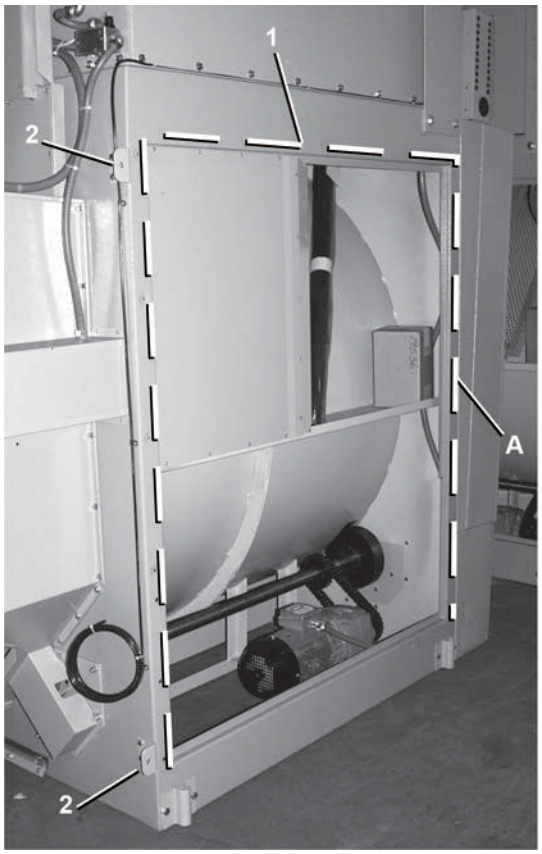
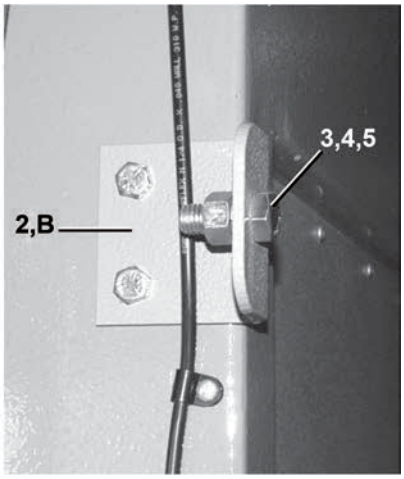
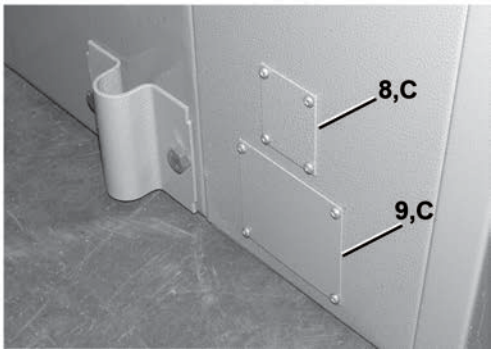
Dryer to Dryer Mounting Parts

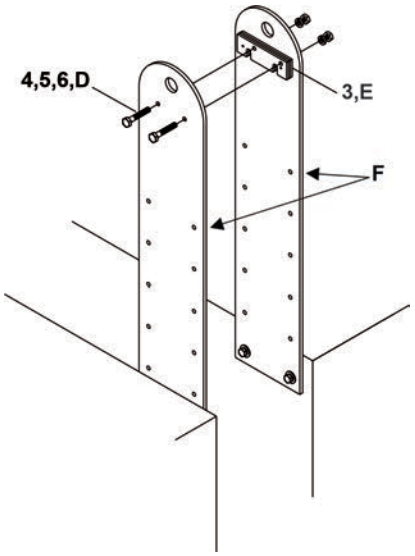
2 Sheets

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









Legend

A . . . 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)

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

C . . . Covers for nameplate and emergency stop replacement.

D . . . Typical

E . . . Shim

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

Dryer to Dryer Mounting Parts

2 Sheets

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

Table 21. Parts List—Dryer to Dryer Mounting Parts

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**
Components				
all	1	60A008A	1" X 1" CLOSED CELL NEO SPONGE W/ADH.STRIP	
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	

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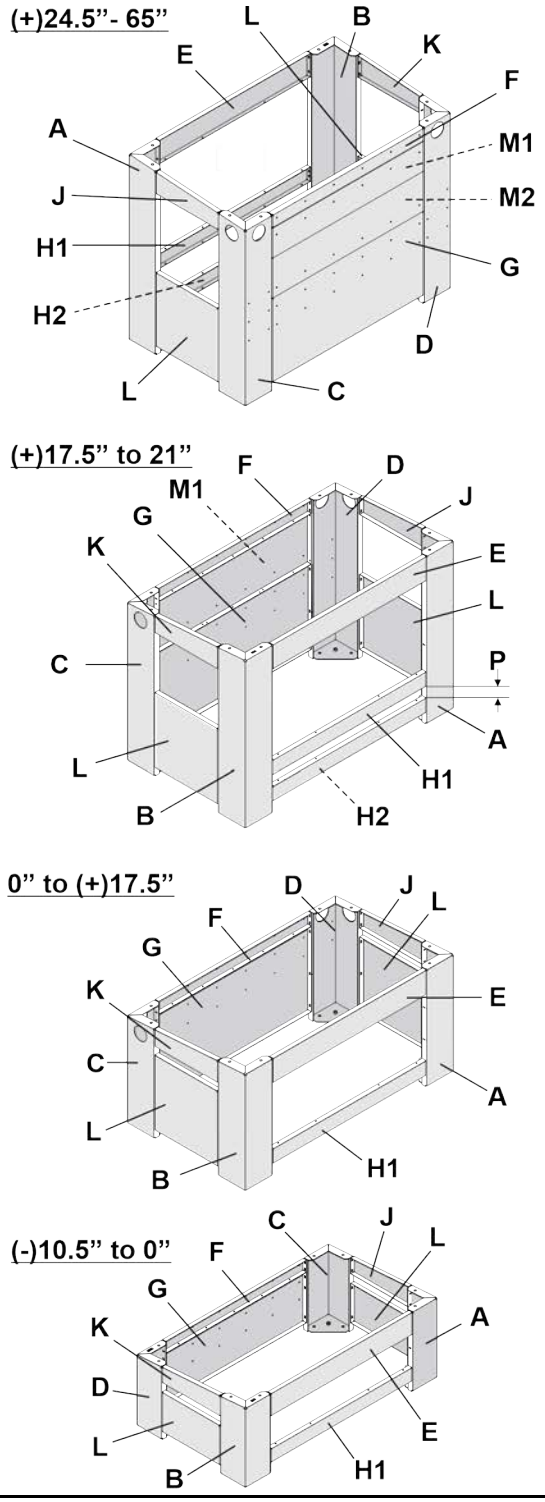
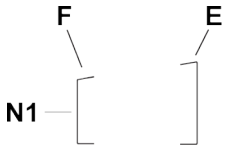
Pedestal Base Installation

4 Sheet

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

Figure 20. Placement of Components with Regard to Pedestal Height





Legend

A . . . Front right leg
B . . . Front left leg
C . . . Rear right leg
D . . . Rear left leg
E . . . Front top cross member
F . . . Rear top cross member
G . . . Rear bottom panel
H1 . . Inverter box support or cross member, one is always supplied.
H2 . . Second cross member is supplied when the front leg heights are 58” [1473 mm] or taller.
J . . . Right side top angled panel
K . . . Left side top angled panel
L . . . Side bottom panels
M1 . . Rear filler panels, together M1 and M2 equal the positive pedestal height ordered.
M2 . . Second rear filler panel, if required
N1 . . Note: The front top cross member (item E) and the rear top cross member (item F) are angled to match the Dryer’s 4 degree rear tilt, this angle may not be immediately apparent. 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.
P . . . Varies

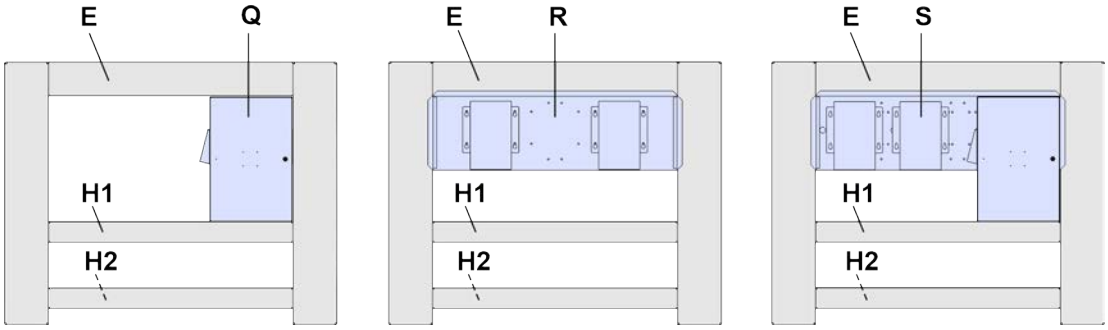
Pedestal Base Installation

4 Sheet

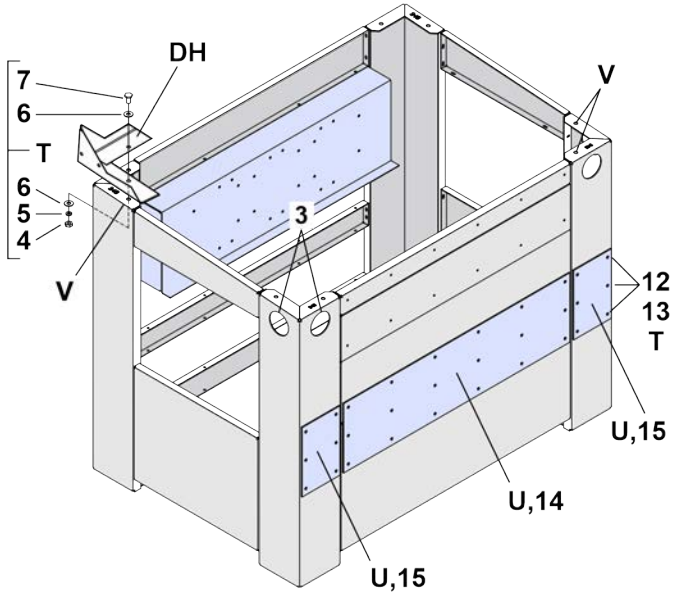
5050, 6450, 6458, 6464, 7676, & 8282 Dryers

Figure 21. Pedestal Options and Hardware Connections

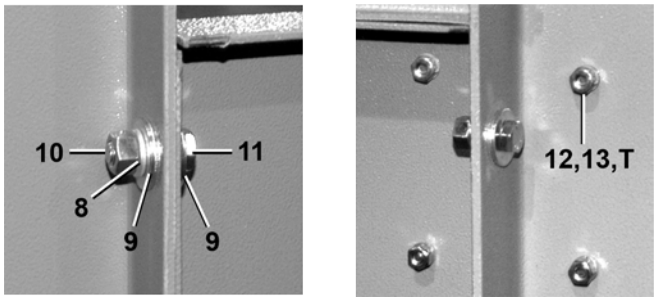
Electrical Options Mounted to the Pedestal Fronts



Hardware Connections



Typical Hardware



Legend

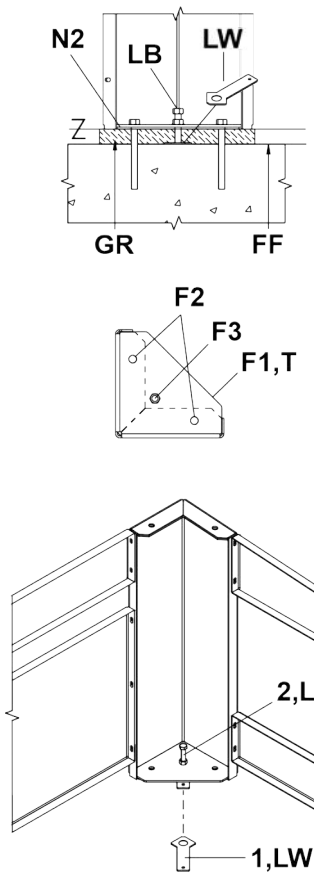
- **DH . .** Cut-away of the front right corner of the Dryer house.
- **E . . .** Front top cross member
- **H1 . .** Inverter box support and/or cross member, one is standard.
- **H2 . .** Cross member, H2, is supplied when the front leg heights are 58”[1473 mm] or taller.
- **Q . . .** Location of the optional blower inverter box when mounted to the pedestal front
- **R . . .** Location of the buck boost transformers when mounted to the pedestal front, when specified
- **S . . .** Location of buck boost transformers and blower inverter box when mounted to the pedestal front
- **T . . .** Typical
- **U . . .** Optional bumper guards
- **V . . .** Bolt the house to the pedestal in 8 places.

Pedestal Base Installation

4 Sheet

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

Figure 22. Anchoring



Legend

FF . . Finished floor
F1 . . Pedestal leg base plates
F2 . . Anchor bolt holes
F3 . . Leveling bolt hole
GR . . Grout
LB . . Leveling bolt
LW . . Leveling bolt washer
N2 . . Note: Pedestal leg base plates (feet) provide substantial grouting surface between the pedestal leg and the finished floor. Shim and use the leveling bolts to level the Dryer to Baseline "Z" (or System Zero Line). Grout and anchor all base plates. See the Dryer model's dimensional drawing and the "Attention Installers" page in the manual and affixed to the machine.
T . . . Typical

Table 22. Parts List—Pedestal Base Installation

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	G77PD030	DRYER PEDESTAL STANDARD HARDWARE	
Components				
all	1	07 71579	DRYER JACKING BOLT WASHER	
all	2	15K226	HXTAPSCR 5/8-11UNC2AX3 GR5 ZIN	
all	3	12P14KSB	SNAPBUSH 5.0" X 4.75" X .75	
all	4	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	5	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	6	15U490	FLTWASH 1+1/2X17/32X1/4 ZINC	
all	7	15K191	HXCAPSCR 1/2-13UNC2AX2.5 GR5 Z	
all	8	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	

Pedestal Base Installation

4 Sheet

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

Table 22 Parts List—Pedestal Base Installation (cont'd.)

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
all	9	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	10	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	11	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	12	15N176	FLATMACSCR 1/4-20NCX3/4SS18-8	
all	13	15G164NE	HEXLOKNUT NYL 1/4-20 UNC2A SS.	
	14	07 71403	6458 BUMPER PAD-16"WX60"LG	5050, 6450, 6458, 6464 Dryers
	14	07 81403	7272 BUMPER PAD	7676 Dryers
all	15	07 71404	6458 BUMPER PAD-16"WX10"LG	

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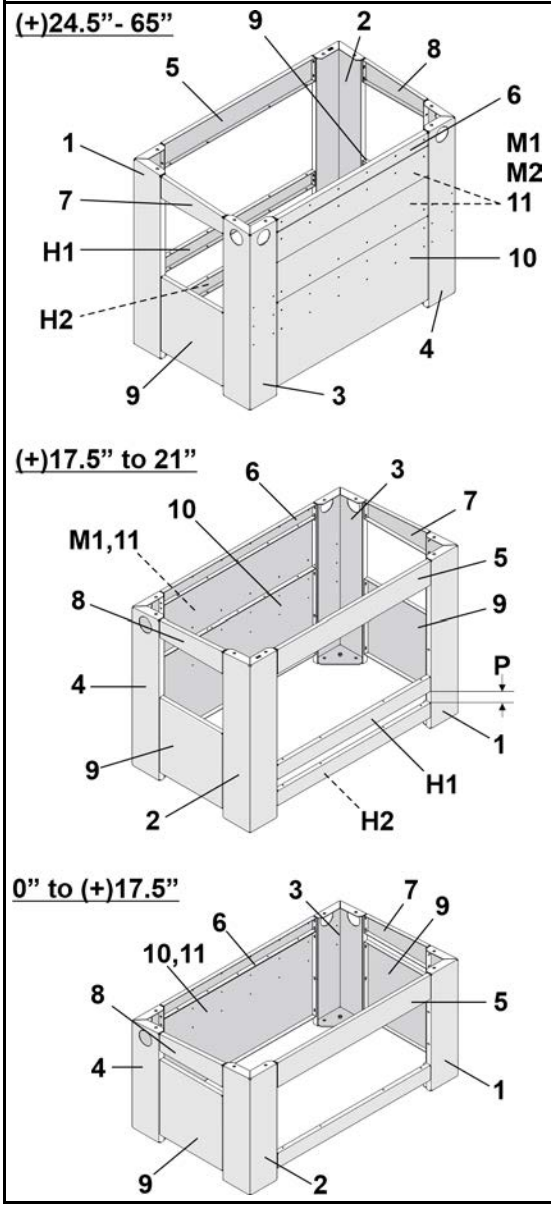
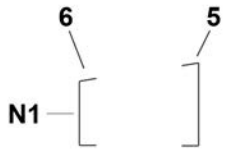
Pedestal Base Components

4 Sheet

5050 Dryers

Figure 23. Components with Regard to Pedestal Height





Legend

H1 . . Inverter box support or cross member, one is always supplied.

H2 . . Second cross member is supplied when the front legs heights are 58” [1473 mm] or taller.

M1 . . Rear filler panels, together M1 and M2 equal the positive pedestal height ordered.

M2 . . Second rear filler panel, if required.

N1 . . Note: The front top cross member (item 5) and the rear top cross member (item 6) are angled to match the dryer’s four degree rear tilt. This angle may not be immediately apparent. 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.

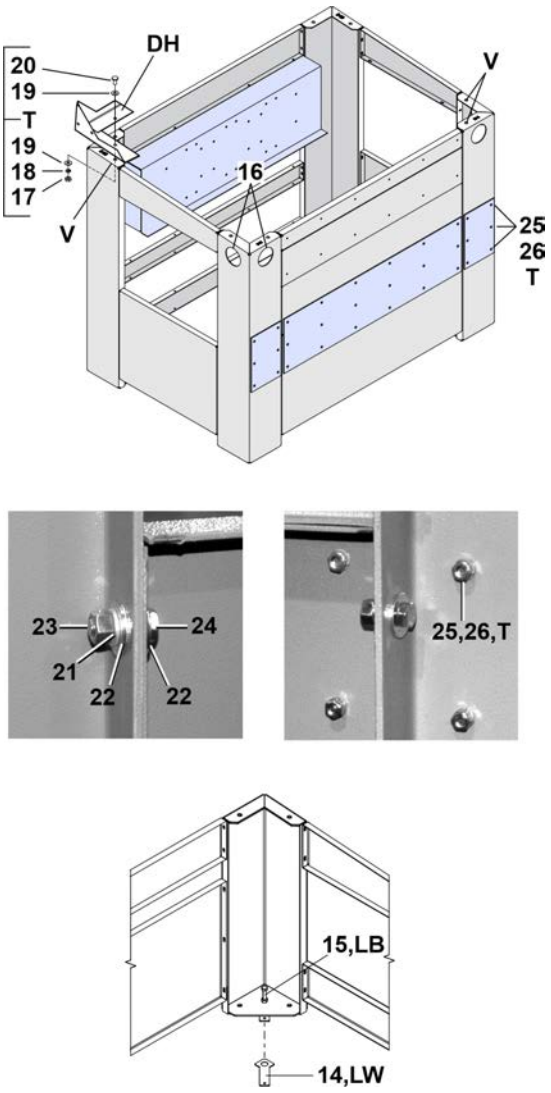
P . . . Varies

Pedestal Base Components

4 Sheet

5050 Dryers

Figure 24. Pedestal to House Connection, Typical Hardware, and Leveling Bolts



Legend

DH. . Cut-away of the front right corner of the dryer house.
LB. . Leveling bolt
LW. . Leveling bolt washer
T. . . Typical
V. . . Bolt the house to the pedestal in eight places.

Table 23. Parts List—Pedestal Base Components

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				
none				
	A		PEDESTAL ORDER HEIGHT 0.0”	REFERENCE
	B		PEDESTAL ORDER HEIGHT 10.5”	REFERENCE
	C		PEDESTAL ORDER HEIGHT 14”	REFERENCE

Pedestal Base Components

4 Sheet

5050 Dryers

Table 23 Parts List—Pedestal Base Components (cont'd.)

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**
	D		PEDESTAL ORDER HEIGHT 17.5”	REFERENCE
	E		PEDESTAL ORDER HEIGHT 21”	REFERENCE
	F		PEDESTAL ORDER HEIGHT 24.5”	REFERENCE
	G		PEDESTAL ORDER HEIGHT 28”	REFERENCE
	H		PEDESTAL ORDER HEIGHT 31.5”	REFERENCE
Components				
A	1	W7 44101B	WLMT=5050 FRONT RIGHT STD PED JACKBOLT	
B	1	W7 44110B	WLMT=5050 FRONT RIGHT 10.50 PED JACKBOLT	
C	1	W7 44108B	WLMT=5050 FRONT RIGHT 14.00 PED JACKSHAFT	
D	1	W7 44112B	WLMT=5050 FRONT RIGHT 17.50 PED JACKBOLT	
E	1	W7 44114B	WLMT = 5050 FRONT RIGHT 21.00" PED JACKBOLT	
F	1	W7 44116B	WLMT=5050 FRONT RIGHT 24.5 PED JACKBOLT	
G	1	W7 44118B	WLMT-5050 FRONT RIGHT 28.00 PED JACKBOLT	
H	1	W7 44100B	WLMT=5050 FRONT RIGHT 31.50 PED JACKBOLT	
A	2	W7 44101C	WLMT=5050 FRONT LEFT STD PED JACKSHAFT	
B	2	W7 44110C	WLMT=5050 FRONT LEFT 10.50 PED JACKBOLT	
C	2	W7 44108C	WLMT=5050 FORNT LEFT 14.00 PED JACKSHAFT	
D	2	W7 44112C	WLMT=5050 FRONT LEFT 17.50 PED JACKBOLT	
E	2	W7 44114C	WLMT = 5050 FRONT LEFT 21.00" PED JACKBOLT	
F	2	W7 44116C	WLMT=5050 FRONT LEFT 24.5 PED JACKBOLT	
G	2	W7 44118C	WLMT=5050 FRONT LEFT 28.00 PED JACKSHAFT	
H	2	W7 44100C	WLMT=5050 FRONT LEFT 31.50 PED JACKBOLT	
A,C	3	W7 44148	WLMT=50" DRYER REAR RIGHT STD PED JACKBOLT	
B	3	W7 44111	WLMT=50" DRYER REAR RIGHT 10.50 PED JACKBOLT	
D	3	W7 44135	WLMT=50" DRYER REAR RIGHT 17.50 PED JACKBOLT	
E	3	W7 44137	WLMT=50" DRYER REAR RIGHT 21.00 PED JACKBOLT	
F	3	W7 44139	WLMT=50" DRYER REAR RIGHT 24.5 PED JACKBOLT	
G	3	W7 44141	WLMT=50" DYRER REAR RIGHT 28.00 PED JACKBOLT	
H	3	W7 44147	WLMT=50" DRYER REAR RIGHT 31.50 PED JACKBOLT	
A,C	4	W7 44148A	WLMT=50" DRYER REAR LEFT STD PED JACKBOLT	
B	4	W7 44111A	WLMT=50" DRYER REAR LEFT 10.50 PED JACKBOLT	
D	4	W7 44135A	WLMT=50" DRYER REAR LEFT 17.50 PED JACKBOLT	
E	4	W7 44137A	WLMT=50" DRYER REAR LEFT 21.00 PED JACKBOLT	
F	4	W7 44139A	WLMT=50" DRYER REAR LEFT 24.5 PED JACKBOLT	

Pedestal Base Components

4 Sheet

5050 Dryers

Table 23 Parts List—Pedestal Base Components (cont'd.)

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
G	4	W7 44141A	WLMT=50" DRYER REAR LEFT 28.00 PED JACKBOLT	
H	4	W7 44147A	WLMT=50" DRYER REAR LEFT 31.50 PED JACKBOLT	
all	5	07 44153	5040 DRYER BASE FILLER TOP FT	
all	6	07 44154	5040 DRYER BASE FILLER FNT+RR	
all	7	07 44155C	5050 DRYER BASE FILL DRV RIGHT	
all	8	07 44155D	5050 DRYER BASE FILL DRV LEFT	
all	9	07 44156A	5050 DRYER BASE FILL DVR LOW	
A-D	10	07 44158	5040=REAR PANEL STD PED	
E,G,H	10	07 44158A	5040=REAR PANEL 21.00 PED	
F	10	07 44158B	5050=REAR PANEL 24.5 PED	
B,C,F	11	07 44217	5040 DRYER BASE FILLER TOP RR	
all	14	07 71579	DRYER JACKING BOLT WASHER	
all	15	15K226	HXTAPSCR 5/8-11UNC2AX3 GR5 ZIN	
all	16	12P14KSB	SNAPBUSH 5.0" X 4.75" X .75	
all	17	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	18	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	19	15U490	FLTWASH 1+1/2X17/32X1/4 ZINC	
all	20	15K191	HXCAPSCR 1/2-13UNC2AX2.5 GR5 Z	
all	21	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	22	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	23	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	24	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	25	15N176	FLATMACSCR 1/4-20NCX3/4SS18-8	
all	26	15G164NE	HEXLOKNUT NYL 1/4-20 UNC2A SS.	

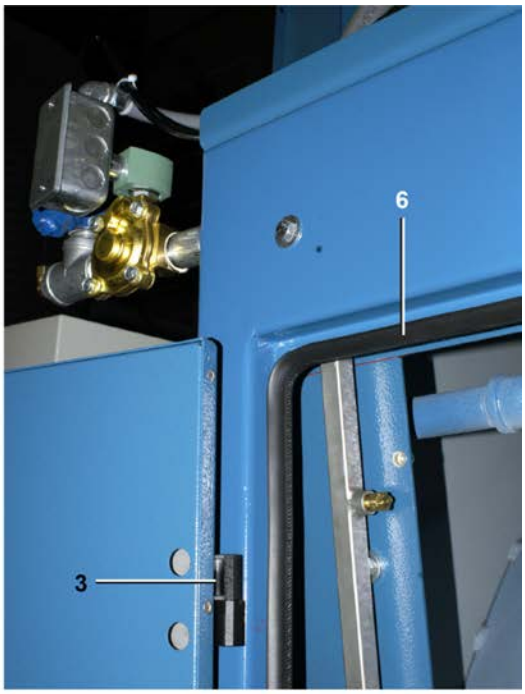
BPDUUM05 / 2023044A BPDUUM05.1 0000531649 B.3 A.4 1/27/23, 3:42 PM Released

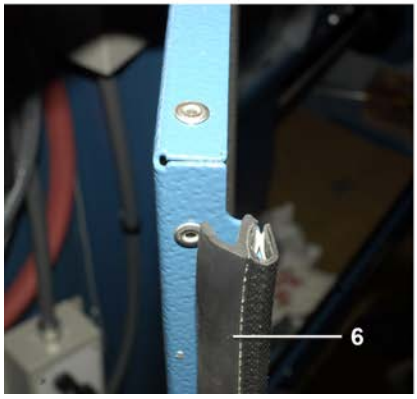
Side Doors

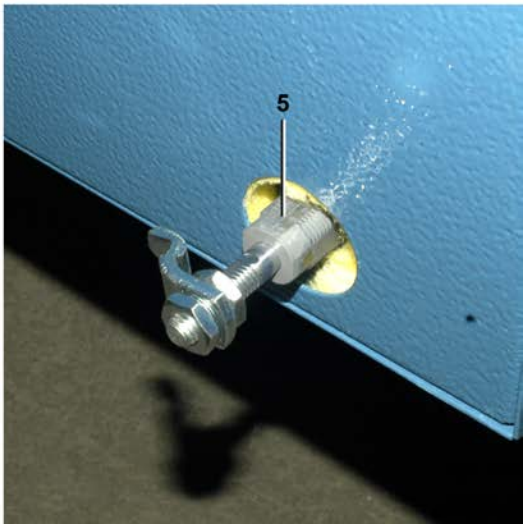
2 Sheets

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

Side Doors used on Dryers since 2014







Side Doors

2 Sheets

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

Table 24. Parts List—

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.

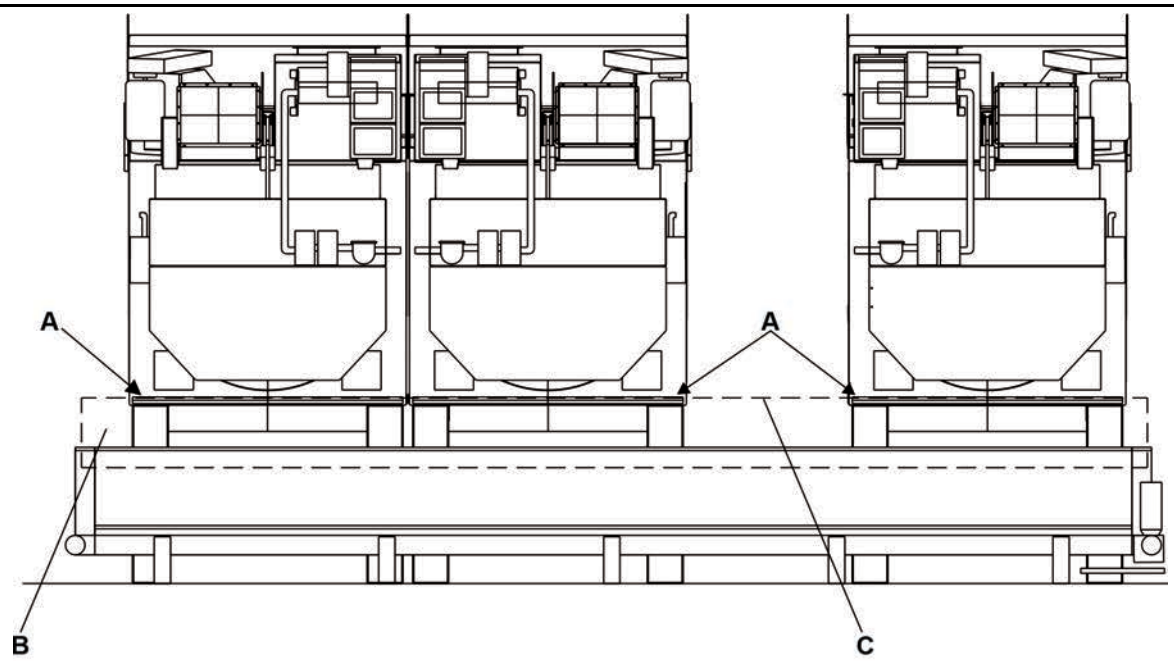
Used In	Item	Part Number	Description/Nomenclature	Comments
			Reference Assemblies	
	A		5050 DRYERS	REFERENCE
	B		6450 DRYERS	REFERENCE
	C		6458 DRYERS	REFERENCE
	D		6464 DRYERS	REFERENCE
	E		7676 DRYERS	REFERENCE
	F		8282 DRYERS	REFERENCE
			Components	
A	1	A74SD018A	5050 DOOR ASSY W/O LOCK	
B	1	A77SD030A	6450 SIDE DOOR ASSY W/O LOCK	
C	1	A77SD017C	6458 HINGED SIDE-DOOR ASSY W/O LOCK V2	
D	1	A77SD023C	6464 HINGED SIDE-DOOR ASSY W/O LOCK V2	
E	1	A79SD022A	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	A77SD030B	6450 HINGED SIDE-DOOR ASSY W/LOCK V2	
C	2	A77SD017B	6458 HINGED SIDE-DOOR ASSY W/LOCK V2	
D	2	A77SD023B	6464 HINGED SIDE-DOOR ASSY W/LOCK V2	
E	2	A79SD023A	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	VISE-ACT.DBBIT.LATCH#E3-12-27	
all	6	60A114	SELF-GRIP GASKET EMKA 1011-17	

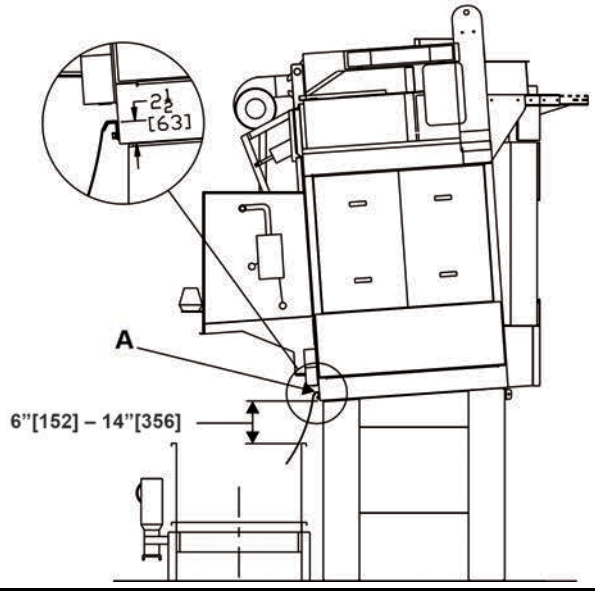
BPDUUM06 / 2022253 BPDUUM06.1 0000486687 A.4 A.5 6/16/22, 9:31 AM Released

Unload Bridge Installation

2 Sheets

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





Legend

A . . . Mounting bracket 001
B . . . Plastic sheeting length as specified
C . . . Plastic sheeting requires field innovation to support it between dryers

Unload Bridge Installation

2 Sheets

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

Table 25. Parts List—Unload Bridge Installation

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				
	B			5050 DRYERS
	C			6450, 6458 DRYERS
	D			6464 DRYERS
	F			7676 DRYERS
	G			8282 DRYERS
Components				
B	1	07 44230	5040 UNLOAD BRIDGE TO CONV	
CD	1	07 71568	6458 UNLOAD BRIDGE TO CONV	
F	1	07 71569	7272 UNLOAD BRIDGE TO CONV	
G	1	07 88094	8282 UNLOAD BRIDGE TO CONV	

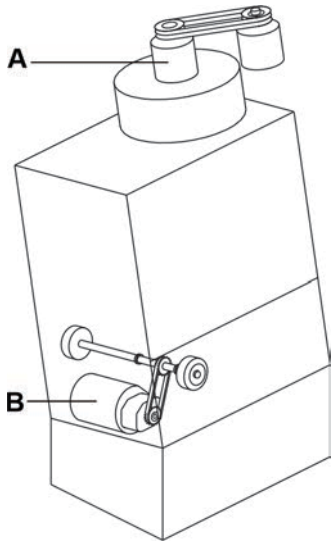
4 Drive Assemblies

BPDD5I01 / 2022256 BPDD5I01.1 0000487147 A.4 6/20/22, 8:42 AM Released

Drive Chart

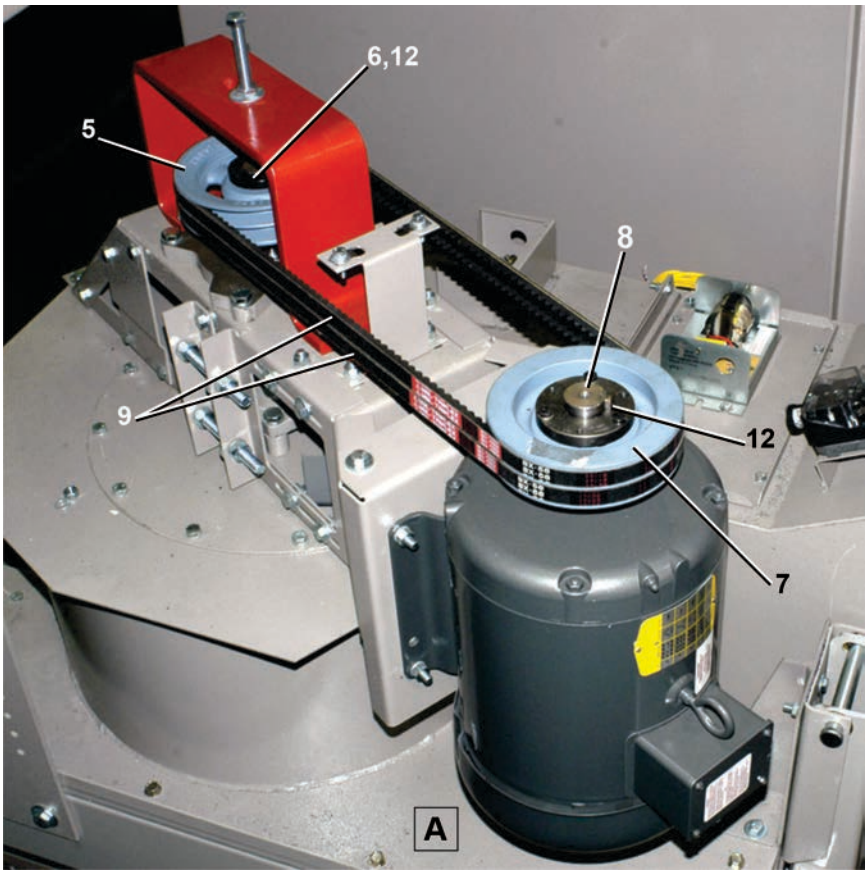
3 Sheets

5050TG1L/R,TS1L/R



Legend

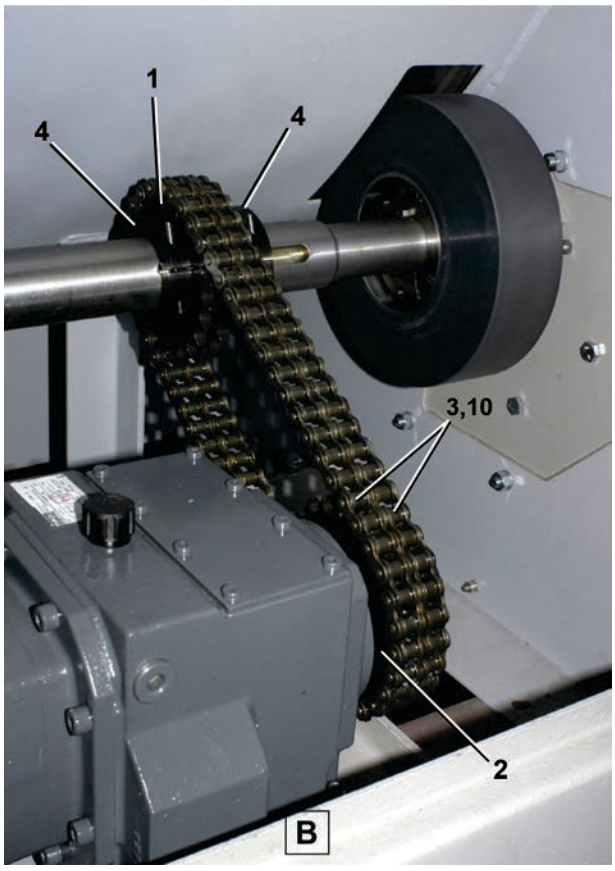
A . . . Blower drive
B . . . Cylinder drive

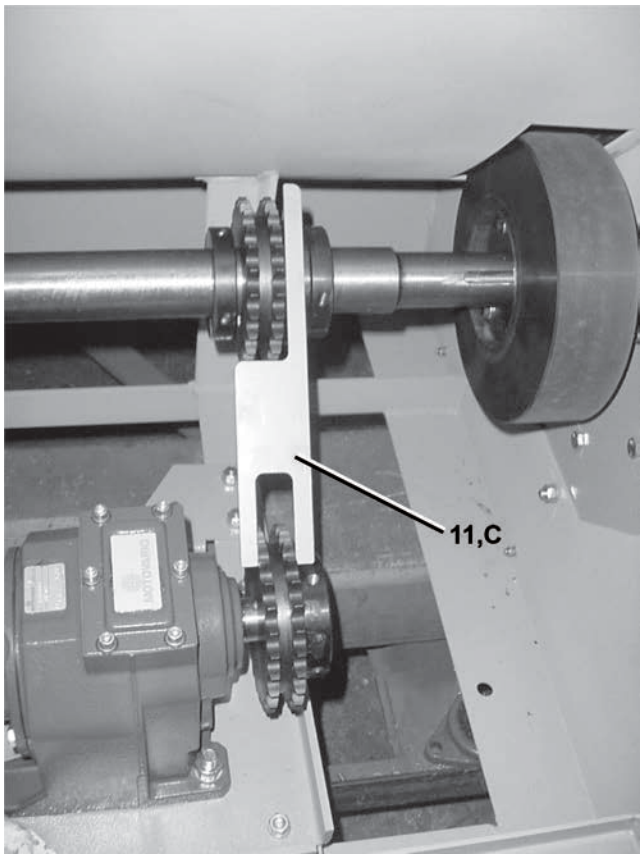


Drive Chart

3 Sheets

5050TG1L/R,TS1L/R





Legend

C . . . Use the Sprocket Alignment Gage (item 12), shipped with the machine, to align the drive and driven sprockets.

Drive Chart

3 Sheets

5050TG1L/R,TS1L/R

Table 26. Parts List—Drive Chart

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	D74 01150	DRVE CHRT 5040TG2L/R DRYER	50C
	B	D74 01160	DRVE CHRT 5040TG2L/R DRYER 60C	60C
Components				
all	1	54N050B23D	SPRKT D50B23H 2" BORE DRVN	
all	2	54N050B25C	SPRKT D50B25H 1" BORE	
all	3	54G036SP	SOLID BUSH CHN 50-2 DBL 36.25"	
all	4	54JH22000C	SHFTCOLL 2"ID DBLSPLT CARSTL	
all	5	56064B2H	VPUL 2B6.4/A6.0 2BK70H	
all	6	56Q1GH	1+3/8" BUSH VPUL TYPE H,D,ORQT OR L	
A	7	56060B2SDS	VPUL 2B6.0/A5.6 (SDS) TYPE QD	
B	7	56054B2SDS	VPUL 2B5.4/A5.0 (SDS) TYPE QD	
all	8	56Q1GSDS	1+3/8" BUSH VPUL QD TYPE SDS	
all	9	56VB058X	VBELT BX58 DAYCO RAWEDGE COG	
all	10	20H011CG	GADUS S2 HIGH SPEED #550027655 EA=1 TUBE	
all	11	07 71752	SPROCKET ALIGNMENT GAGE-6458	
all	12	15E195	SQMACHKEY 3/16X1+1/2 NOTAPERH	

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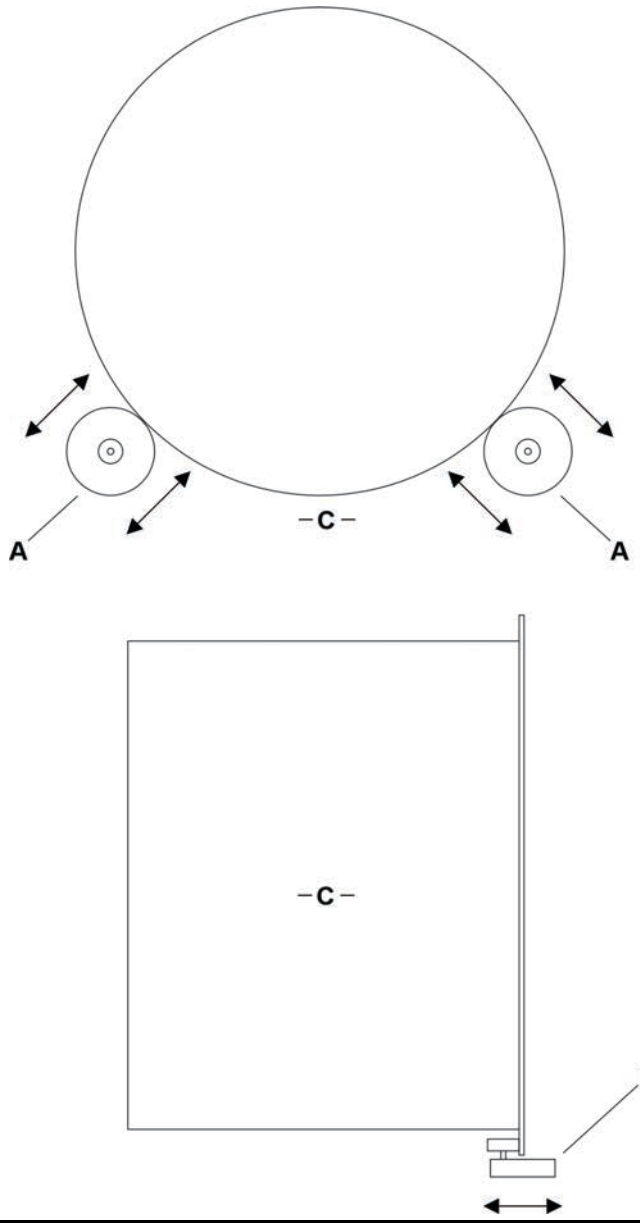
Cylinder Installation

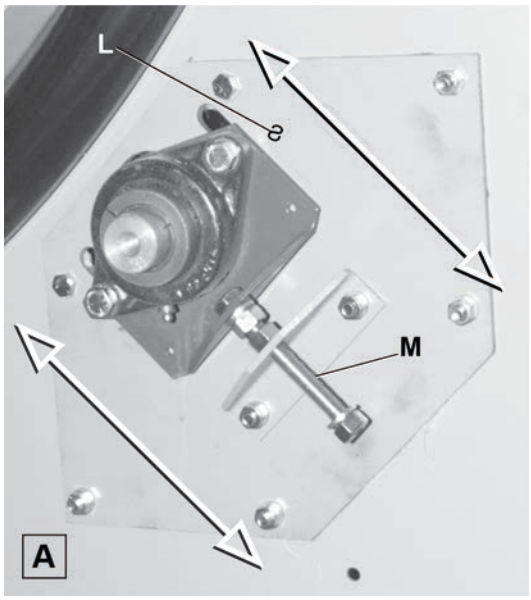
3 Sheets

5050TG2L/R,TS2L/R

NOTE: Cylinder is aligned when it is symmetrical and square within the house cylinder cavity.



Drive and Support Roller Adjustments



Legend

A . . . Detail A. Use the adjustable bolts on the bearing mounting plates to adjust the position of the drive rollers.

B . . . See Detail B

C . . . Cylinder

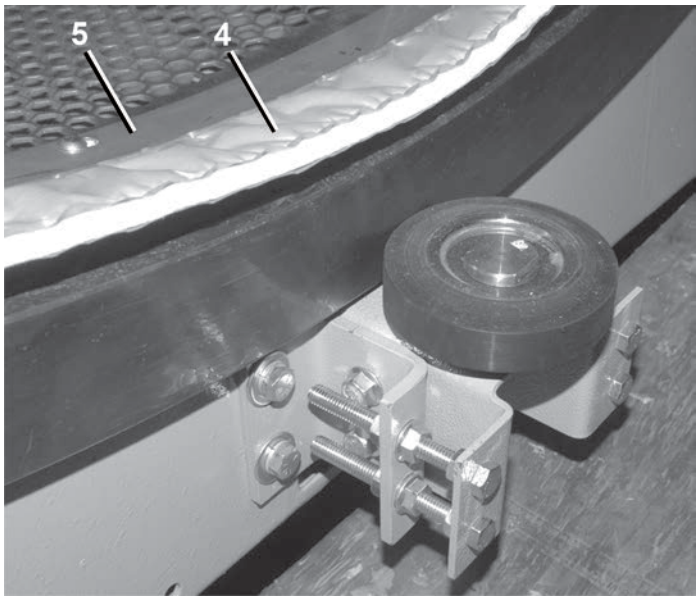
L . . . Support roller bearing mounting plates

M . . . Adjustable bolts

Cylinder Installation

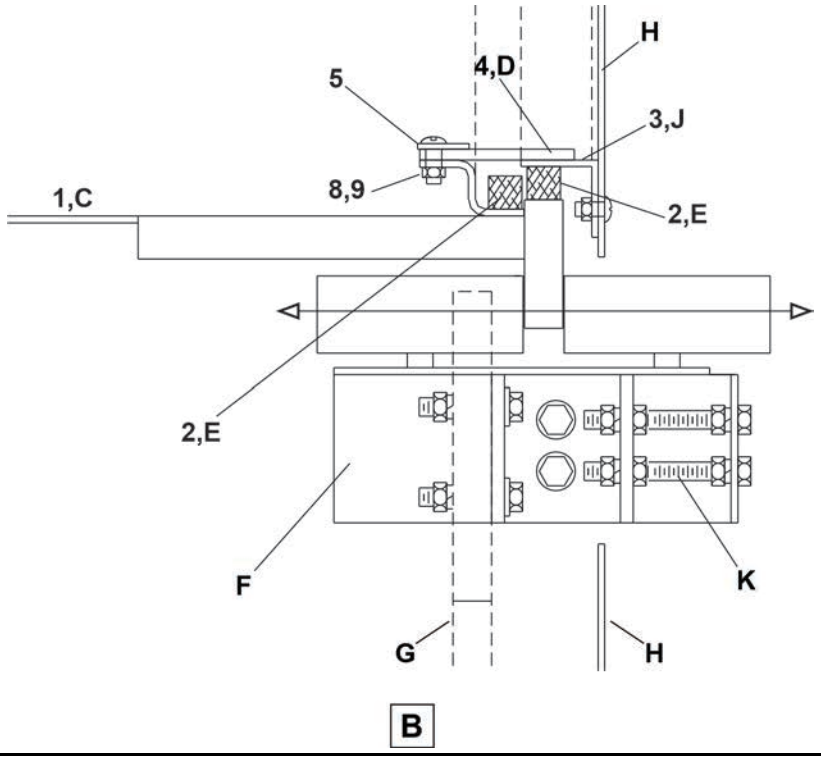
3 Sheets

5050TG2L/R,TS2L/R



Legend

B . . . Detail B: Guide roller adjustments (adjusts front/rear position of Cylinder)
C . . . Cylinder
D . . . Felt flap seal
E . . . Felt
F . . . Guide roller assembly, see BPDUUI01
G . . . House
H . . . Shellfront
J . . . Ring
K . . . Adjustment bolts



Cylinder Installation

3 Sheets

5050TG2L/R,TS2L/R

Table 27. Parts List—Cylinder Installation

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	A74FS002	5050 FRONT FLAP SEAL ASSY	
Components				
all	1	A74CA010	5050 DRYER BASKET	5050 STANDARD
all	1	A74CA011	5050 DRYER BASKET TEFLON COAT	5050 TEFLON
all	1	A74CA012	5050 DRYER BASKET HITEMP COAT	5050 HITEMP
all	2	27A686	FELT 3/4"THKX1/2"W F7=0.67	
all	3	W7 40950	WELD=50" DRYER FRONT SEAL COSMETIC RING	
all	4	07 41226A	5040 FRONT SEAL/FELT/NOMEX	
all	5	07 44067	5040 CYL SEAL RETAINER STRIP	
all	8	15K033	BUTSOKCAPSCR 1/4-20X5/8 SS18-8	
all	9	15G164NE	HEXLOKNUT NYL 1/4-20 UNC2A SS.	

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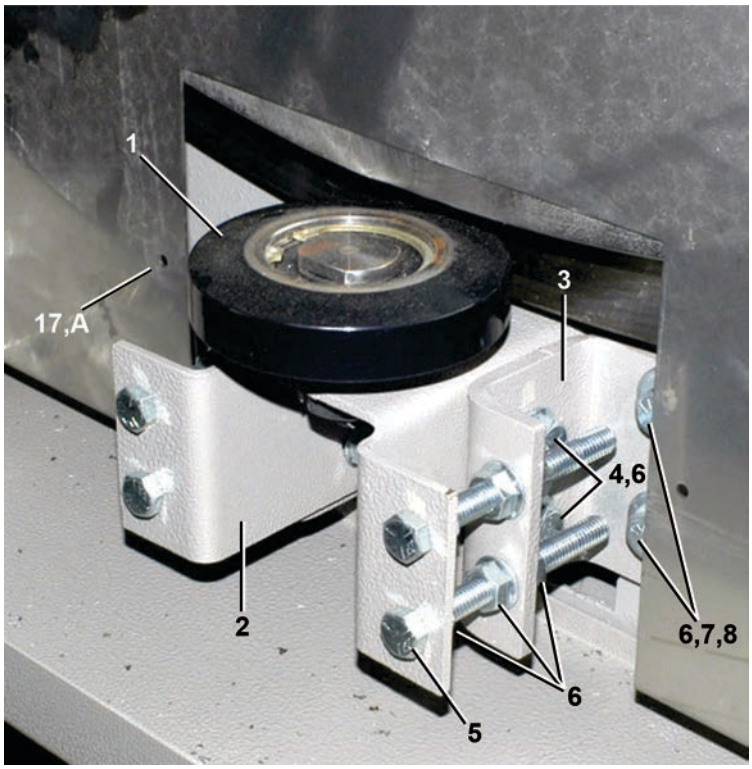
Guide Roller Assembly

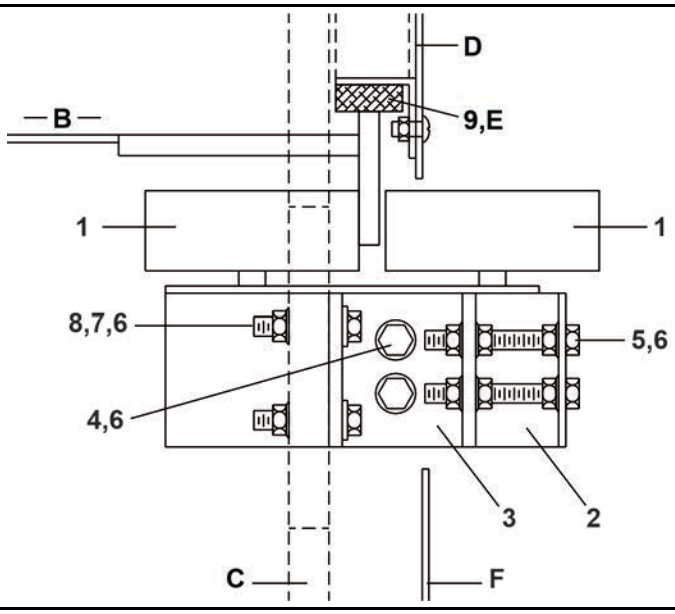
2 Sheets

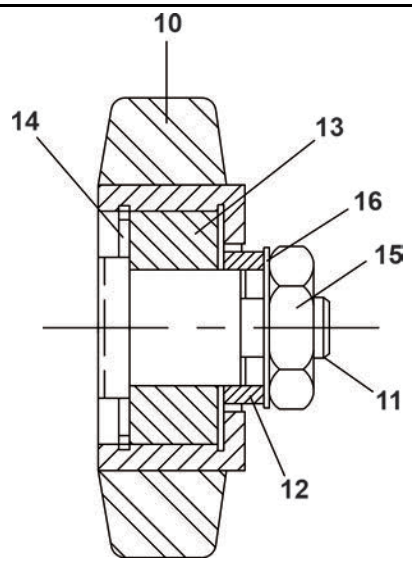
5050, 6450, 6458, 6464, 7676, and 8282 Dryers



Legend

A . . . Cover (not shown)
B . . . Cylinder
C . . . House
D . . . Cosmetic ring
E . . . Felt
F . . . Shellfront





Guide Roller Assembly

2 Sheets

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

Table 28. Parts List—Guide Roller 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.

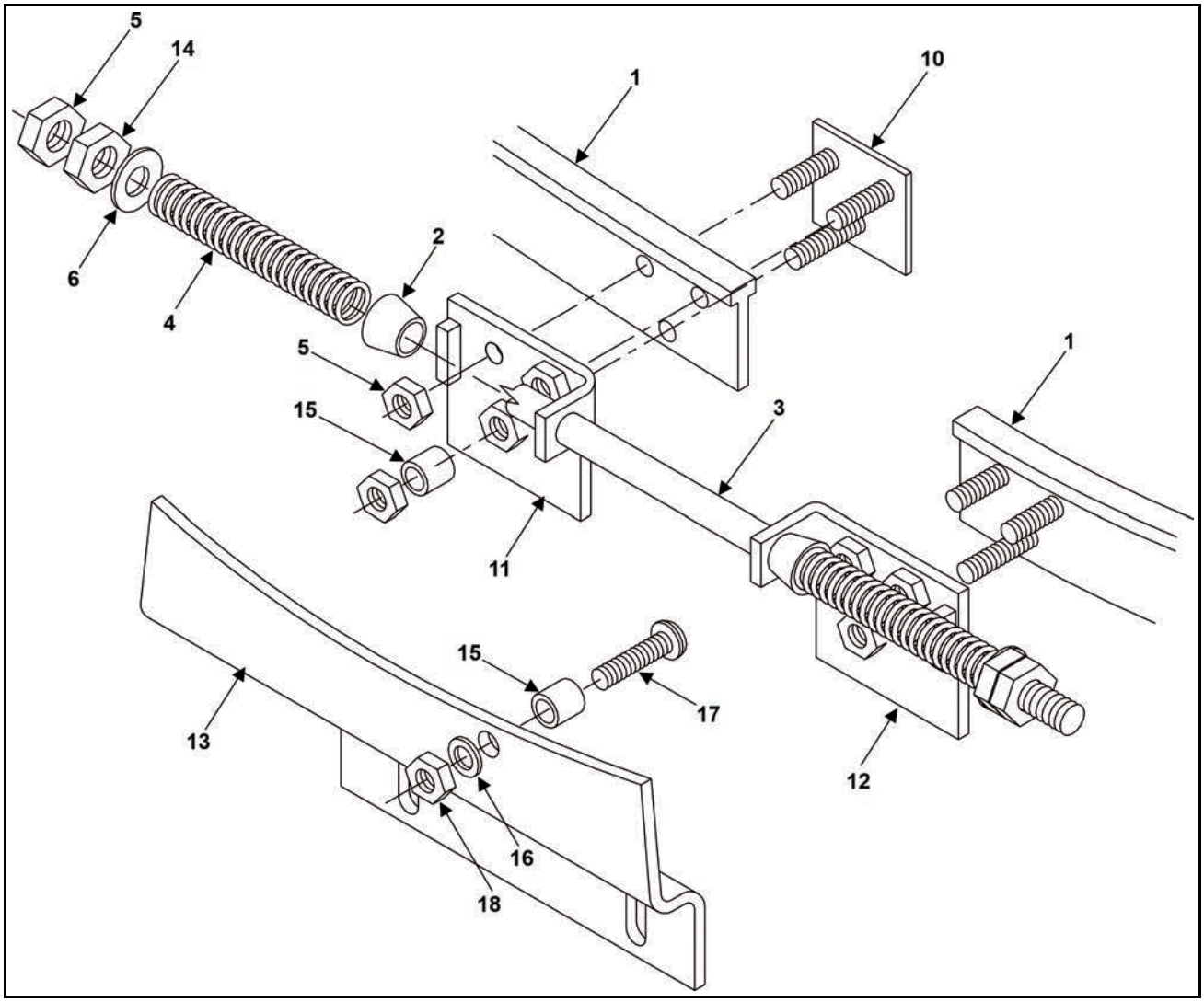
Used In	Item	Part Number	Description/Nomenclature	Comments
			Reference Assemblies	
	A	A77GB010	6458 GUIDE ROLLER ASSY=DRYER	REFERENCE 5050TG1L/R,TS1L/R 6450TG1L/R,TS1L/R 6458TG1L/R,TS1L/R 6464TG1L/R,TS1L/R
	B	A78GB001	72" GUIDE ROLLER ASSY	REFERENCE 7676TG1L/R 8282TG1L/R
			Components	
A	1	A75GB003B	*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#63205LLBC3/5C 1/BX .9843"ID	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	64" DRYER GUIDE ROLLER COVER	

BPDD5I02 / 2022275 BPDD5I02.1 0000492422 A.3 A.4 7/5/22, 7:15 AM Released

T-Seal Assembly

3 Sheets

5050TG1L/R,TS1L/R



T-Seal Assembly

3 Sheets

5050TG1L/R,TS1L/R

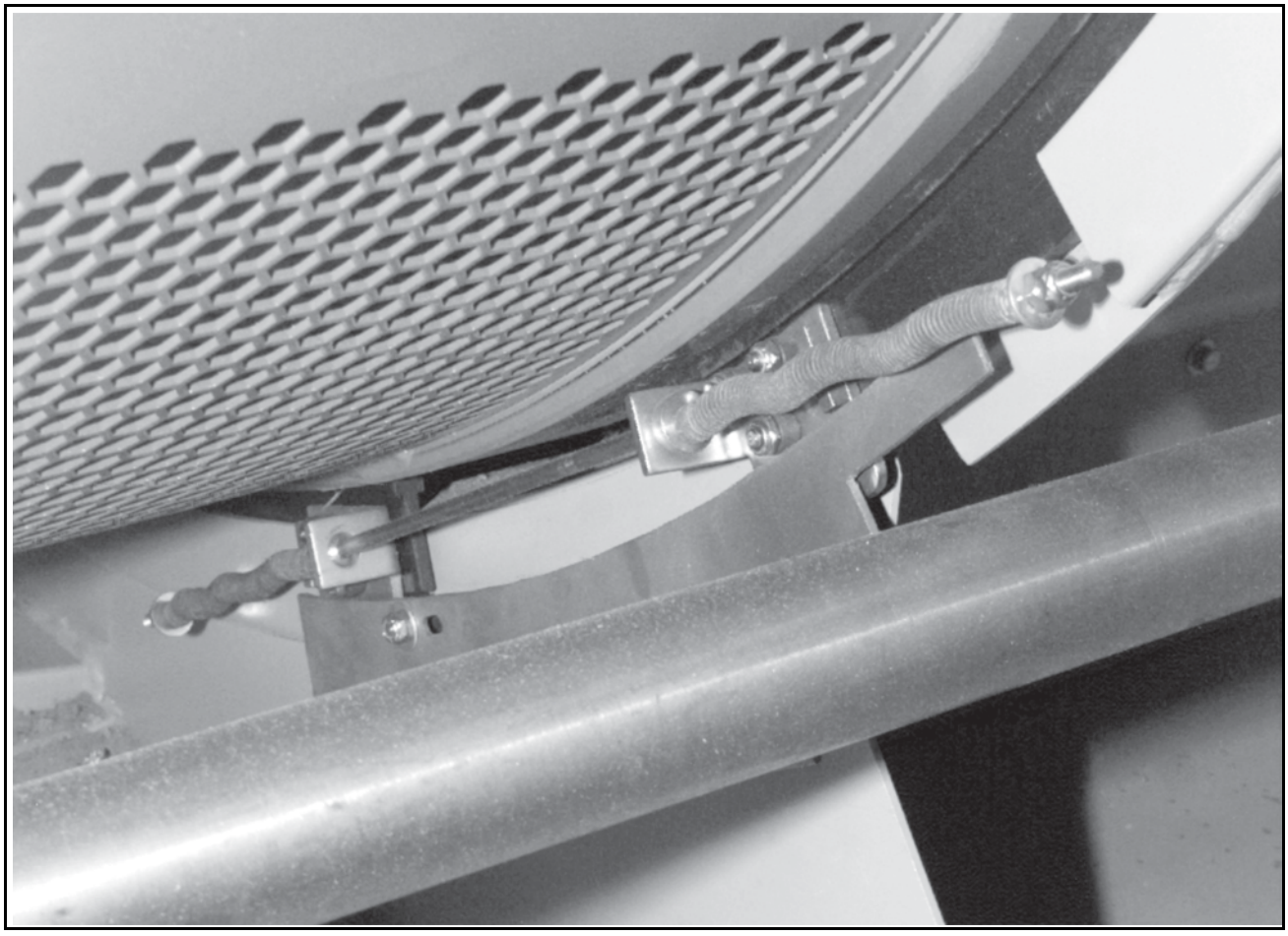


Table 29. Parts List—T-Seal Assembly

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	G74SH003	*5040 T-SEAL INSTALL 93213	
Components				
all	1	X7 41000	3BOLT T-SEAL NOTCH+DRIL 5040	
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	15G164	HX THIN LOCKNUT NYL1/4-20 SS	
all	6	15U188	FLTWASH 1/4 STD COMM SS18-8	
all	10	07 50498	RIBPLATE=STUD HOLDER T-SEAL	

T-Seal Assembly

3 Sheets

5050TG1L/R,TS1L/R

Table 29 Parts List—T-Seal Assembly (cont'd.)

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**
all	11	W7 50466A	*WLMT=SEAL/YOKE LF SIDE 3BOLT	
all	12	W7 50467A	*WLMT=SEAL/YOKE RT SIDE 3BOLT	
all	13	07 71509	6458 "T" SEAL RETAINER BKT	
all	14	15G170	HEXNUT 1/4-20UNC2 SS18-8	
all	15	54J004H	COLLAR=HEAT TREAT 45-55 RC	
all	16	15U200	FLATWASHER(USS STD) 5/16"ZNC P	
all	17	15N176A	TRUSSCR 1/4-2OUNCX3/4 SS18-8	
all	18	15G166A	HXLOKNUT NYL1/4-20 UNC2A STL/Z	

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4.1 Felt Seal Inspection and Maintenance

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Milnor® 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.

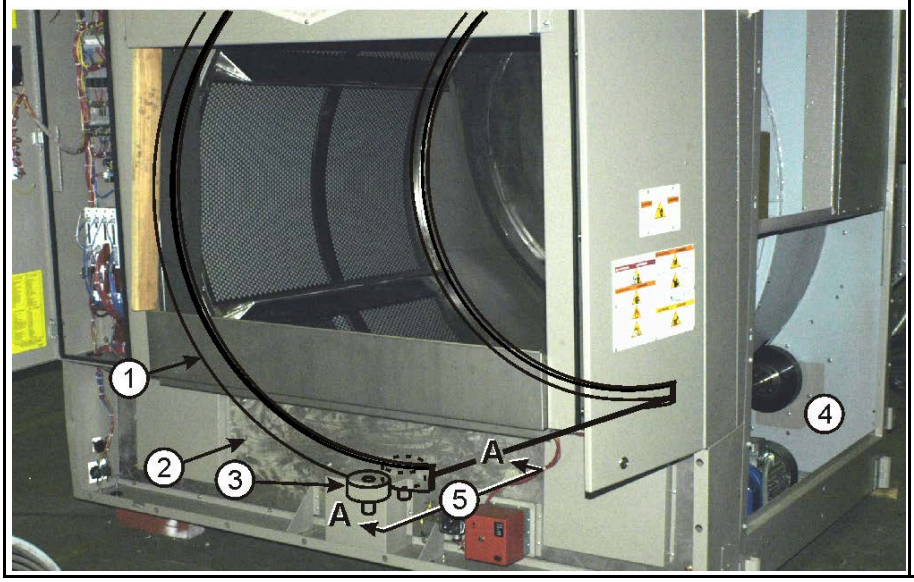
WARNING: Explosion hazard — If the basket seals deteriorate or spread apart, goods can become caught between the basket and shell front or get sucked into the blower wheel causing blower to fail and expel metal fragments at high speed. Bystanders can be struck.

- 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 25: Dryer Components Pertinent To This Work, page 83 .

Figure 25. Dryer Components Pertinent To This Work

Dryer—Access Panels Removed, Load/discharge Doors Blocked Open



Legend

1. Basket front ring
2. Shell front
3. Guide rollers (control basket front-to-rear position)
4. Basket drive components
5. Where section views in this document occur.

4.1.1 Inspecting the Seals and Selecting Replacement Seals

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WARNING: Crush hazard — 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.

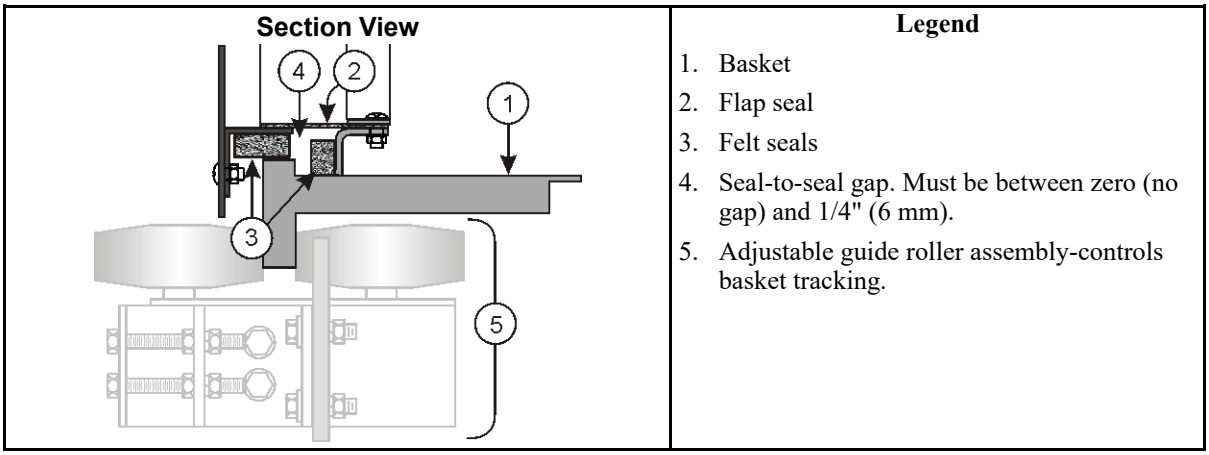
- Do not service machine unless qualified and authorized.
- Unload goods, lockout/tagout power at the external disconnect switch, block the doors open, and mechanically restrain the drive chain to prevent basket rotation.
- Lockout/tagout power at the external disconnect before accessing guide rollers.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

WARNING: Burn hazard — Hot goods and machine surfaces within a recently operated dryer can cause serious burns on contact.

- Do not service machine unless qualified and authorized.
- Ventilate and illuminate the dryer interior before entering the basket.

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 above), enter the basket.
3. Referring to Figure 26: Inspecting Seals, page 85 , lift the flap seal and inspect the felt seals.
   - If the seals are deteriorated, replace them as explained in Section 4.1.2 : Seal Replacement, page 85.
   - If the seals are in good condition, but the seal-to-seal gap exceeds 1/4" (25 mm), add felt, as explained in Section 4.1.3 : How To Close a Front Seal Gap, page 87.
   - Otherwise, return the dryer to service.

Figure 26. Inspecting Seals



4.1.2 Seal Replacement

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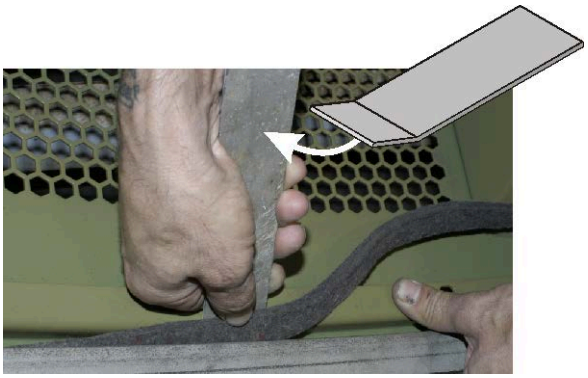
Refer to your "Cylinder Installation" parts document for seal and related component part identification. If you order the silicone rubber flap seal used on older models, you will receive the newer Nomex® seal, which should be used instead. 3M Rubber and Gasket Adhesive #1300, used to glue the felt seals 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 27, page 85 and Figure 28, page 85.

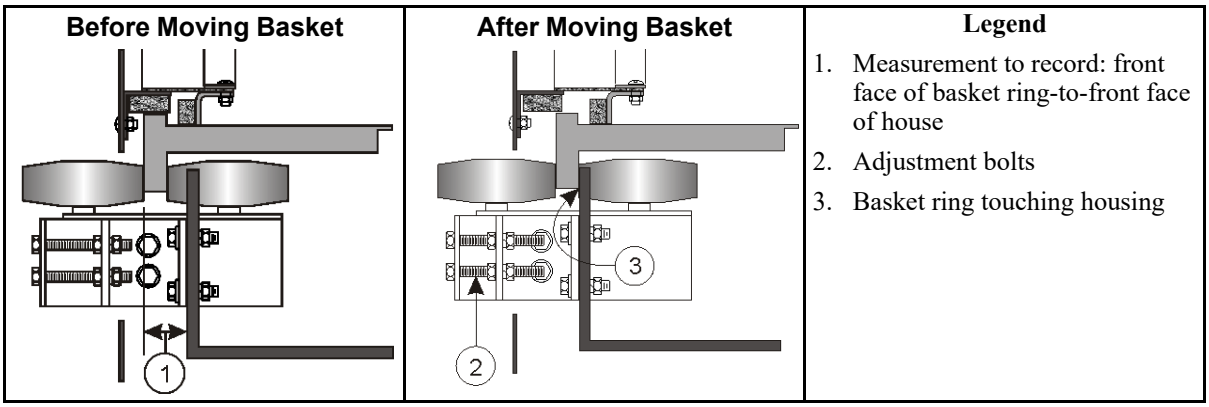
Figure 27. Adhesive applicator—1" paint brush, bristles held at an angle with tape

Figure 28. 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 (Figure 25, page 83).
   b. Measure and record the face of house-to-face of basket dimension (Figure 29, page 86, item 1). **When returning the dryer to operable condition, restore this dimension.**
   c. Use the guide roller adjustment bolts (Figure 29, page 86, item 2) to move the basket rearward until it is **lightly** touching the house (Figure 29, page 86, item 3).

Figure 29. 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 26: Inspecting Seals, page 85).
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 27, page 85 and Figure 30, page 86.
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 28, page 85 and Figure 31, page 86.

Figure 30. Section View: Applying Adhesive

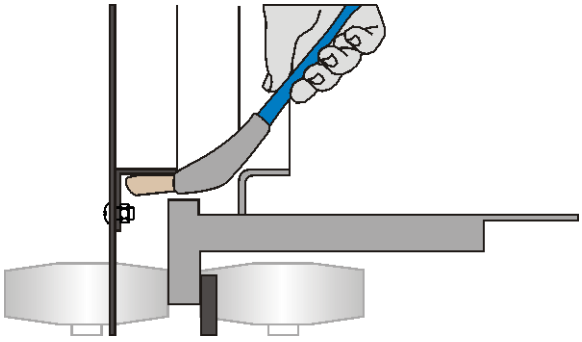
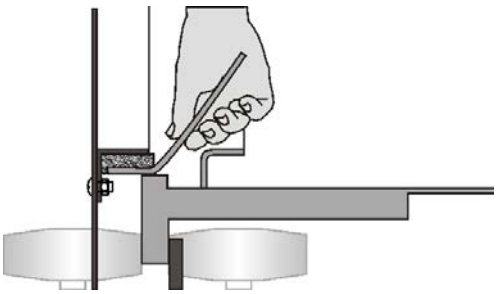


Figure 31. Section View: Setting Felt Seal



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.**

4.1.3 How To Close a Front Seal Gap

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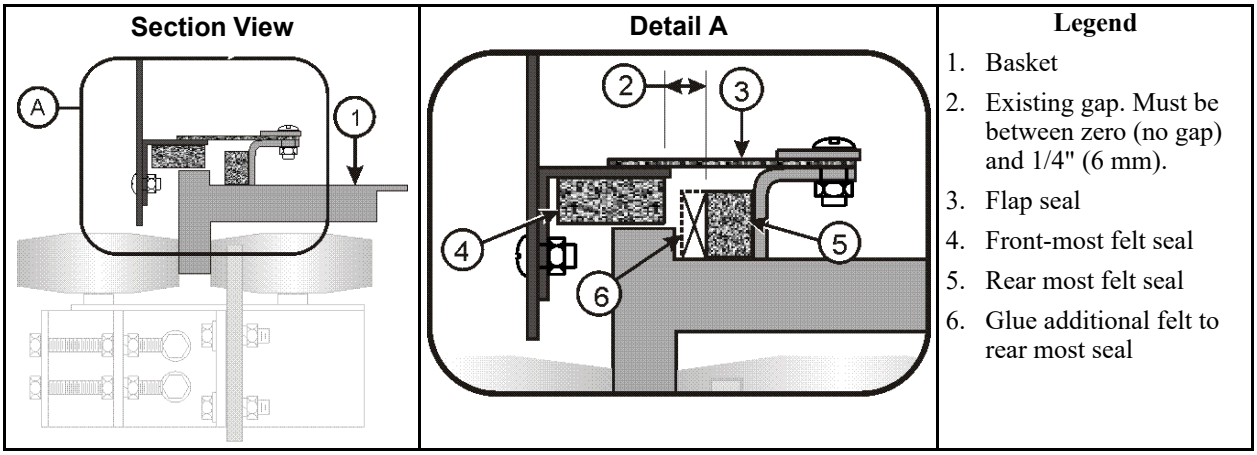
This instruction applies to all Milnor® dryer models.

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 rear most felt seal, as shown in Figure 32: Adding Felt to Existing Seal, page 87 . It is not necessary to replace the existing seals unless they are deteriorated.

Table 30. 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 rear most seal, if needed
27A689	Felt, 1/4" (6) thick x 3/4" (19) *	Add to rear most 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 32. 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 30: Materials Available from Milnor® for Closing Seal Gap, page 87) to the rear most felt seal as follows:

a. Cut length to fit around the circumference of the basket.

b. Apply adhesive (see Table 30, page 87) 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.

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Drive and Support Rollers

6 Sheets

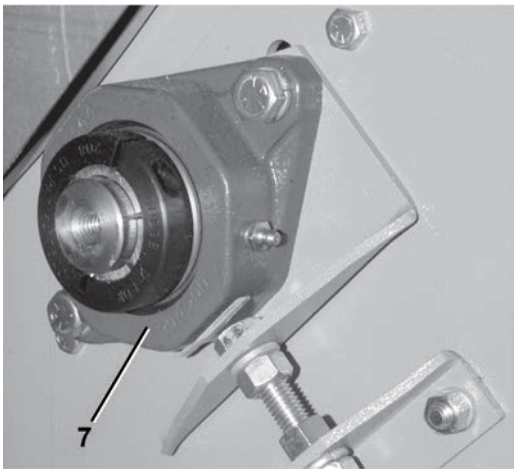
5050TG1L/R, TS1L/R

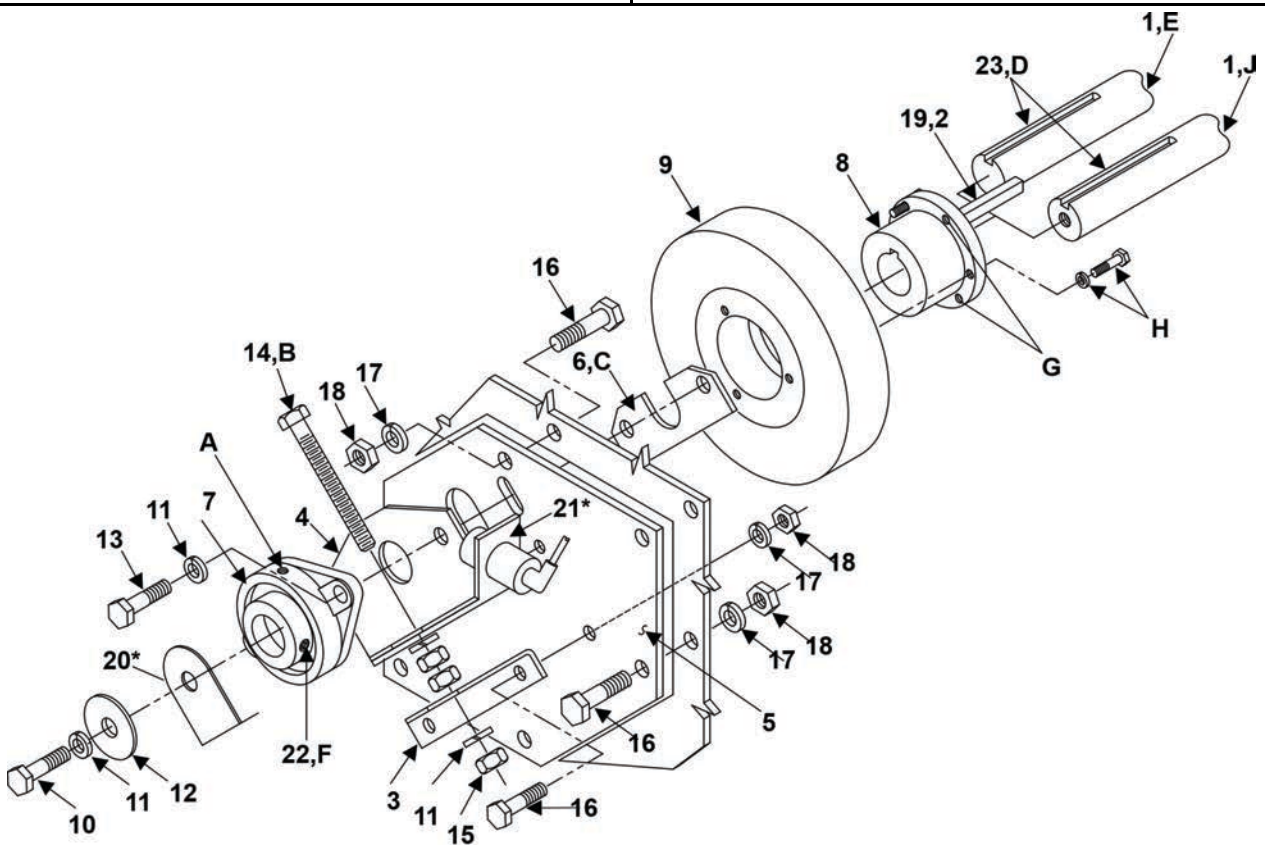
Figure 33. Exploded View of Drive and Support Rollers

NOTE: 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.

Legend

A . . . Lubrication lines, see Detail A
B . . . Adjustment bolt
C . . . Tap plate
D . . . Locktite 680 on shafts under bearings
E . . . Drive shaft
F . . . Locktite 242 on set screw
G . . . Bushing push off holes
H . . . Included with item 8
J . . . Support shaft



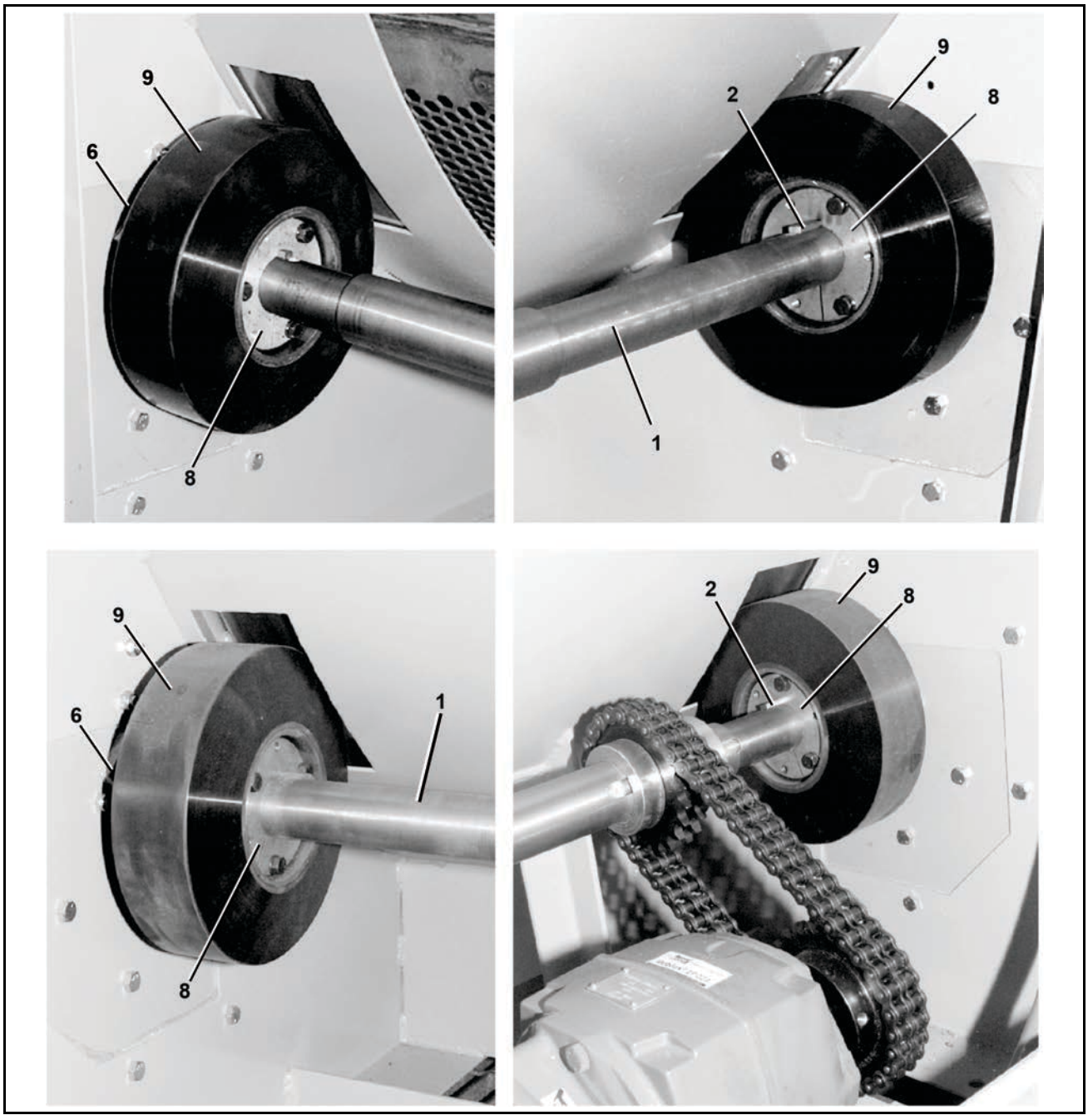


Drive and Support Rollers

6 Sheets

5050TG1L/R, TS1L/R

Figure 34. Rollers, Shafts, Bushings

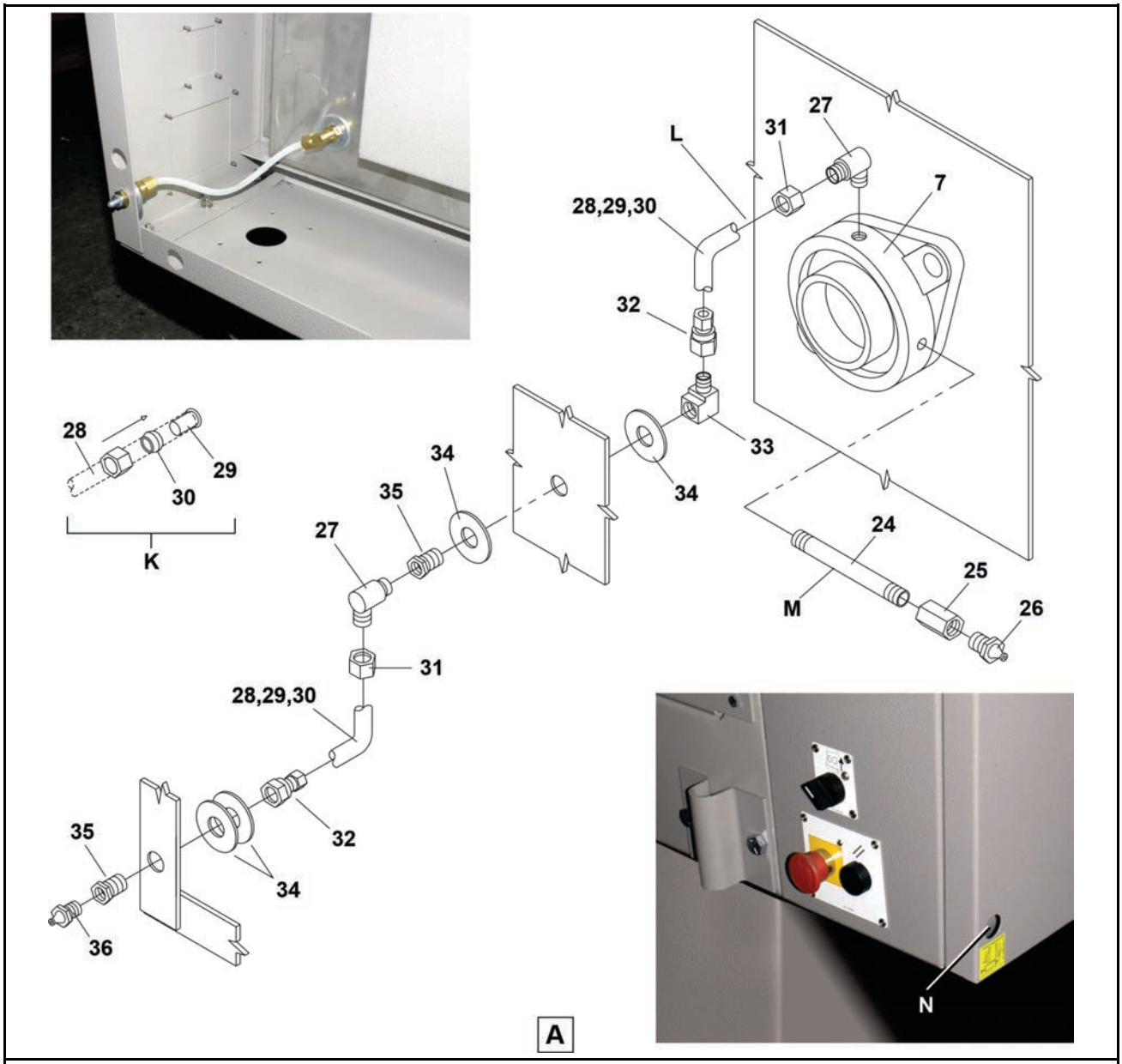


Drive and Support Rollers

6 Sheets

5050TG1L/R, TS1L/R

Figure 35. Lubrication Lines



Legend

K . . . Typical fittings, tubing ends
L . . . Front bearing lubrication lines
M . . . Rear bearing lubrication lines
N . . . Front bearing lubrication grease fitting (within)

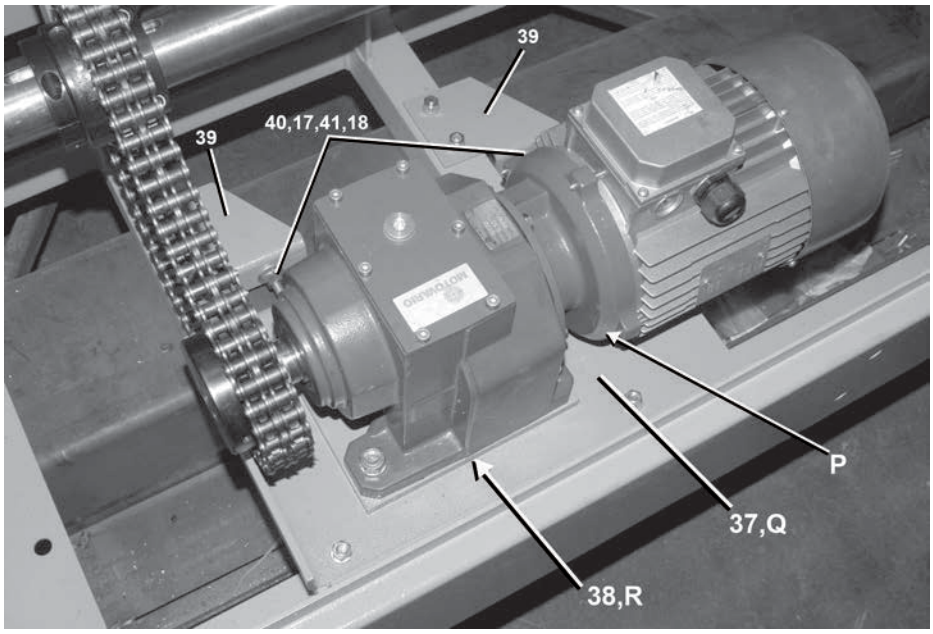
Drive and Support Rollers

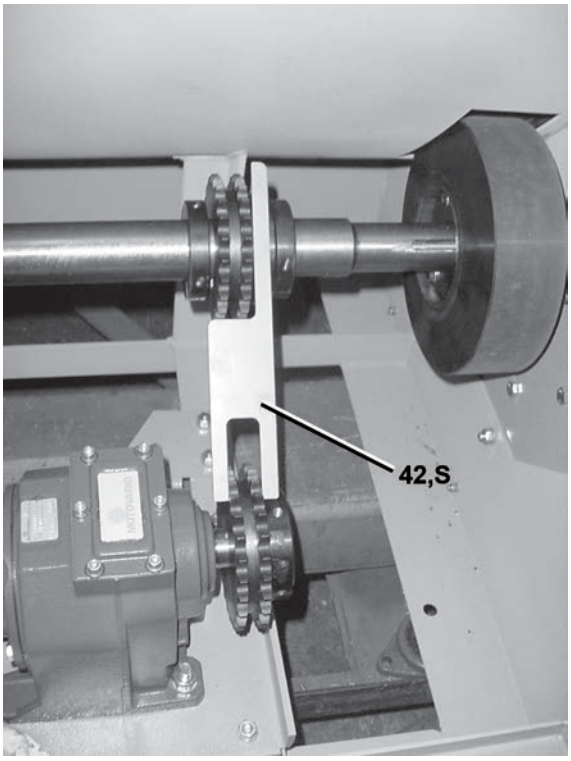
6 Sheets

5050TG1L/R, TS1L/R

Figure 36. Motor Mount and Sprocket Alignment

The 6458 Dryer is shown. The 5050 Dryer is similar, see parts list.





Legend

P . . . Motor mounting flange

Q . . . Base

R . . . Spacer must be installed to provide sufficient clearance between motor mounting flange and base.

S . . . Use the Sprocket Alignment Gage (item 42), shipped with the machine, to align the drive and driven sprockets.

Drive and Support Rollers

6 Sheets

5050TG1L/R, TS1L/R

Table 31. Parts List—Drive and Support Rollers

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	G74DB003	5050TG1 DRIVE INSTAL LF	5050TG1L, TS1L
	B	G74DB003A	5050TG1 DRIVE INSTAL RT	5050TG1R, TS1R
	C	A74DB005	5050TG1 CYLINDER DRIVE ASSY	
			Components	
all	1	X7 44050A	5050TG2 DRIVE SHAFT	
all	2	07 50031A	DRYER SHAFT KEY=WHEEL	
all	3	07 50127	BRKT=BEARING AJUST	
all	4	07 50128	BRKT=BEARING MOUNTING	
all	5	07 71280	6458 SUPP/DRIVE BEAR MTG PLT	
all	6	07 70049A	BEAR ADJUST TAP PLATE	
all	7	56F1H2CSWC	FLG BRG=1.438 B.D.+COLLAR	
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 FTL	
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	
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	6458/64 DRYER LF PHOTO EYE BRKT	
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	

Drive and Support Rollers

6 Sheets

5050TG1L/R, TS1L/R

Table 31 Parts List—Drive and Support Rollers (cont'd.)

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**
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	NPTELB 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	
all	37	07 44051	50" DRYER LF GEAR MTR SUPP PLATE	
all	38	07 44052	5040 GEAR REDUCER SPACER	
all	39	07 71166	50&64" DRYER LF MTR MNT ADJ BOLT BKT	
all	40	15K142	HXCAPSCR 3/8-16X6 GR8ZC	
all	41	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	42	07 71752	SPROCKET ALIGNMENT GAGE-6458	

5 Door Assemblies

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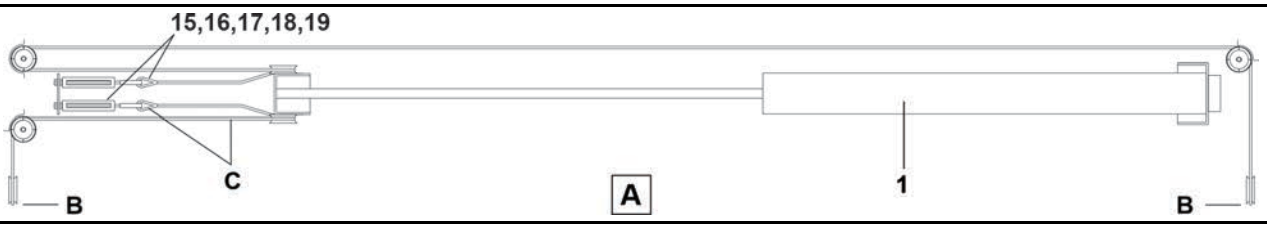
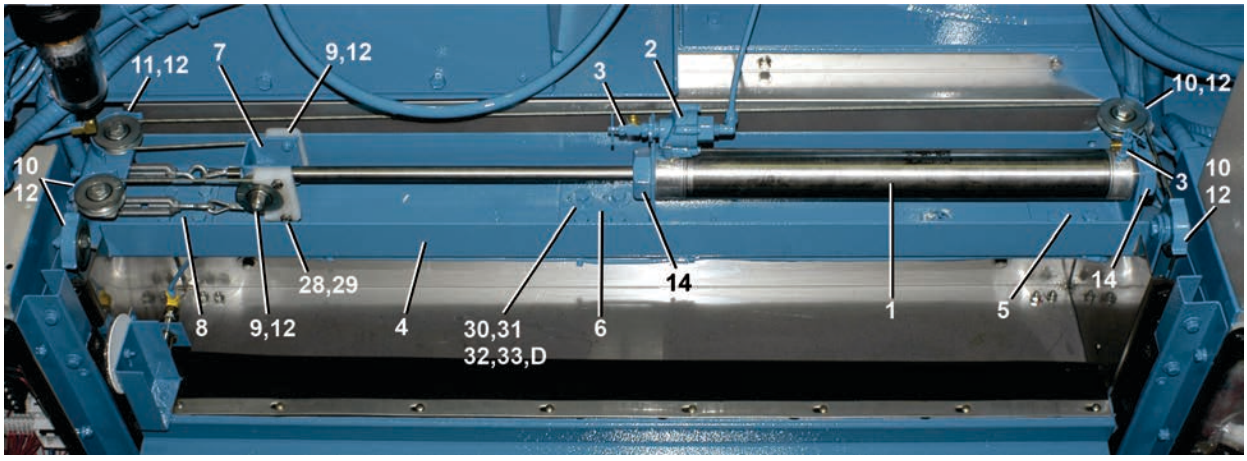
Load Door Installation

4 Sheets

5050TG1L/R,TS1L/R





Legend

A . . . Top view

B . . . From door lift brackets

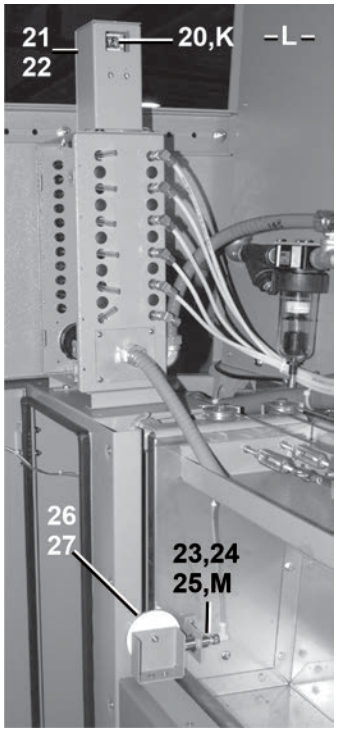
C . . . Lower cables and turnbuckles are shown to the inside for visibility. They should be perfectly in line with upper cables.

D . . . Typical, 19 instances

K . . . Full up photo eye

L . . . The 6458TG2R is shown. The 5050TG2LR/T2SLR parts are similar. See the parts list.

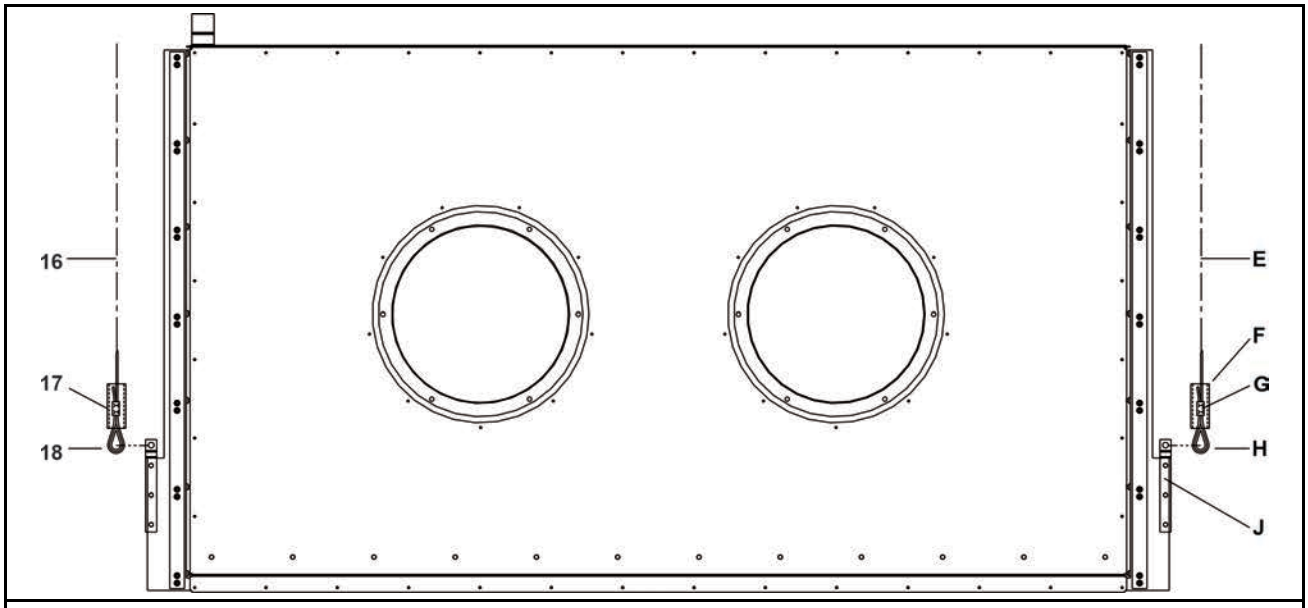
M . . . Full down proximity switch



Load Door Installation

4 Sheets

5050TG1L/R,TS1L/R



Legend

E . . . Cable
F . . . Hose
G . . . Sleeve
H . . . Eyelet thimble
J . . . Door lift bracket

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

4 Sheets

5050TG1L/R,TS1L/R

Table 32. Parts List—Load Door Installation

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	A74SD016	50" DRYER DOOR DRIVE ASSEMBLY	5050TG1L/R, TS1L/R
	B	A74SD012	5040 LD DOOR CABLE SHORT	
	C	A74SD013	5040 LD DOOR CABLE LONG	
			Components	
all	1	27C220	AIR CYL 2"BORE X 15"STROKE	
all	2	96M055	DELTROL QUICK EXHAUST VLV.1/4"	
all	3	96H018	ANGLE NEEDLE VLV 1/4"T X 1/8MP	
all	4	07 44172	50" DRYER LOAD DOOR CYLINDER BRACKET	
all	5	07 44178	5040 DOOR CYL BRKT RT	
all	6	07 44183	5040 LD CYL BRKT FRONT	
all	7	07 44179	5040 LD AIR CYL PULL MT BRKT	
all	8	07 44180	5040 WIRE MT BRKT	
all	9	07 40937	UHMW PULLEY GUIDE AIRCYL	
all	10	W7 71197	6458 90 DEG PULLEY GRD WELD	
all	11	W7 71199	6458 180 DEG PULLEY GRD WELD	
all	12	27A965	PULLEY ZINC PLATE #CPS6150	
all	13	07 44185	AIR CYLINDER MOUNT SPACER	
all	14	15G264A	HEXJAMNUT 1+1/4-12UNF 2B ZINC	
all	15	17A051	EYEBOLT 1/4-20X2"LONG ZINC	
all	16	27A964B	CABLE 3/32" 3095GN4 GALVANIZED	
all	17	27A963B	LOOP SLEEVE 3/32" 7092A	
all	18	27A962B	THIMBLE SS 3/32 AN100-4	
all	19	17A074	TURNBKLE 1/4X4 EYE+EYE ZINC	
all	20	09RPE011	PHOTOEYE VALU-BEAM 10-30DC	
all	21	03 E3X6A	ENCL:PHOTOEYE MOUNTING BOX	
all	22	03 E3X6B	PHOTOEYE COVER	
all	23	09RPS30ADS	PROX SW QK CONN 30M NO-DC SHLD EUROFAST	
all	24	09RPSDC095	CON.90DEG FEMALE DC 3A300V 5M WK4T-6	
all	25	07 40959	LOAD DOOR PROXIMITY SWT BRKT	
all	26	07 44188	BRKT=LOAD DR PHOTO/PROX	
all	27	09RPE001A	REFLECTOR 3"DIA CLEAR	
all	28	15K041	HXCAPSCR 1/4-2OUNC2AX1 GR 5 ZI	
all	29	15G164	HX THIN LOCKNUT NYL1/4-20 SS	

Load Door Installation

4 Sheets

5050TG1L/R,TS1L/R

Table 32 Parts List—Load Door Installation (cont'd.)

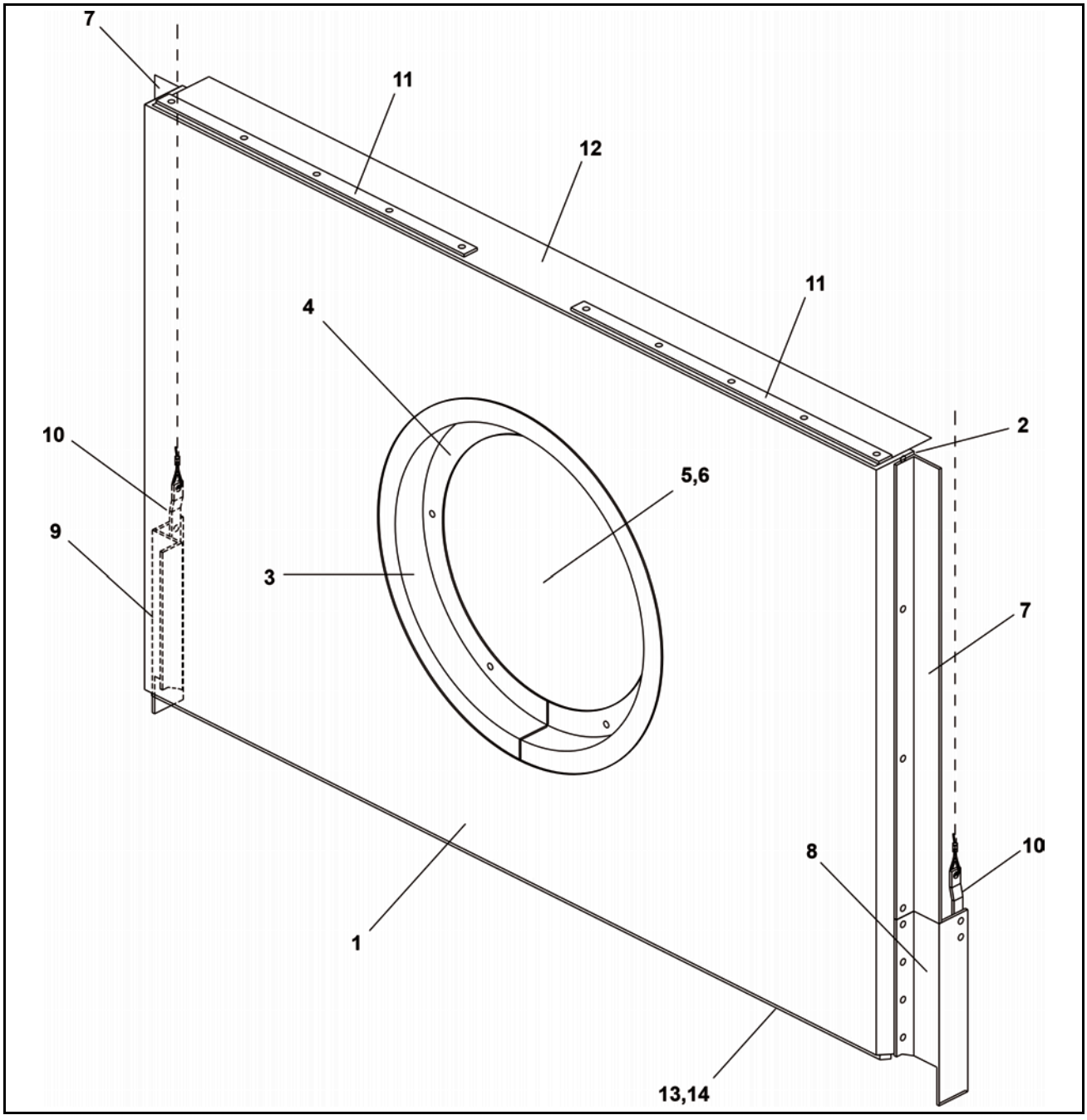
Find the assembly for your machine and the letter shown in the "Item" column. The components for your machine will show this letter or the word "all" in the "Used In" column. The numbers shown in the "Item" column are those shown in the illustrations.				
Used In	**Item**	**Part Number**	**Description/Nomenclature**	**Comments**
all	30	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	31	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	32	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	33	15G205	HXNUT 3/8-16UNC2B ZINC GR2	

BPDD5D02 / 2022284 BPDD5D02.1 0000500509 A.4 7/6/22, 11:17 AM Released

Load Door

2 Sheets

5050TG1L/R,TS1L/R



Load Door

2 Sheets

5050TG1L/R,TS1L/R

Table 33. Parts List—Load Door

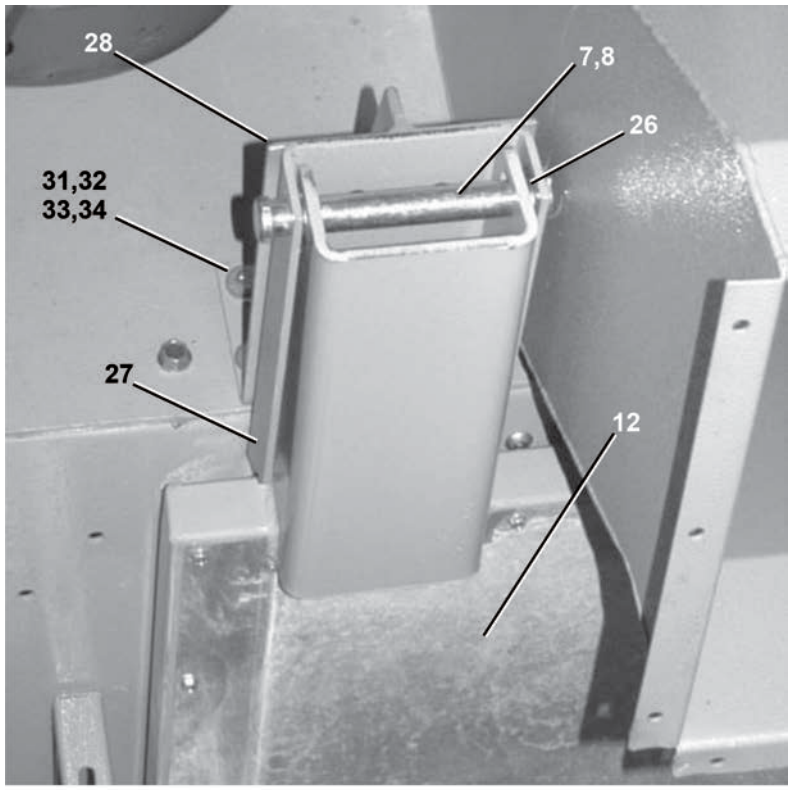
Find the assembly for your machine and the letter shown in the "Item" column. The components for your machine will show this letter or the word "all" in the "Used In" column. The numbers shown in the "Item" column are those shown in the illustrations.				
Used In	**Item**	**Part Number**	**Description/Nomenclature**	**Comments**
Reference Assemblies				
	A	A74SD015	ASSY=50" DRYER LOAD DOOR	
Components				
all	1	07 40914	LOAD DOOR MAIN - OUTSIDE	
all	2	07 40916	LOAD DOOR MAIN - S/S INSIDE	
all	3	W7 40915	*WLMT = SIGHT GLASS RING	
all	4	07 50057	RING=SIGHGLASS LOAD DOOR	
all	5	02 02366A	GASKET DOORGLASS = DRYER	
all	6	02 09215	DRGLASS 12 3/8DIA SS STAMPED	
all	7	07 40917	LOAD DOOR SEAL-TALL	
all	8	07 44182A	5040 LD SEAL RIGHT	
all	9	07 44182	5040 LD SEAL LEFT	
all	10	07 44184	5040 DOOR WIRE BRKT	
all	11	07 50012	LOAD DOOR SEAL STRAP	
all	12	07 50013A	RUBBER LOAD DOOR SEAL WIDE	
all	13	27A680	FELT 1/4"THK X 1"W SAE F-7	
all	14	20C044	RUB/GASKET ADH 3M#EC1300 PINTS	

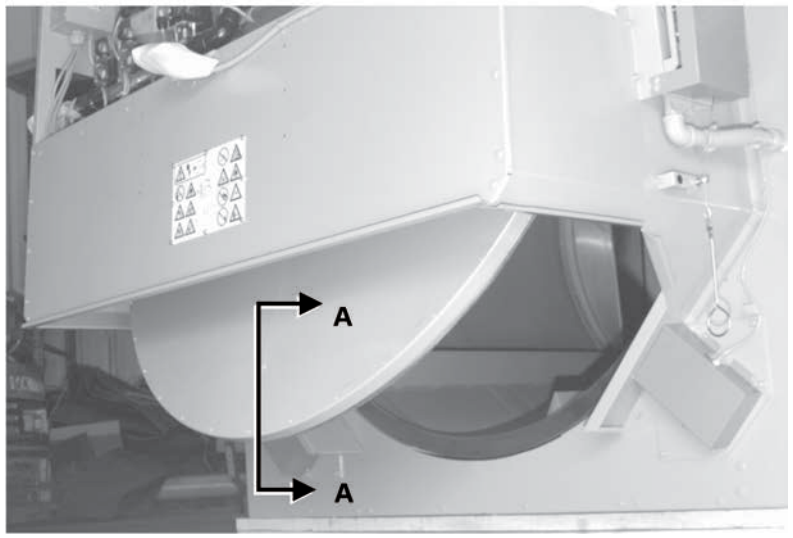
BPDD5D03 / 2022304 BPDD5D03.1 0000502890 A.4 7/21/22, 8:29 AM Released

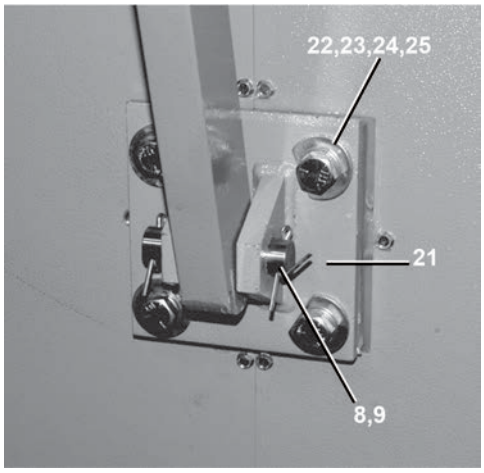
Unload Door

4 Sheets

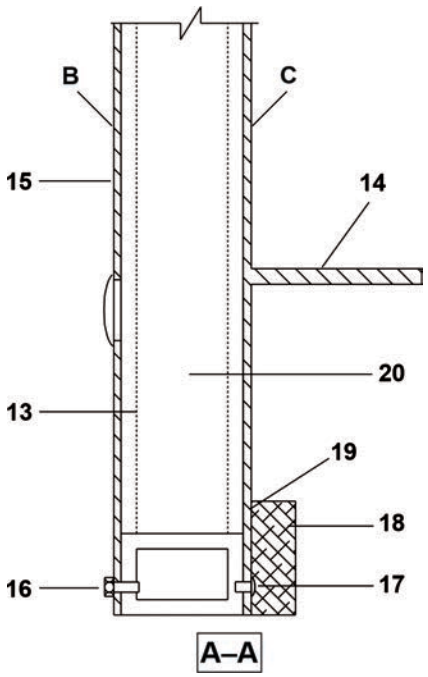
5050TG1L/R,TS1L/R







Unload Door Assembly



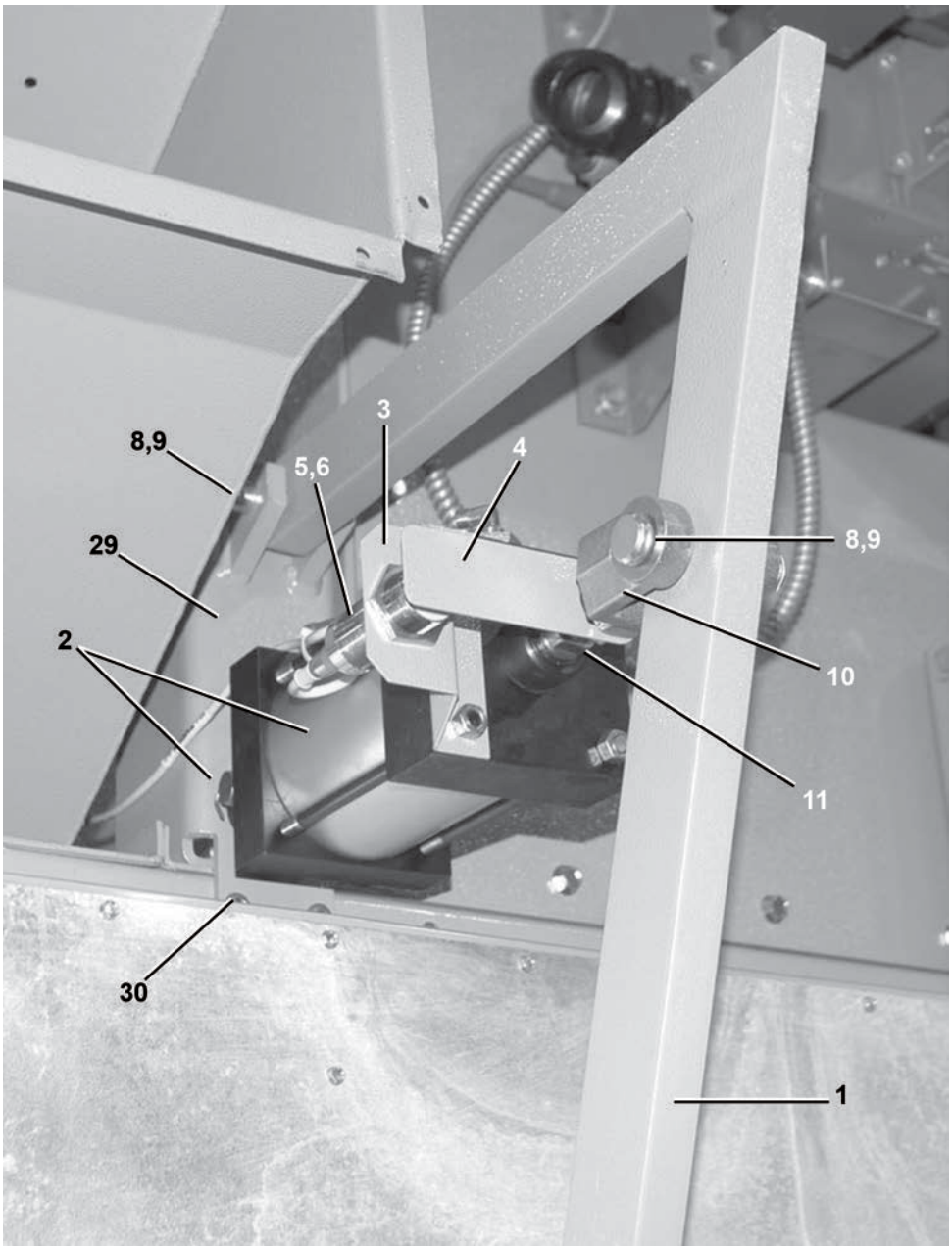
Legend

A–A . . Detail view
B . . . Outer cover
C . . . Inner cover

Unload Door

4 Sheets

5050TG1L/R,TS1L/R



Unload Door

4 Sheets

5050TG1L/R,TS1L/R

Table 34. Parts List—Unload Door

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	G74SD014	5040TG2 UNLOAD DOOR WIDE INST	DOOR INSTALLATION
	B	A74SD014	5040 UNLD DR ASSY REAR DISCHRG	DOOR ASSEMBLY
			Components	
all	1	W7 40712	*UNLOAD DOOR LINK-ARM WLD5040	
all	2	27C650	AIR CYL 4"X3.5"X1" CLEVIS MNT.	
all	3	07 71132	6458 UNLOAD DOOR PROX BKT	
all	4	07 71133	6458 UNLOAD DOOR PROX TARGE	
all	5	09RPS30CAS	PROXSW QK CONN 30M NO-AC SHLD	
all	6	09RPTAC005	CONN.ST.FEM 3-PIN AC 3A 5M	
all	7	17A044A	CLEVIS PIN 3/4X5+21/32 ZN SPEC	
all	8	15H051	STDCOTTERPIN 1/8X1+1/2ZINCPL	
all	9	17A045A	CLEVIS PIN HARD CHROME3/4X3.09	
all	10	17A049B	CLEVIS ROD END 3/4-16#RC-0750	
all	11	15G239S	HEXJAMNUT 3/4-16UNF2 SS18-8	
all	13	W7 44004	5040 UNLD DR FRAME WELD WIDE	
all	14	W7 44000	5040 UNLD DR INNER SKIN WELD	
all	15	07 44009	5040 INSUL COVER UNLD DR WIDE	
all	16	15P059	SCRHXSELFDR:10-16X1/2 #2 ZINC	
all	17	15P053	8-18X3/4 PPHTEKSSW/MICROSPHERE	
all	18	27A682	FELT 3/8"THK X 1"W SAE F-7	
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	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	23	15K173A	HXCAPSCR 1/2-13UNC2AX1.75 GR5	
all	24	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	25	15U280C	FLATWASH(US STD)1/2"CLIP+ZNC	
all	26	15U320P	FLATWASHER(USS STD) 3/4" ZNC P	
all	27	07 44041	5040 UNLOAD DOOR HINGE	
all	28	W7 44098	5040 REAR EXHAUST UNLD WELD	
all	29	W7 44040	WLMT=50"DRYER UNLOAD DOOR CYL	
all	30	15K084	TRUSS HXSOK 3/8-16 X 23/32SS	
all	31	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	

Unload Door

4 Sheets

5050TG1L/R,TS1L/R

Table 34 Parts List—Unload Door (cont'd.)

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**
all	32	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	33	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	34	15G205	HXNUT 3/8-16UNC2B ZINC GR2	

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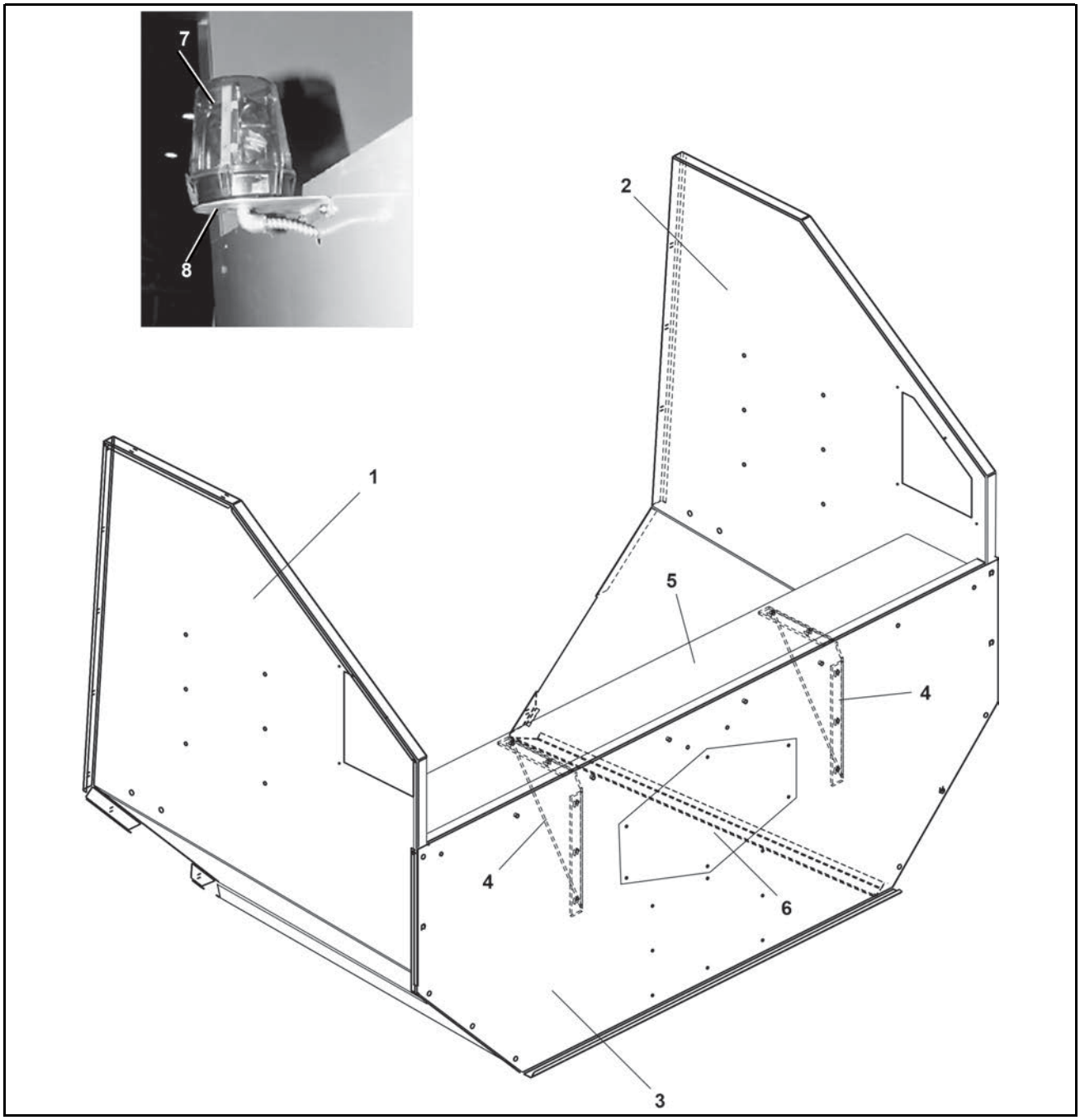
Unload Shroud

2 Sheets

5050TG1L/R,TS1L/R



Unload Shroud

2 Sheets

5050TG1L/R,TS1L/R

Table 35. Parts List—Unload Shroud

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	G74GS002	5040 UNLOAD SHROUD	
Components				
all	1	07 41230	5040 UNLOAD SHROUD RIGHT	
all	2	07 41230A	5040 UNLOAD SHROUD LEFT	
all	3	07 41231	5040 UNLOAD SHROUD BACK PLT	
all	4	07 71169	SHIP BRKT=UNLOAD DOOR	
all	5	07 41232	5040 GAS PIPE SUPPORT PLT	
all	6	01 10034A	NAMEPLATE,LARGE "MILNOR" LOGO	
all	7	09H025V37	BEACON ROTARY 5.5" AMBER	
all	8	03 BL1X6Y	BRKT:MIC6 DRY FLASH DIS LITE	

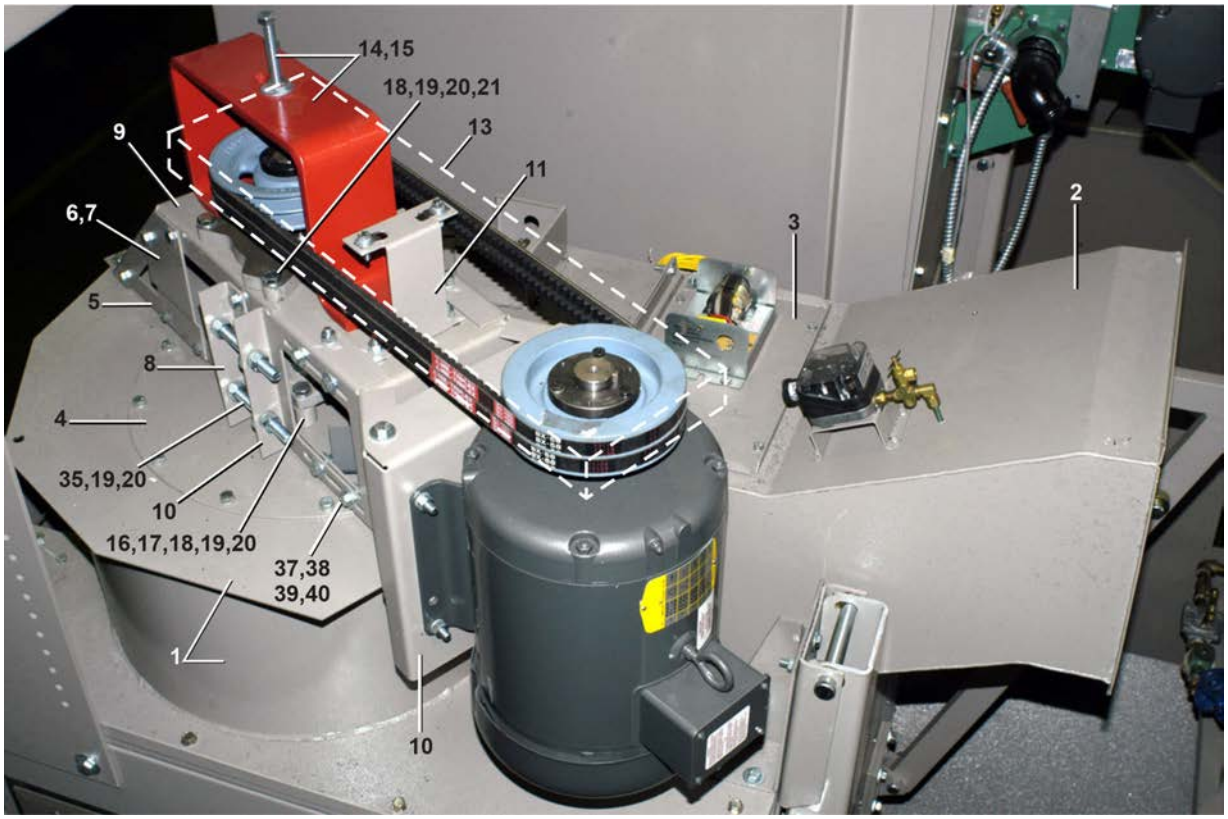
6 Air Flow Assemblies

BPDD5A01 / 2022413 BPDD5A01.1 0000524264 A.4 A.5 10/4/22, 10:54 AM Released

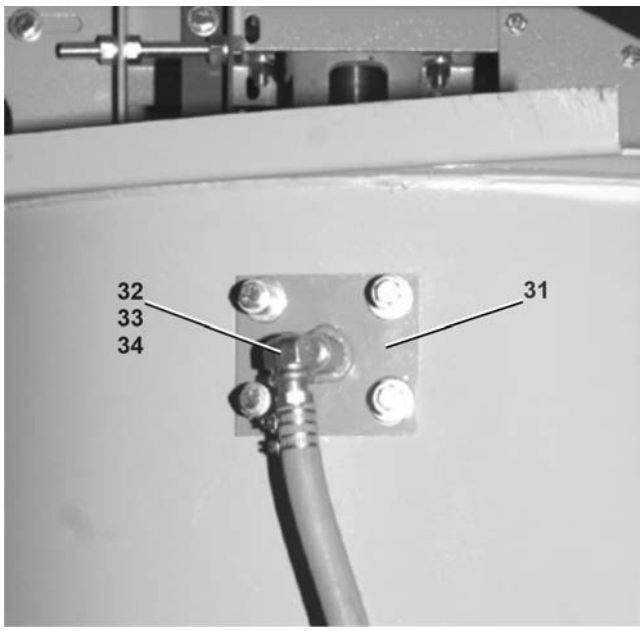
Blower Installation & Exhaust Duct to Rear

5 Sheets

5050TG1L/R,TS1L/R



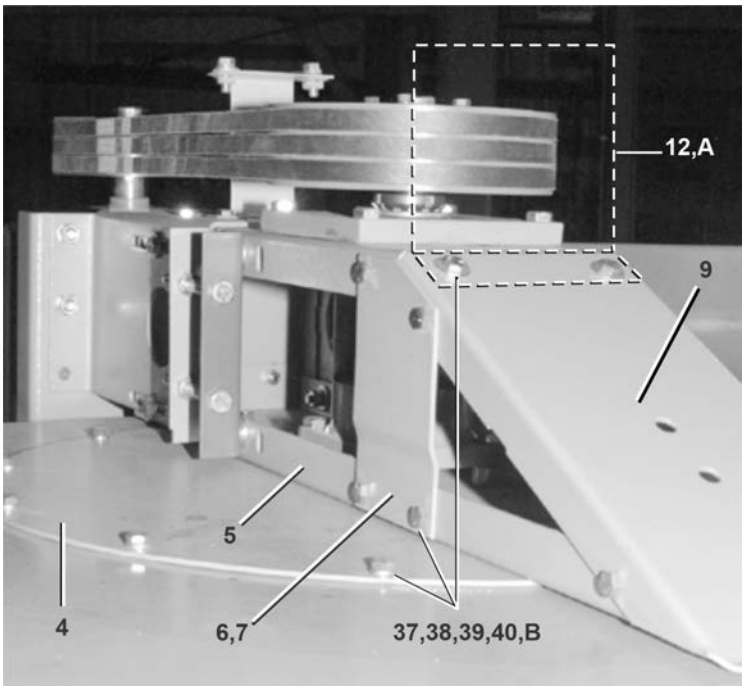
Blower Blow Down



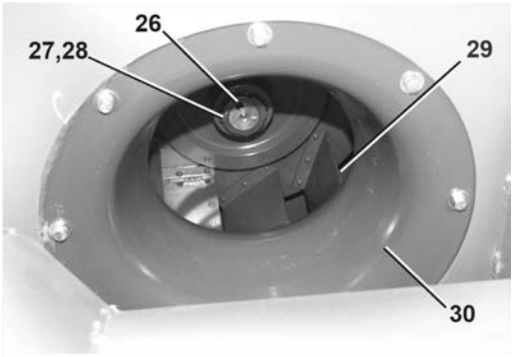
Blower Installation & Exhaust Duct to Rear

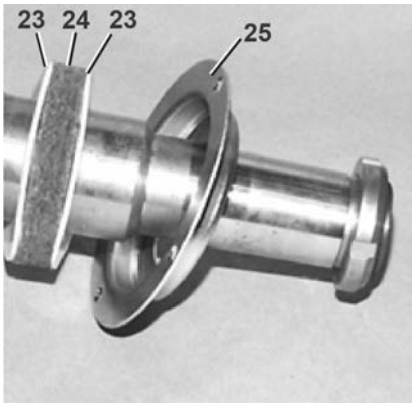
5 Sheets

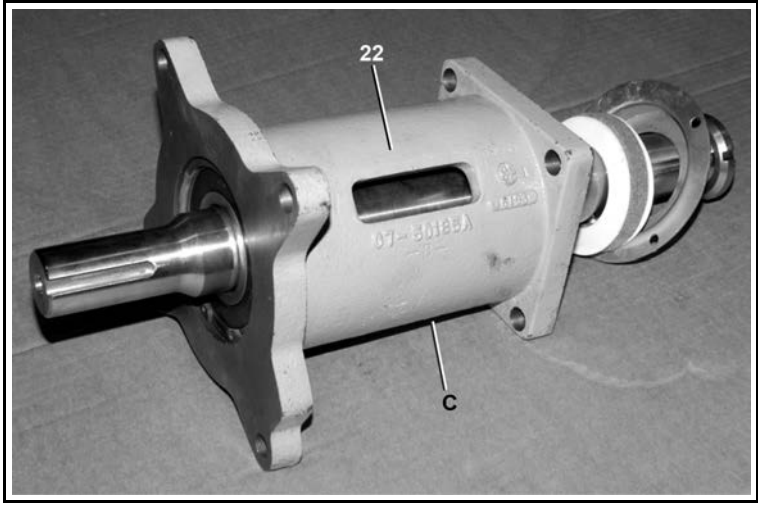
5050TG1L/R,TS1L/R



Underside of Blower







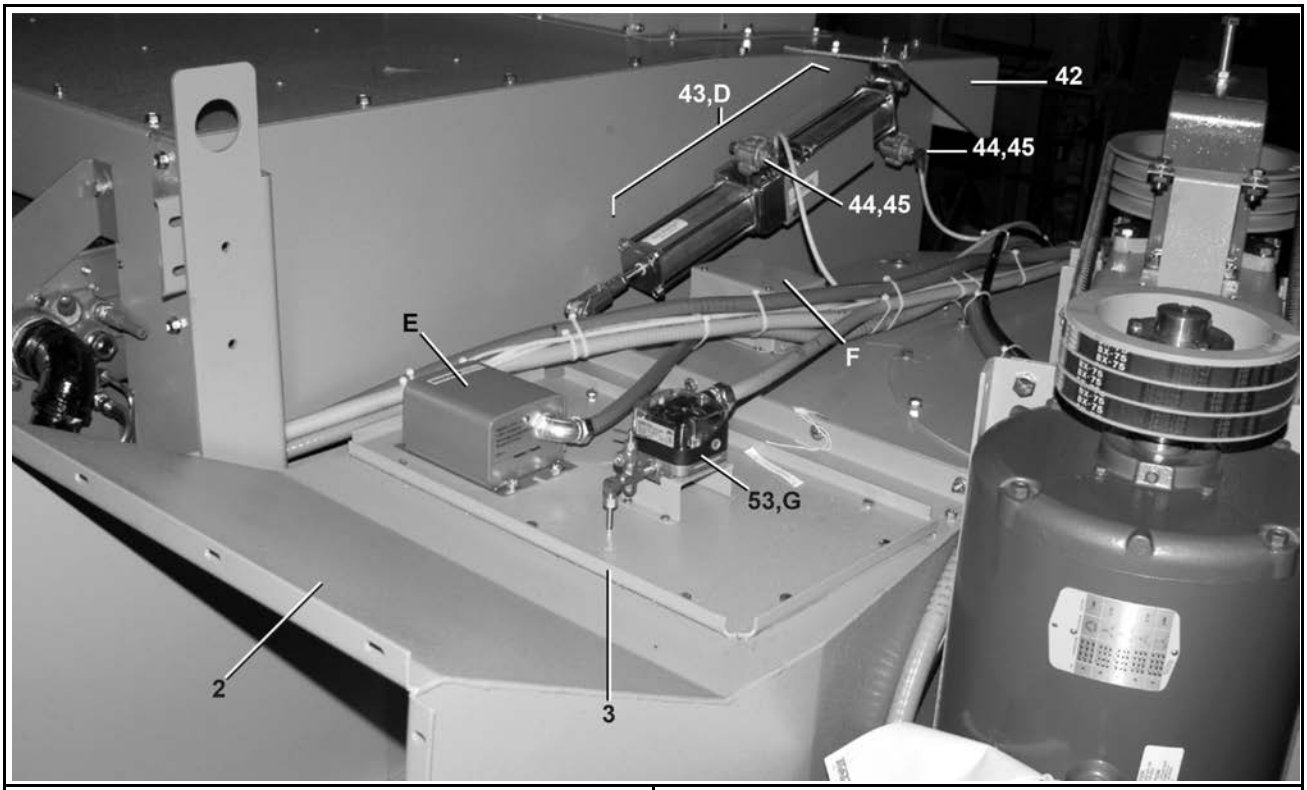
Legend

A . . . Belt guard support bracket
B . . . Typical
C . . . For bearing assembly see BPDDUB01

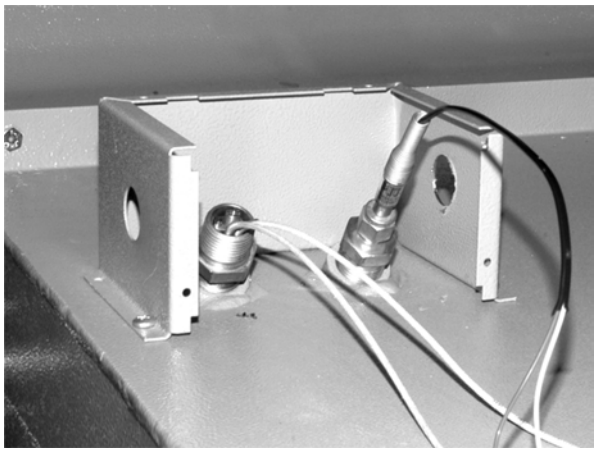
Blower Installation & Exhaust Duct to Rear

5 Sheets

5050TG1L/R,TS1L/R



Outlet Probes



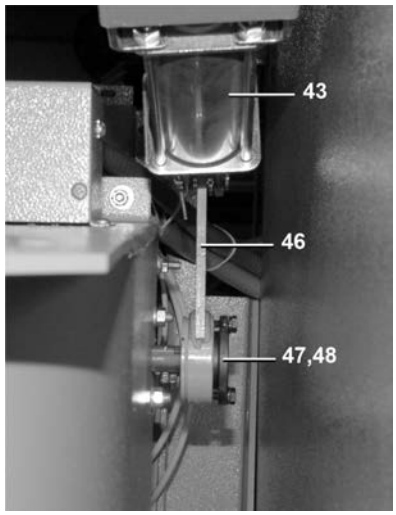
Legend

D . . . For air cylinders see BPDDUP01
E . . . Spark generator (TG1R,TG1L)
F . . . Outlet probes
G . . . Back pressure switch

Blower Installation & Exhaust Duct to Rear

5 Sheets

5050TG1L/R,TS1L/R



Blower Exhaust Duct

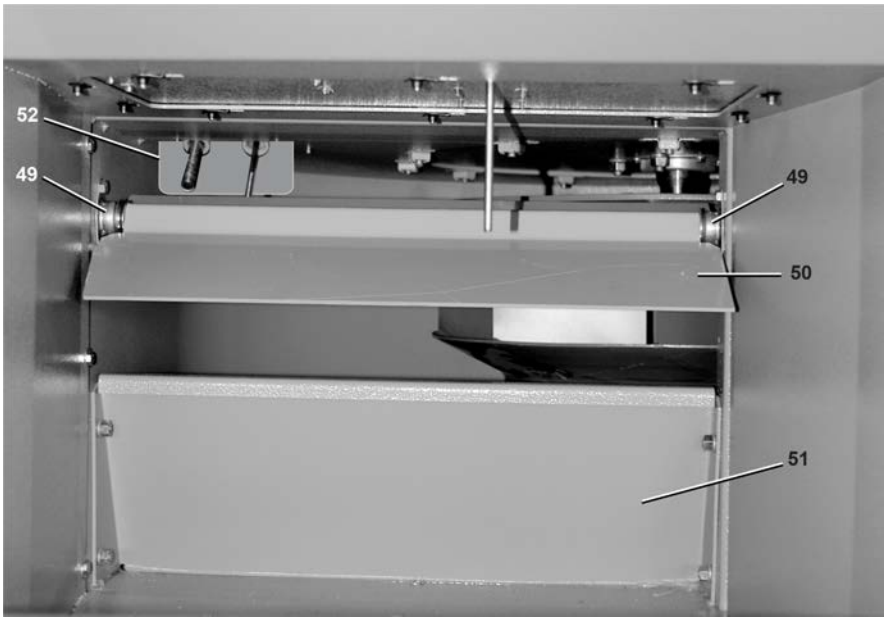


Table 36. Parts List—Blower Installation & Exhaust Duct to Rear

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	A74BA001B	5040 BLWR+DMPR ASSY GAS-LEFT	BLOWER LEFT
	B	A74BA001C	5040 BLWR+DMPR ASSY GAS-RIGHT	BLOWER RIGHT
			Components	
A	1	W7 40456A	5040 BLOWER WELDMENT-LEFT	
B	1	W7 40456B	5040 BLOWER WELDMENT-RIGHT	
A	2	W7 40452A	WLMT=5040 LT BLOWER EXHAUST	
B	2	W7 40452B	WLMT=5040 RT BLOWER EXHAUST	
all	3	07 40446	COVER=DAMPER ACCESS	
all	4	07 60037	15" BLOWER HSG. COVER PLATE	
all	5	07 60078A	15"BLWR BKT MTR BOT CHNL	
all	6	07 60090	15"BLOWER BKT.SUPPORT L.	
all	7	07 60090A	15"BLOWER BKT SUPPORT R	
all	8	07 50252	ANGLE=BELT ADJ BLOWER MOTOR	
all	9	07 60077A	15"BLWR BKT MTR TOP CHNL	
all	10	07 60039	50" DRYER 15"BLOWER MOTOR MT BRKT	
all	11	07 50262	BRACKET=MAIN BLW BELT GUARD	

Blower Installation & Exhaust Duct to Rear

5 Sheets

5050TG1L/R,TS1L/R

Table 36 Parts List—Blower Installation & Exhaust Duct to Rear (cont'd.)

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
all	12	07 60075	BRKT=15"BLOWER BELT GUARD LFT	
all	13	07 50268	50" DRYER BLOWER BELT GUARD	
all	14	07 50187	DRYER SHIPPING BLWR BEARING HOLDER	
all	15	15D119	HXTAPSCR 1/2-13X4 GR5 ZNC FTL	
all	16	07 50179	BLOWER BRG HSE SPACER=00143	
all	17	15K198	HEXCAPSCR 1/2-13UNC2AX3 GR5 ZI	
all	18	15U243	FLTWASHER 7/8ODX33/64IDX16GA Z	
all	19	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	20	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	21	15K182	HEXTAPSCR 1/2-13X2ZINC GR5 FUL	
all	22	A75BG004	BLW BRG HSE ASSY=2001354	
all	23	07 50288	BLOWER SHAFT TEFLON SEAL	
all	24	07 50287	BLOWER SHAFT FELT SEAL	
all	25	07 50286	BLOWER SHAFT SEAL CAP	
all	26	15E225	SQMACHKEY 3/8X1+1/2 NOTAPER-NO	
all	27	56AHN08	N08 BEARING LOCKNUT	
all	28	56AHW108	TW108 BEARING LOCKWASHER	
all	29	13E150TCCW	BLOWER WHL 15"CL-2 CCWTABERHUB	
all	30	07 60067	15" DIA INLET NOZZLE 5840	
all	31	W7 60265	*LINT NOZZLE PLATE WLMT	
all	32	51E505	HOSESTEM BRASS 3/8H XMPT	
all	33	12P014SZ	TUBE CLAMP 1/2"ST/Z TIN#4886S	
all	34	60E005F	TUBING NYL.BLK.1/2"ODX.375ID	
all	35	15K202	HEXCAPSCR 1/2-13UNC2AX5 GR5 ZI	
all	36	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	37	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	38	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	39	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	40	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	41	17N070P	RETAIN NUT 3/8-16 #S10100-27	
A	42	07 44163	5040 L REAR EXH MAIN CYL SUPP	
B	42	07 44163A	5040 R REAR EXH MAIN CYL SUPP	
all	43	A77AC003	6458 MAIN DAMP CYL ASSY	
all	44	96M055	DELTROL QUICK EXHAUST VLV.1/4"	

Blower Installation & Exhaust Duct to Rear

5 Sheets

5050TG1L/R,TS1L/R

Table 36 Parts List—Blower Installation & Exhaust Duct to Rear (cont'd.)

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
all	45	5SP0GFFSSV	NPT PLUG 3/8 SQSOLIDVENTBLKSTL	
all	47	15E195	SQMACHKEY 3/16X1+1/2 NOTAPER&H	
all	48	56Q0PH	3/4" BROWNING H BUSHING TYPE 1	
all	49	54E015	FLGMTBRG 3/4 BORE BRZ #FLB12	
all	50	W7 60060	*15"BLOWER DAMPER WLMT	
all	51	07 60057	15" BLOWER CUTOFF PLATE-LT	
all	52	07 71040	FENWALL DEFLECTOR	
all	53	A77BP001	6458 BACK PRESSURE SWIT ASSY	

BNDDUM01 / 2022422 BNDDUM01 0000524620 10/10/22, 9:18 AM Released

6.1 Main Air Blower Wheel Replacement

BNDDUM01.C01 0000524619 A.2 A.4 10/7/22, 4:01 PM Released

NOTICE: "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.

6.1.1 Resources Needed

BNDDUM01.C02 0000524618 A.3 A.4 10/10/22, 8:08 AM Released

- 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 37: Preparing for the Work, page 116)
- 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

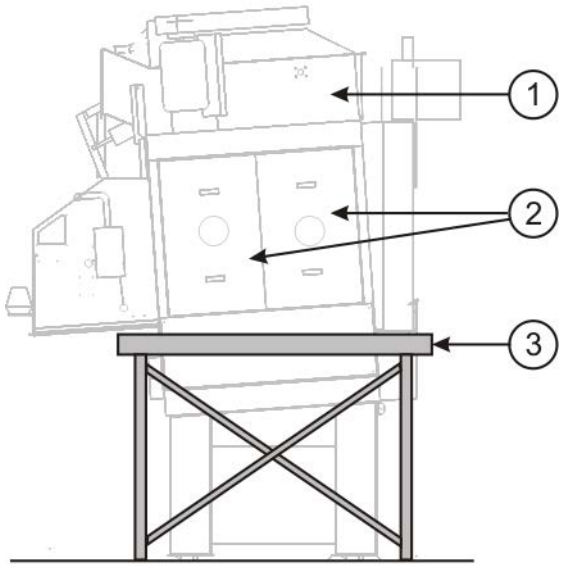
6.1.2 Preparations

BNDDUM01.C03 0000524615 A.2 A.4 10/7/22, 4:01 PM Released

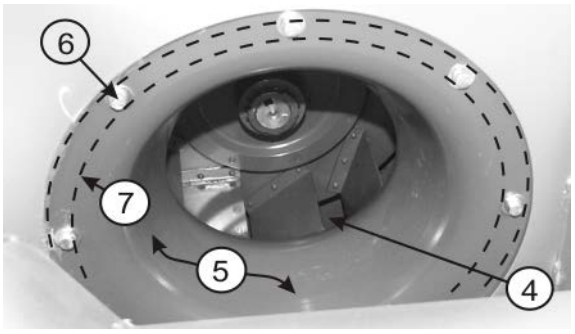
1. Familiarize yourself with the blower assembly (see the service manual).
2. Set up the scaffold or platform against the blower side of the dryer as shown in Figure 37, page 116.
3. **Remove electrical power from the machine (see Notice above).** Allow the machine to cool.
4. Remove the two access panels on the blower side of the dryer housing.

Figure 37. Preparing for the Work

Blower-side View (may be opposite hand)



View of Cone and Blower from below



Legend

1. Blower housing
2. Side panels to remove
3. Scaffold or platform to work on.
4. Blower wheel
5. Cone
6. 3/8" hex bolt, flat washer, lock washer (8)
7. Steel spacer

6.1.3 Remove the Old Blower Wheel

BNDDUM01.T01 0000524614 A.3 A.4 10/10/22, 8:08 AM Released

1. Refer to Figure 37, page 116. 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: 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 38: Blower Wheel Attachment to Shaft, page 117 . 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.

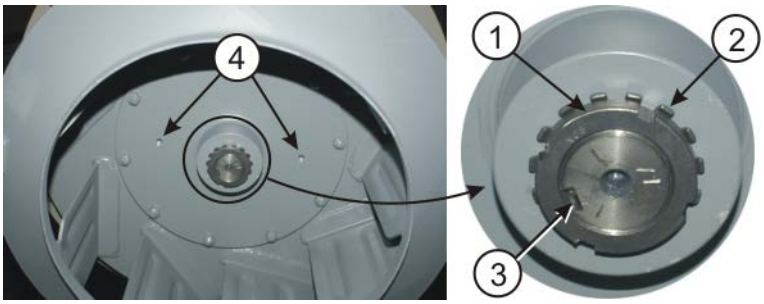
4. Refer to Figure 38, page 117. Two threaded holes on the blower wheel hub (item 4) will accept the 3/8" jack bolts. Insert both bolts until they stop against the top of the blower housing. With the bearing lock nut still attached, alternately tighten the jack bolts to push the wheel off of the shaft 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 38. Blower Wheel Attachment to Shaft

View of the Blower Wheel and the End of the Shaft



Legend

1. Bearing lock nut
2. Bearing lock washer
3. Shaft key
4. Threaded holes for jack bolts

6.1.4 Install the New Blower Wheel

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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 metalic 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 above) 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.

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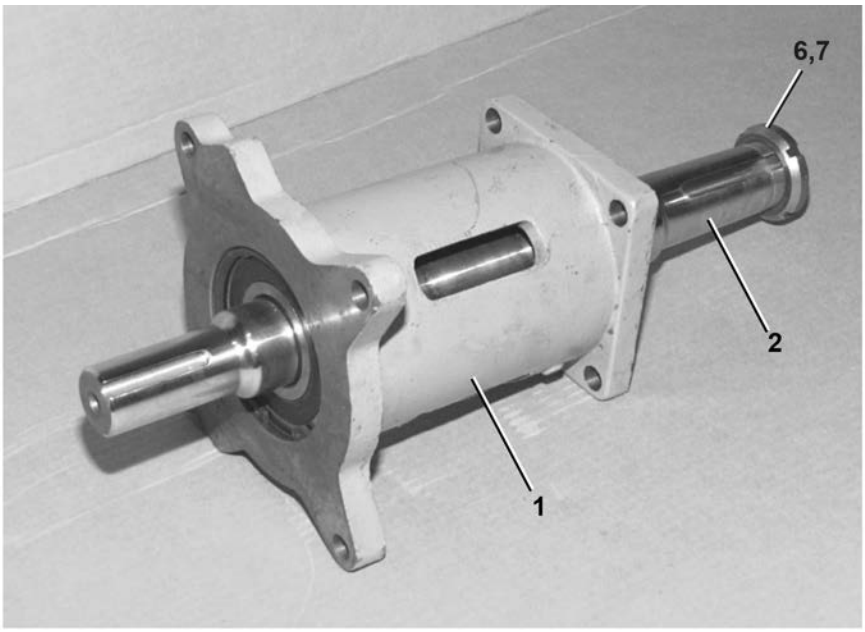
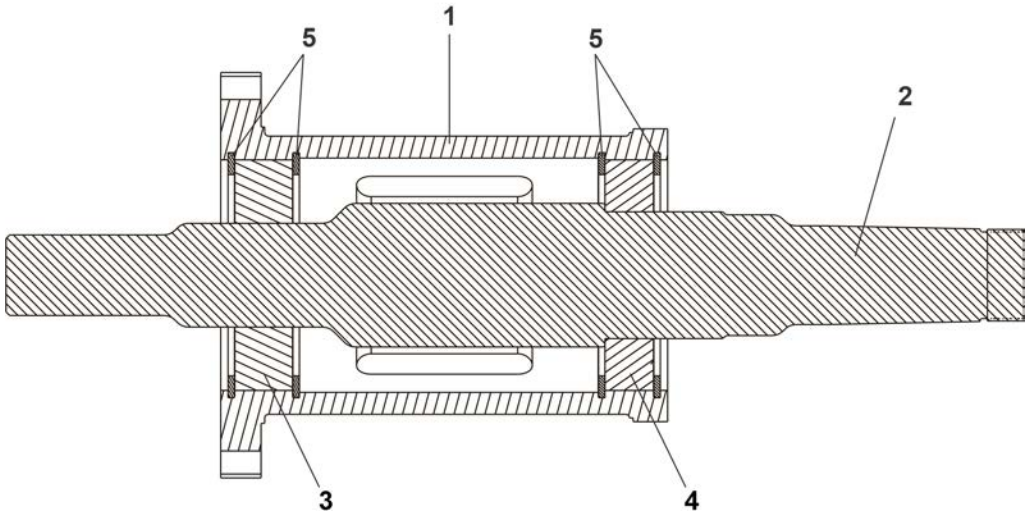
Blower Bearing

2 Sheets





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

2 Sheets

Table 37. 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	

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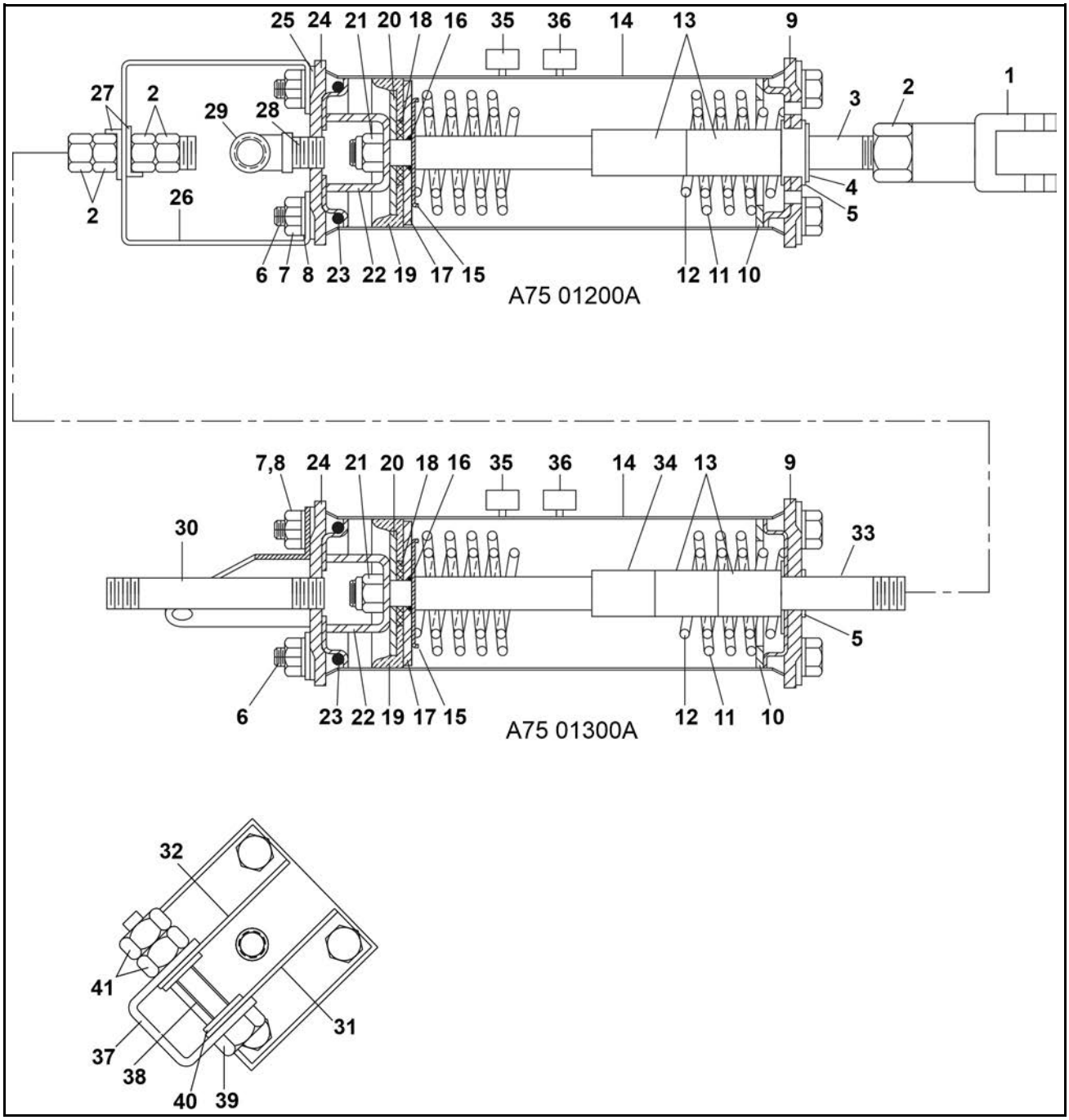
Blower Main Damper Air Cylinders

3 Sheets

5050, 6458, 6464, 7676, and 8282 Dryers

Figure 39. Cross Section



Blower Main Damper Air Cylinders

3 Sheets

5050, 6458, 6464, 7676, and 8282 Dryers

Table 38. Parts List—Blower Main Damper Air Cylinders

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	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	07 50331B	LOCKING WASHER AIRCYL SHAFT	
all	28	5N0ECL3G42	NPT NIPPLE 1/4XCLS TBE GALSTL	
all	29	5SL0EBEA	NPTELB 90DEG 1/4 BRASS 125#	

Blower Main Damper Air Cylinders

3 Sheets

5050, 6458, 6464, 7676, and 8282 Dryers

Table 38 Parts List—Blower Main Damper Air Cylinders (cont'd.)

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
all	30	5N0ECLSBE2	NPT NIP 1/4XCLS TBE BRASS 125#	
all	31	02 02547	BRKT=AIRCYL-LFT ZINC/CAD	
all	32	02 02550	BRKT=AIRCYL-RIGHT ZINC/CAD	
all	33	02 18650A	STEM-AIRCYL.UPLOCK PRESS	
all	34	27B240	SPCRROLL.5ID.813L.062T STLZNC	
all	35	20L601A	ID TAG NAT'L#1614 ALUM EMB "A"	
all	36	20L601E	ID TAG NAT'L#1614 ALUM EMB "E"	
all	37	02 02556	SUPPORT=AIRCYL 12GA ZINC PLT	
all	38	27B2750L0T	SPC RROLL.562ID.937L.048T ZNK	
all	39	15K206	HEXCAPSCR 9/16-12X2.5 ZC GR5	
all	40	15U311A	FLTWASHER9/16 ASME/B18.22.1TYP	
all	41	15G235F	HXFNJAMNUT 9/16-12UNC2B ZINC G	

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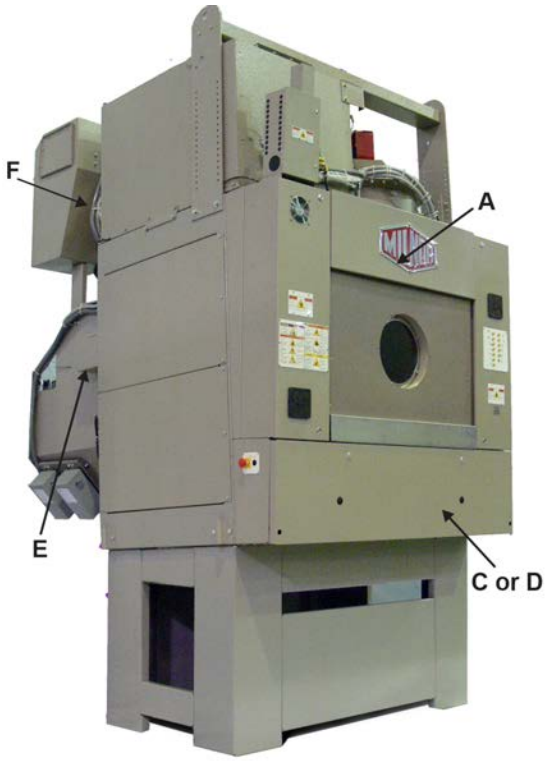
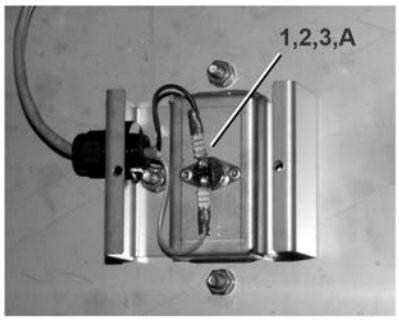
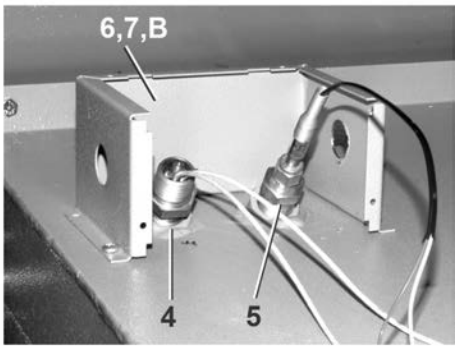
Temperature Sensors

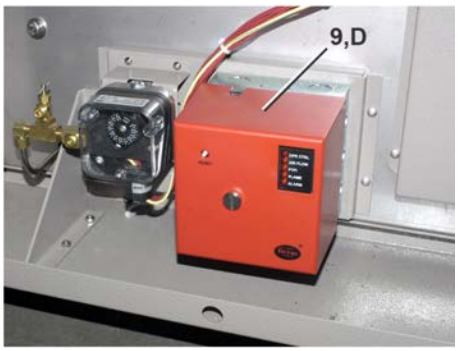
3 Sheets

5050TG1L/R,TS1L/R









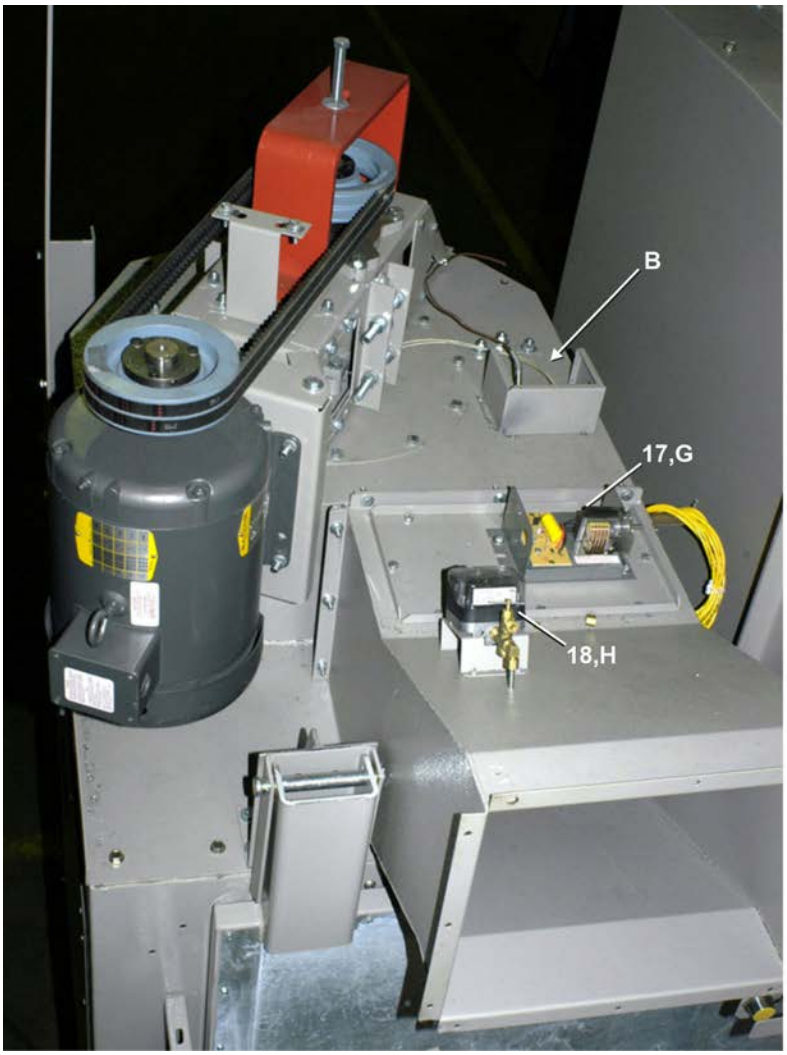
Legend

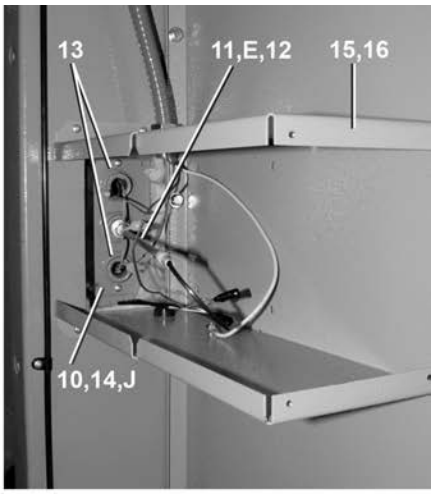
A . . . Basket temperature switch
B . . . Outlet temperature switch and temperature probe
C . . . Burner Controller (5040TG2L, TG2R European gas trains shown)
D . . . Fire eye (5040TG2L,TG2R only)

Temperature Sensors

3 Sheets

5050TG1L/R,TS1L/R





Legend

E . . . Inlet temperature probe
F . . . Burner thermostat
G . . . Spark generator
H . . . Back pressure switch
J . . . Insulation required in cavity

Temperature Sensors

3 Sheets

5050TG1L/R,TS1L/R

Table 39. Parts List—Temperature Sensors

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**
			Components	
all	1	30RA225T	THERMOSTAT CLOSES AT 225-DEG F	
all	2	07 71531	6458 HIGH TEMP SWITCH HOLDER	
all	3	07 71533	6458 HIGH TEMP SWITCH COVER	
all	4	30R0225P	THERMOSW.FENWAL CLOSE @ 225F STAINLESS STEEL	5050TG1L/R
all	4	30R0240P	THERMOSW.FENWAL CLOSE @ 240F STAINLESS STEEL	5050TS1L/R
all	5	30R0055PP	* DRYER OUTLET T/C PROBE ASSY	
all	6	03 CL4X3Y	COVER:DRYER TEMP PROBE	
all	7	03 E4X3Y	ENCL:DRYER TEMP PROBE	
all	8	09X151	BURNER CTL-AUSTR.110/50 10SEC	5050TG1L/R CE (EUROPE)
all	9	09X150A3	FLAMESAFE CTL ASSY #MC120	5050TG1L/R
all	10	W3 BF3X5B	50"DRYER INLET TEMP PROBE HOLDER	
all	11	30R0050PP	*100# DRYER T/C PROBE ASSY	
all	12	51A026C	THRMCOUPCON BRAS1/4TUBEX1/2MPT	
all	13	30R0550P	THERMOSW.FENWAL OPEN @ 550F	
all	14	98P030	INSUL.FIBRGLS.24X48X1+1/2E=1SH	
all	15	07 44161	5040 TEMP PROBE BOX	
all	16	07 44162	5040 TEMP PROBE BOX COVER	
all	17A	09X175	IGNITION TRANSFRMER Q624A1014-U "UNITS"	US
all	17B	09X175A	IGNITION TRANSFRMER CE ECLIPSE 10012234	CE (EUROPE)
all	17BB	09X175AB	MOUNTING KIT FOR 09X175A - ECLIPSE	CE (EUROPE)
all	18	A77BP001	6458 BACK PRESSURE SWIT ASSY	
all	19	30RA175T	THERMOSTAT OPENS AT 175F	

7 Gas Assemblies

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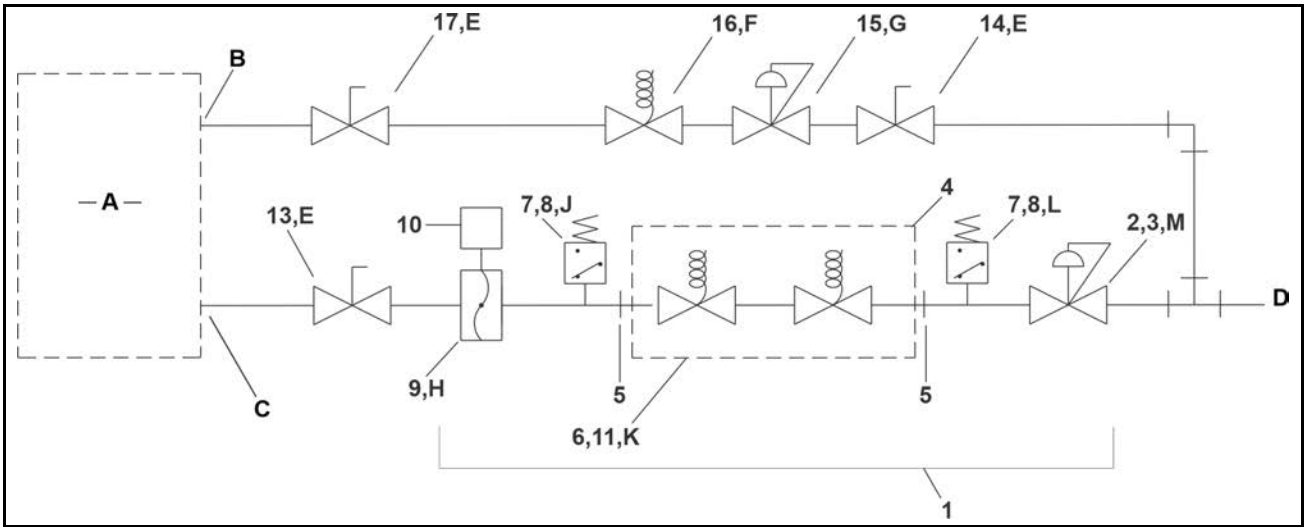
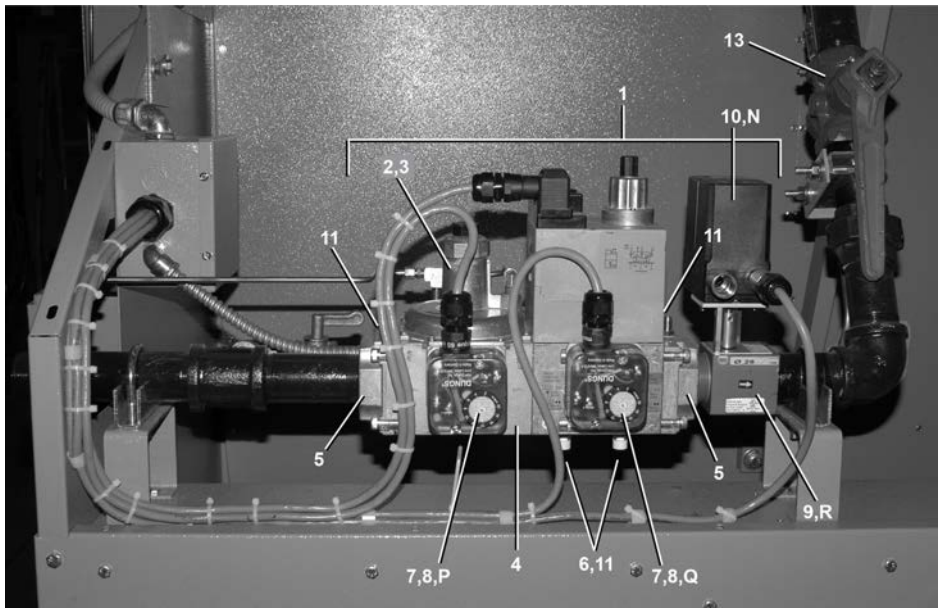
Natural Gas Schematic, CSA

4 Sheets

5040TG2L,TG2R; 5050TG1L,TG1R; 6458TG1L,TG1R; 6464TG1L,TG1R; 7272TG1L,TG1R

Figure 40. Main Gas Inlet





Legend

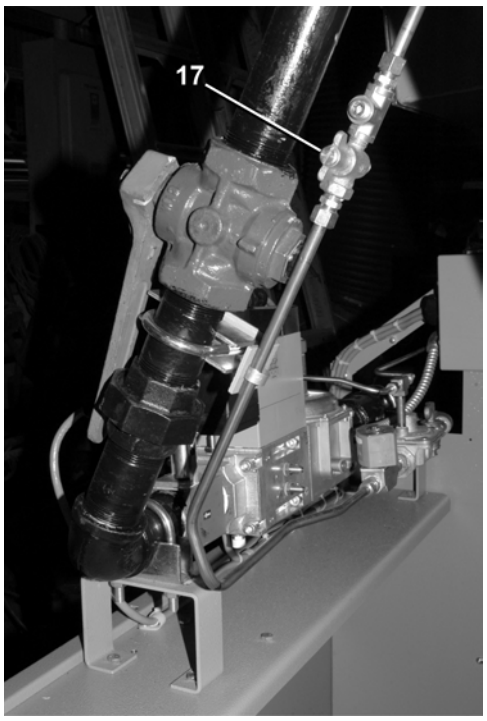
- **A . . .** Eclipse® burner unit
- **B . . .** Pilot input
- **C . . .** Burner input
- **D . . .** Gas main inlet
- **E . . .** Manual valve
- **F . . .** 2 way valve
- **G . . .** Gas regulator
- **H . . .** Modulating valve on/off
- **J . . .** High pressure switch
- **K . . .** Dual shut-off valve
- **L . . .** Low pressure switch
- **M . . .** Gas pressure regulator
- **N . . .** Actuator
- **P . . .** Low gas pressure switch
- **Q . . .** High gas pressure switch
- **R . . .** Butterfly valve

Natural Gas Schematic, CSA

4 Sheets

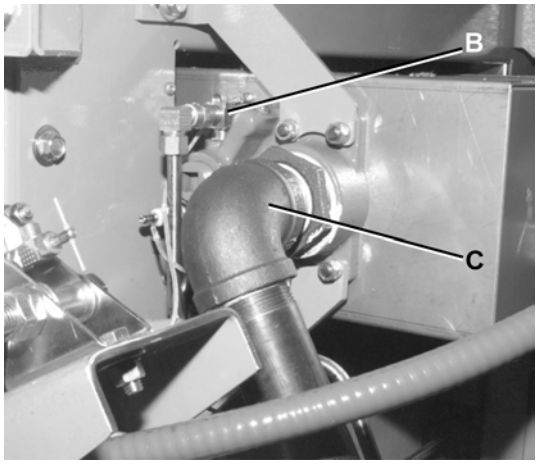
5040TG2L,TG2R; 5050TG1L,TG1R; 6458TG1L,TG1R; 6464TG1L,TG1R; 7272TG1L,TG1R

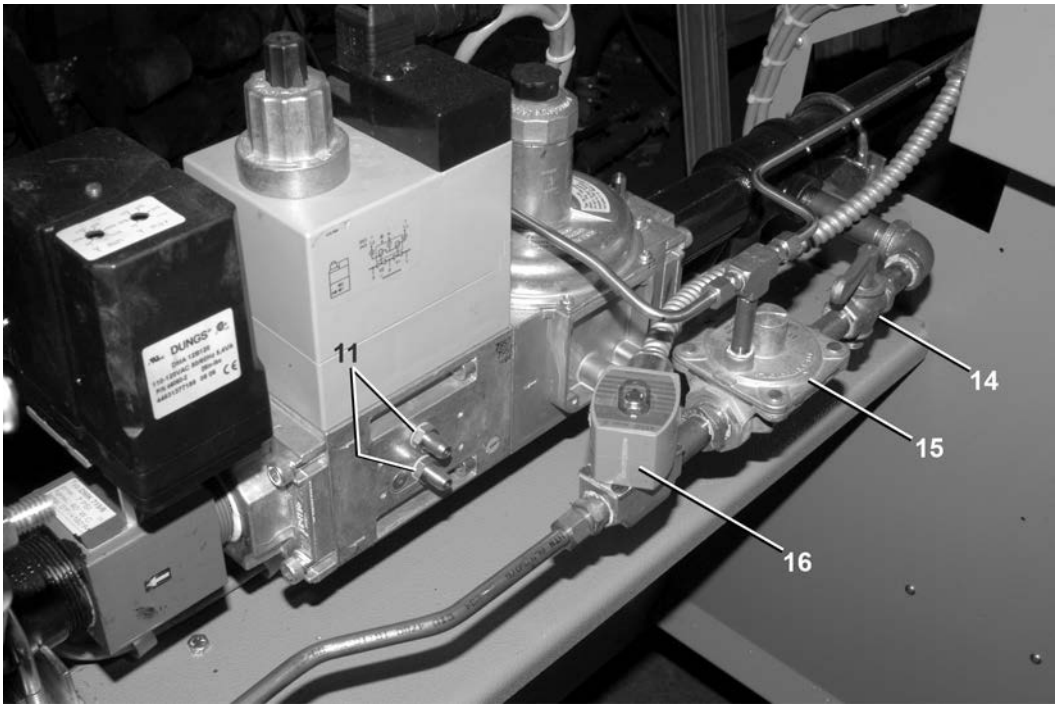
Figure 41. Pilot Line



Legend

B . . . Pilot input
C . . . Burner input





Natural Gas Schematic, CSA

4 Sheets

5040TG2L,TG2R; 5050TG1L,TG1R; 6458TG1L,TG1R; 6464TG1L,TG1R; 7272TG1L,TG1R

Table 40. Parts List—Natural Gas Schematic, CSA

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	A74VG052	5040TG1L AH NAT. 2V-NOVENT=CSA	5040TG2R,5050TG1R
	B	A74VG052A	5040TG1R AH NAT. 2V-NOVENT=CSA	5040TG2L,5050TG1L
	C	A77VG052	6458/64TG1L AH NAT. 2V-NOVENT=CSA	6458TG1L,6464TG1L
	D	A77VG052A	6458/64TG1R AH NAT. 2V-NOVENT=CSA	6458TG1R,6464TG1R
	E	A79VG052	7272TG1L AH NAT. 2V-NOVENT=CSA	7272TG1L
	F	A79VG052A	7272TG1R AH NAT. 2V-NOVENT=CSA	7272TG1R
			Components	
A	1	A74VG009	1.0" VALTRAIN 1MILBTU LT TO RT UL795/CSA	CONTAINS ITEMS 2–11
B	1	A74VG009A	1.0" VALTRAIN 1MILBTU RT TO LT UL795/CSA	CONTAINS ITEMS 2–11
C	1	A77VG020	1.5"VALTRAIN 2MILBTU LT TO RT UL795/CSA	CONTAINS ITEMS 2–11
D	1	A77VG020A	1.5"VALTRAIN 2MILBTU RT TO LT UL795/CSA	CONTAINS ITEMS 2–11
E	1	A79VG020	2.0" VALTRAIN 3MILBTU LF TO RT UL795/CSA	CONTAINS ITEMS 2–11
F	1	A79VG020A	2.0" VALTRAIN 3MILBTU RT TO LF UL795/CSA	CONTAINS ITEMS 2–11
ABCD	2	96SD010	FRI712 GAS PRESS/REG #D230475	
EF	2	96SD032	2"NPT FRS 720/6 GAS REGULATOR	
ABCD	3	96SD011	FRI MOUNTING KIT #D219968	
AB	4	96SD020	DMV-DLE 702/6 DUAL VALVE	
CD	4	96SD012	DMV-DLE 703/602DUAL SHUTOFF VALVE	
EF	4	96SD028	DMV-DLE 525/11 DUAL SHUTOFFVAL	
AB	5	96SD003	1"NPT FLANGE ONLY #D222369	
CD	5	96SD013	1-1/2" FLNG ONLY #D222003	
EF	5	96SD029	2"FLANGE ONLY #D232407	
all	6	96SD014	VISUALVAL POSINDIC #217-665	
all	7	96SD015	GAO-A2-4-5 HI&LOW GASPRESSWITCH	
ABCD	8	96SD016	MTGKIT FOR HI GAS PRESS SWITCH	
AB	9	96SD005A	DMK 710-/6 1"NPT BUTTERFLY 21M	
CD	9	96SD017	DMK715/6 1-1/2"NPT BUTRFLY 28M	
EF	9	96SD030	DMK 720/6 2"NPT BUTTERFLY VAL	
all	10	96SD018	DMA 12C120 ACTUATR 12 SEC TIME DMA	
AB	11	96SD008	G 1/8"TEST NIPPLE #D219008	
CD	11	96SD019	G 1/8" TEST NIPPLES(PRESSTEST)	
EF	11	96SD008	G 1/8" TEST NIPPLES KDI # 219008	
AB	13	96G100C	1"GAS STOP VALVE	

Natural Gas Schematic, CSA

4 Sheets

5040TG2L,TG2R; 5050TG1L,TG1R; 6458TG1L,TG1R; 6464TG1L,TG1R; 7272TG1L,TG1R

Table 40 Parts List—Natural Gas Schematic, CSA (cont'd.)

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**
CD	13	96G150C	1.5"GAS STOP VAL	
EF	13	96G200	2" GAS STOP VAL	
all	14	96G030	3/8"GAS BALL VLV/ T- HANDLE	
all	15	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C-MAXITRL	
ABC	16	96TCC2BA37	3/8" N/C 2WAY 120V50/60C VALVE	
ABC	17	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL # 55-302-01	

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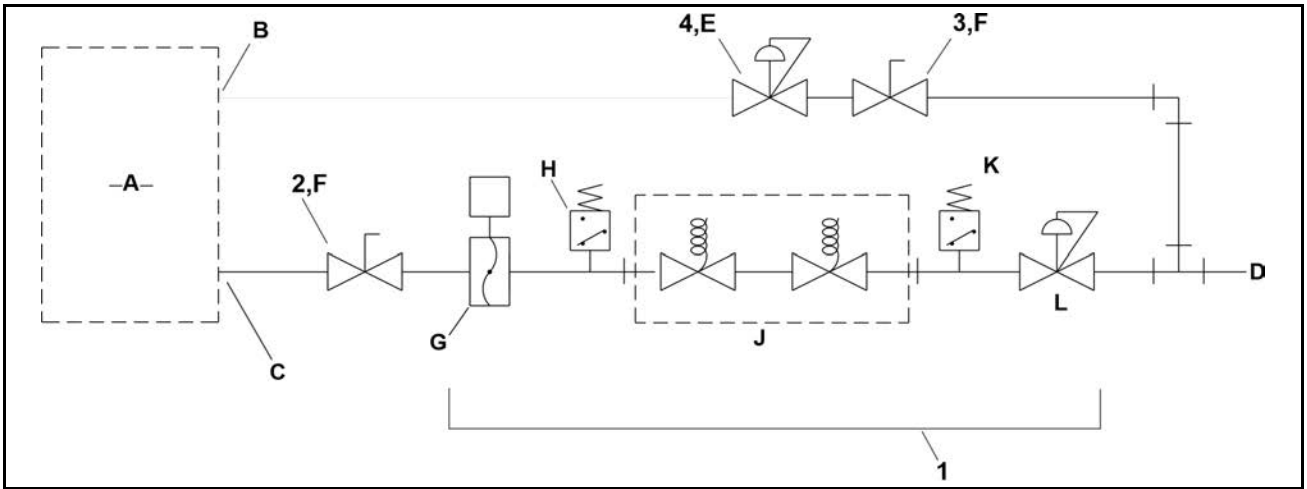
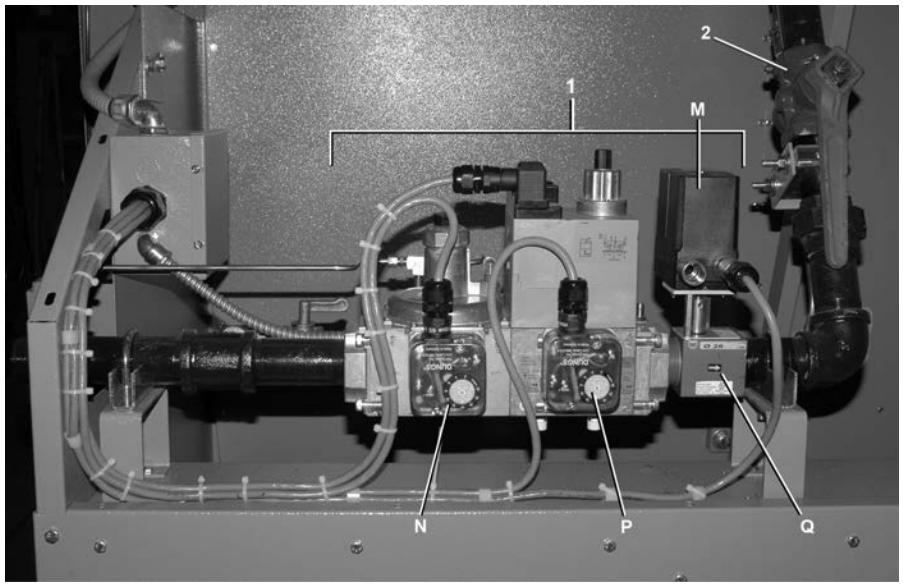
Natural Gas Schematic, Europe

3 Sheets

5040TG2L/R; 5050TG1L/R

Figure 42. Main Gas Inlet





Legend

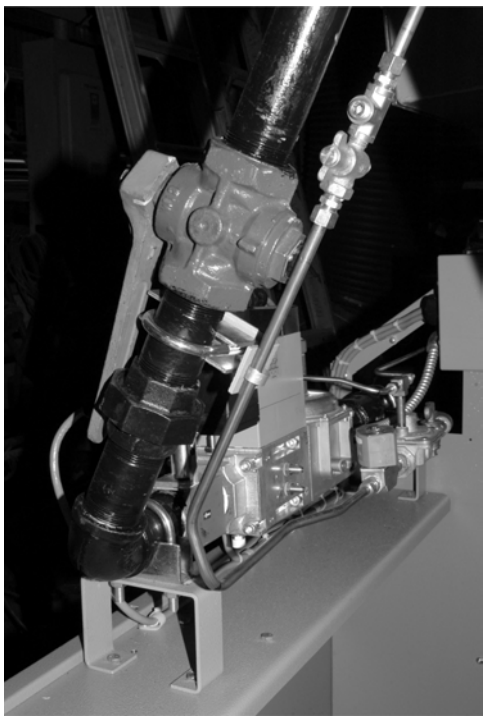
A . . . Eclipse® burner unit
B . . . Pilot input
C . . . Burner input
D . . . Gas main inlet
E . . . Gas regulator
F . . . Manual valve
G . . . Modulating valve on/off
H . . . High pressure switch
J . . . Dual shut-off valve
K . . . Low pressure switch
L . . . Gas pressure regulator
M . . . Actuator
N . . . Low gas pressure switch
P . . . High gas pressure switch
Q . . . Butterfly valve

Natural Gas Schematic, Europe

3 Sheets

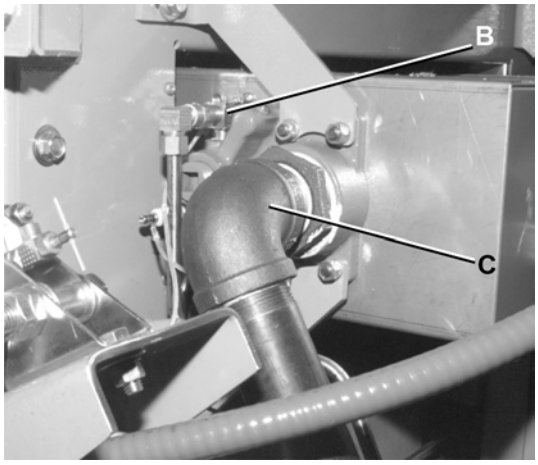
5040TG2L/R; 5050TG1L/R

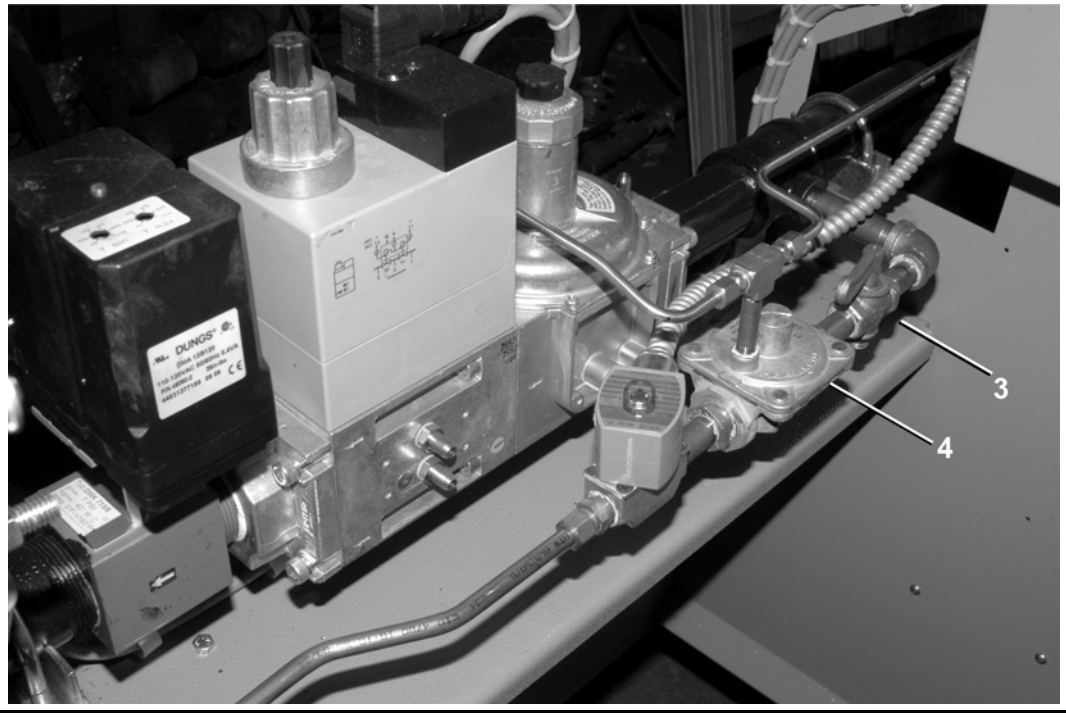
Figure 43. Pilot Line



Legend

B . . . Pilot input
C . . . Burner input





Natural Gas Schematic, Europe

3 Sheets

5040TG2L/R; 5050TG1L/R

Table 41. Parts List—Natural Gas Schematic, Europe

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	A74VG054	5040 NAT 2V-NOVENT=EU LF	5040TG2L,5050TG1L
	B	A74VG054A	5040 NAT 2V-NOVENT=EU RT	5040TG2R,5050TG1R
Components				
A	1	A74VG010	1.0" VALTRAIN 1MILBTU 10S=EU LT TO RT EN746-2	
B	1	A74VG010A	1.0" VALTRAIN 1MILBTU 10S=EU RT TO LT EN746-2	
all	2	96G100D	1.0" GAS STOP VAL - NON-LUBE - CE	
all	3	96G030A	RP3/8 GAS STOP VAL - NON-LUBE - CE	
all	4	96J507A	1/2"INLET GASREG LEVER ACTING 7"W.C-MAXITRL CE	

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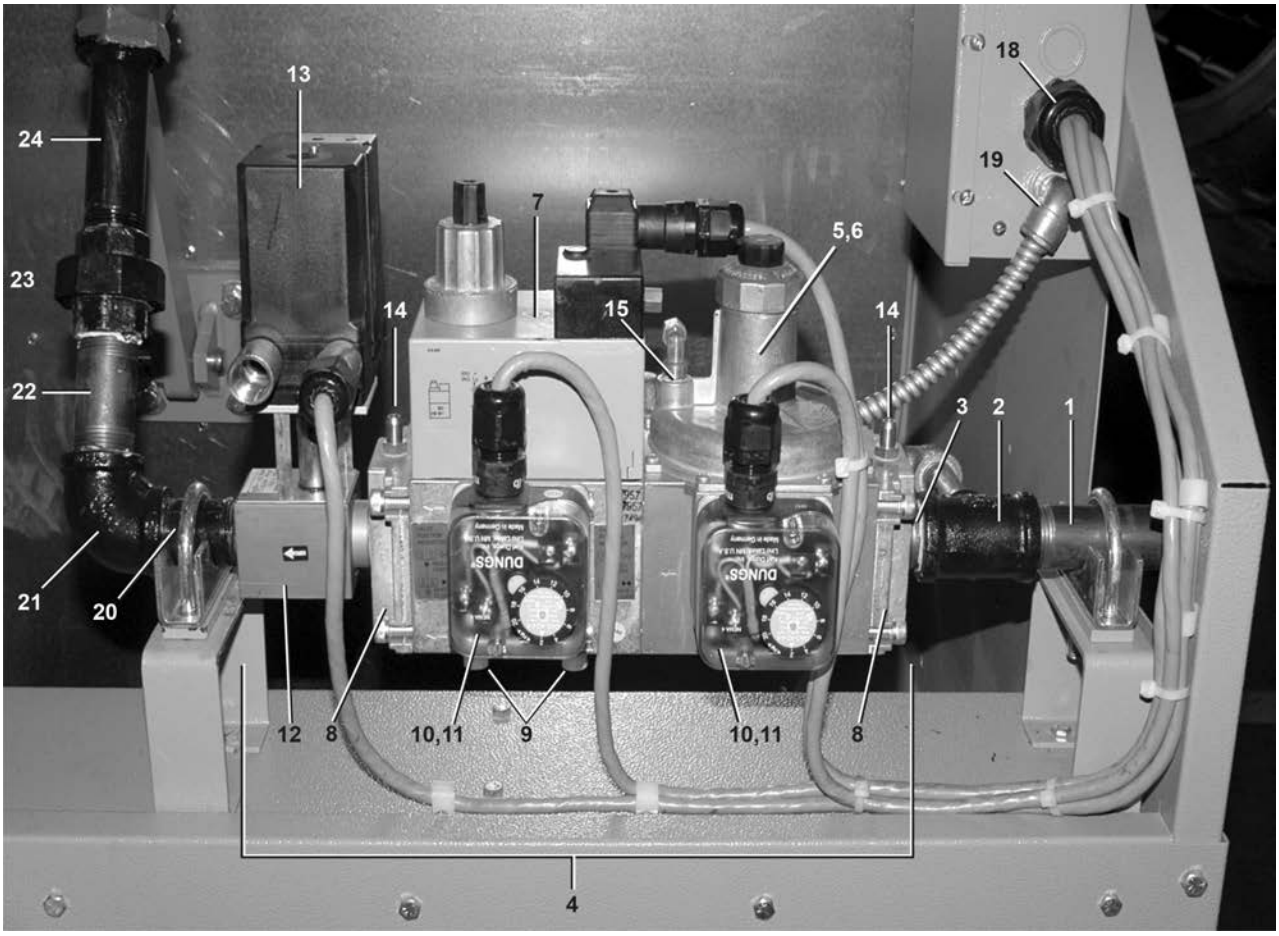
Gas Piping, CSA and Europe

6 Sheets

5040TG2L/R, 5050TG1L/R

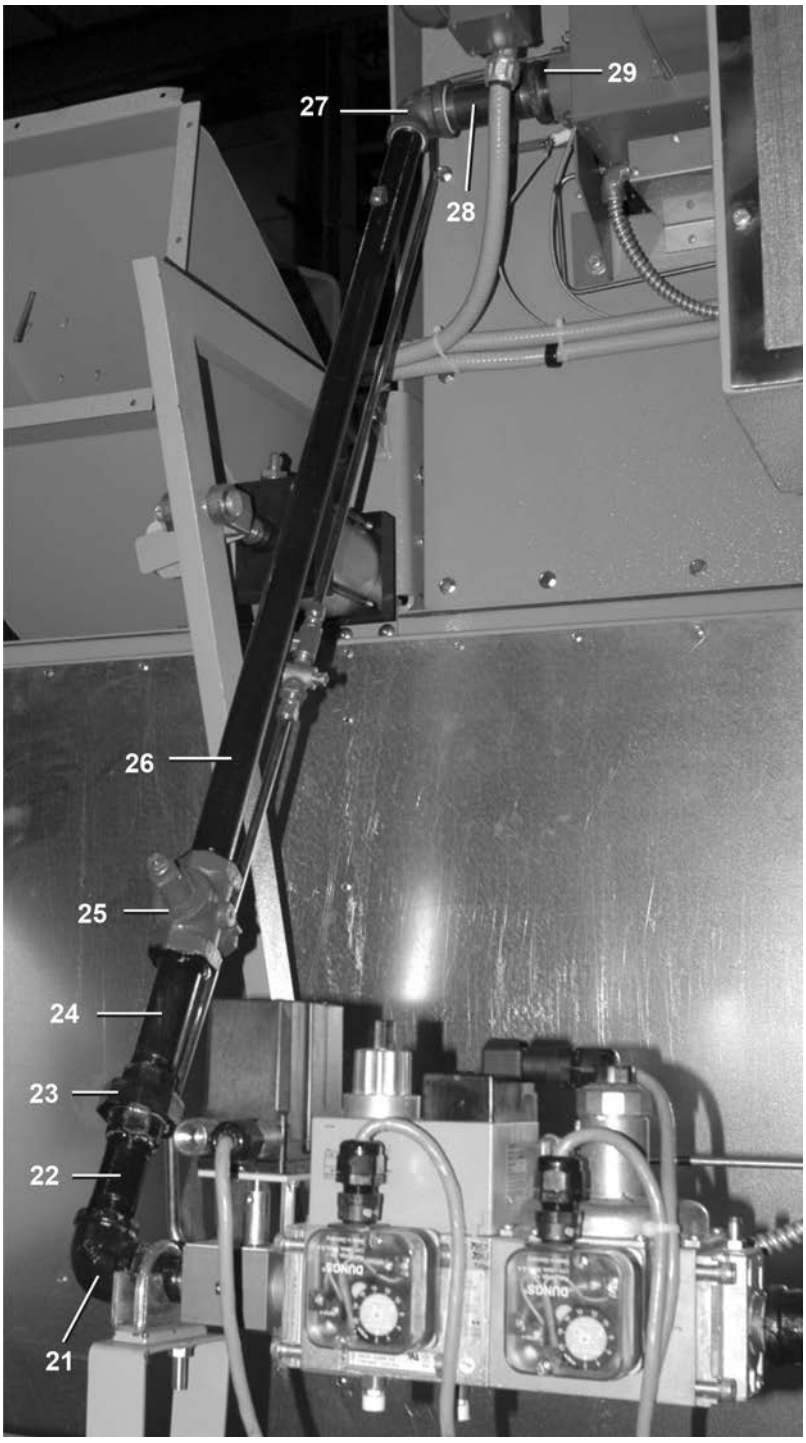
5040TG2R Shown



Gas Piping, CSA and Europe

6 Sheets

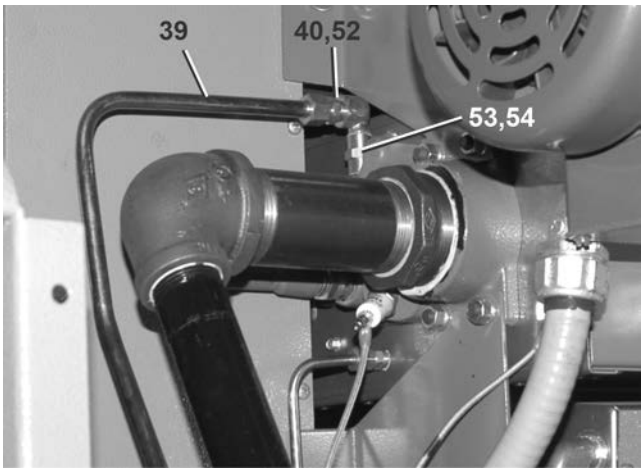
5040TG2L/R, 5050TG1L/R

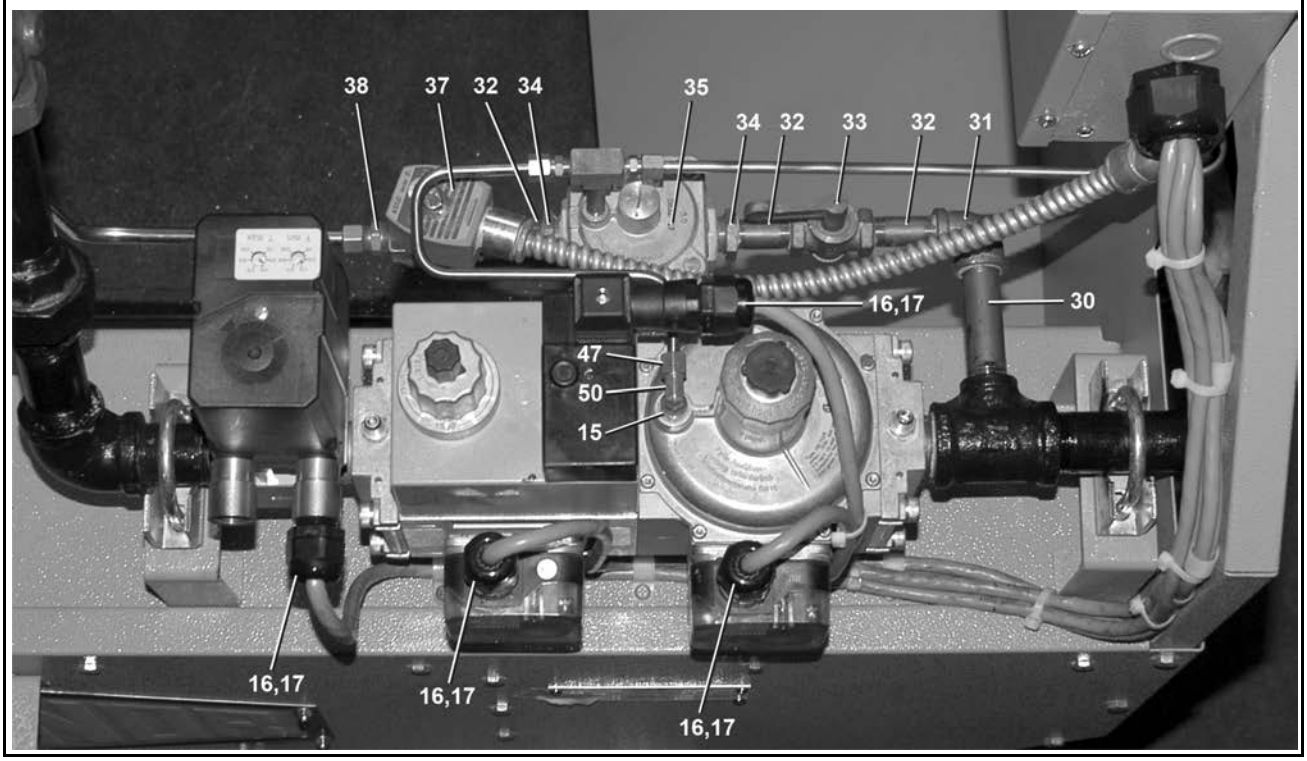


Gas Piping, CSA and Europe

6 Sheets

5040TG2L/R, 5050TG1L/R

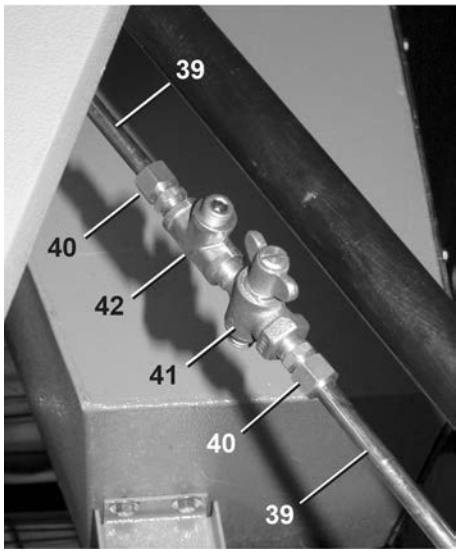


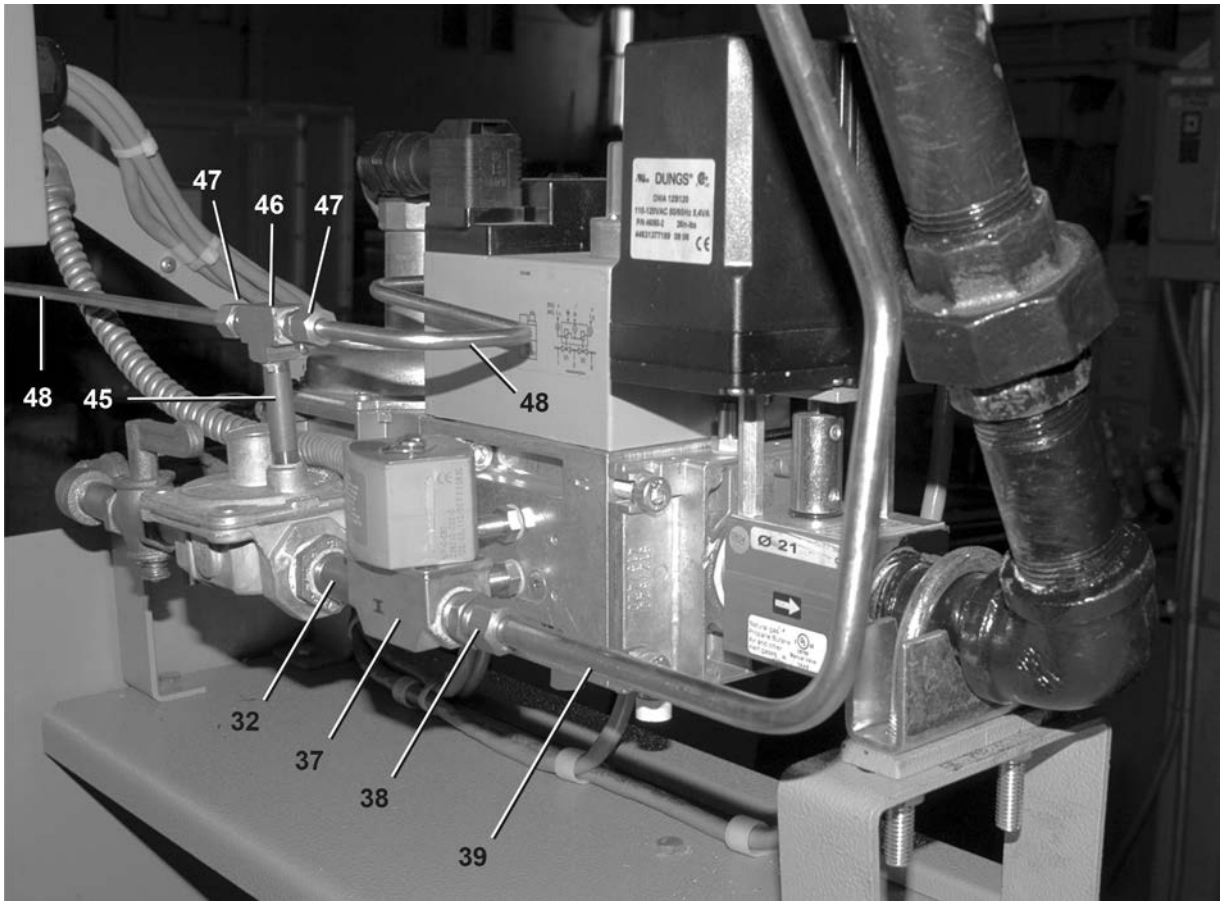


Gas Piping, CSA and Europe

6 Sheets

5040TG2L/R, 5050TG1L/R





Gas Piping, CSA and Europe

6 Sheets

5040TG2L/R, 5050TG1L/R

Table 42. Parts List—Gas Piping, CSA and Europe

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	A74VG015	5040 NAT. GAS TRAIN VERT SECTION=CSA	5040TG2L/R, 5050TG1L/R
	B	A74VG011	5040 NAT. GAS TRAIN ENTRY SECTION	5040TG2L/R, 5050TG1L/R
	C	A74VG014	5040TG1R AH NAT. 2V-NOVENT=CSA	5040TG2R, 5050TG1R
	D	A74VG014A	5040TG1L AH NAT. 2V-NOVENT=CSA	5040TG2L, 5050TG1L
	E	A74VG013	5040 NAT. PILOT GAS PIPE	5040TG2L/R, 5050TG1L/R
			Components	
all	1	5N1A07AF42	NPT NIPPLE 1X7 TBE BLKSTL S	
all	2	5S1AMFA0G	NPT TEE 1X1X3/8" BLKMAL 150#	
all	3	5N1ACLSF42	NPT NIP 1X CLS TBE BLKSTL SK40	
all	4	A74VG009	1.0" VALTRAIN 1MILBTU LT TO RT UL795/CSA	
all	4	A74VG009A	1.0" VALTRAIN 1MILBTU RT TO LT UL795/CSA	
all	5	96SD010	FRI712 GAS PRESS/REG #D230475	
all	6	96SD011	FRI MOUNTING KIT #D219968	
all	7	96SD020	DMV-DLE 702/6 DUAL VALVE	
all	8	96SD003	1"NPT FLANGE ONLY #D222369	
all	9	96SD014	VISUALVAL POSINDIC #217-665	
all	10	96SD015	GAO-A2-4-5 HI&LO GASPRESSWITCH	
all	11	96SD016	MTGKIT FOR HI GAS PRESS SWITCH	
all	12	96SD005A	DMK 710-/6 1"NPT BUTTERFLY 21M	
all	13	96SD018	DMA 12C120 ACTUATR 12 SEC TIME DMA	
all	14	96SD008	G 1/8"TEST NIPPLE #D219008	
all	15	51T311	FLAMEARREST VNTSCREEN.375BRASS	
all	16	12M043F050	LIQTITE 1/2" STR. FITTING	
all	17	09V290A	CABLE #18/4 SJTO 7/16"OD 250'	
all	18	12M043F100	LIQTITE 1" STR. FITTING	
all	19	12M036L	1/2" 90-DEG SHORT ELLS	
all	20	5N1A02KG41	NPT NIP 1X2.5 TOE GALSTL SK40	
all	21	5SL1AMFA	NPT ELBOW 90DEG 1" BLKMAL 150#	
all	22	5N1A03KF42	NPT NIP 1X3.5 TBE BLK STL SK40	
all	23	5SU1AMF	NPT UNION 1" BLKMAL 150#	
all	24	5N1A05AF42	NPT NIPPLE 1X5 TBE BLKSTL S	
all	25	96G100C	1"GAS STOP VALVE WRENCH HANDLE	
all	26	5N1A38AF82	NPT NIP 1X38 TBE BLKSTL SK80	

Gas Piping, CSA and Europe

6 Sheets

5040TG2L/R, 5050TG1L/R

Table 42 Parts List—Gas Piping, CSA and Europe (cont'd.)

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
all	27	5SL1KMFA1A	NPT ELB 90DEG 1.5X1 BLKMAL150#	
all	28	5N1K05AF42	NPT NIP 1.5X5 TBE BLKSTL SK40	
all	29	5SB2A1KCEO	NPTHEXBUSH 2X1.5 BLKCI 125#	
all	30	5N0K03KB42	NPT NIP 1/2X3.5 TBE BRASS STD	
all	31	5SL0KBEA0G	NPTELB 90DEG 1/2X3/8 BRASS 125	
all	32	5N0G02ABE2	NPT NIP 3/8X2 TBE BRASS STD	
all	33	96G030	3/8"GAS BALL VLV/ T- HANDLE	
all	34	5SR0K0GBE	NPT RED 1/2X3/8 BRASS 125#	
all	35	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C.	
all	37	96TCC2BA37	3/8" N/C 2WAY 120V50/60C VALVE	
all	38	53A026	BODYMALECON3/8X3/8 #68C-6-6B	
all	39	87Z010	TUBE 3/8"ODX.035" SS304 *20RM	
all	40	53A023	MALECON3/8X.25COMP ANCHR#68-64	
all	41	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL # 55-302-01	
all	42	51V015	TEE 1/4 FGDBRASS 101T7-444	
all	45	5N0C03ABE2	NPT NIP 1/8X3 TBE BRASS STD	
all	46	51V010A	TEE 1/8"BRSEXTR BLOCTYP#2203P2	
all	47	53A005B	BODYMALCON1/4X1/8COMP #B68A-4A	
all	48	87Z00EX035	TUBE=1/4"ODX.035WL 316LSS*20RM	
all	50	53A031XB	BODY-EL90MALE.25X25 #269C-4-4B	
all	52	5SL0EBEC	NPTELB 90DEG STRT 1/4 BRASS125	
all	53	5SCC0EBE	NPT COUP 1/4 BRASS 150#PSI W/HEX	
all	54	5N0GCLSBE2	NPT NIP 3/8XCLS TBE BRASS STD	

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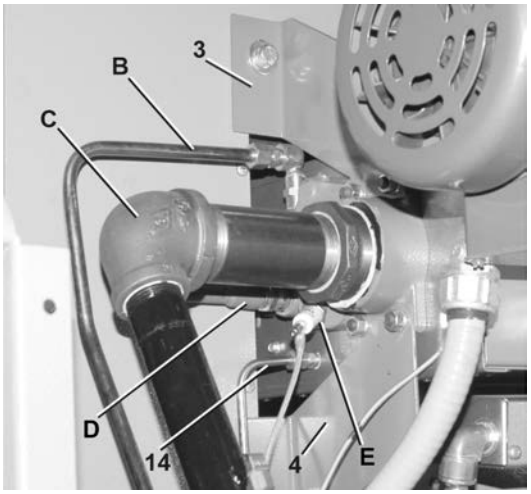
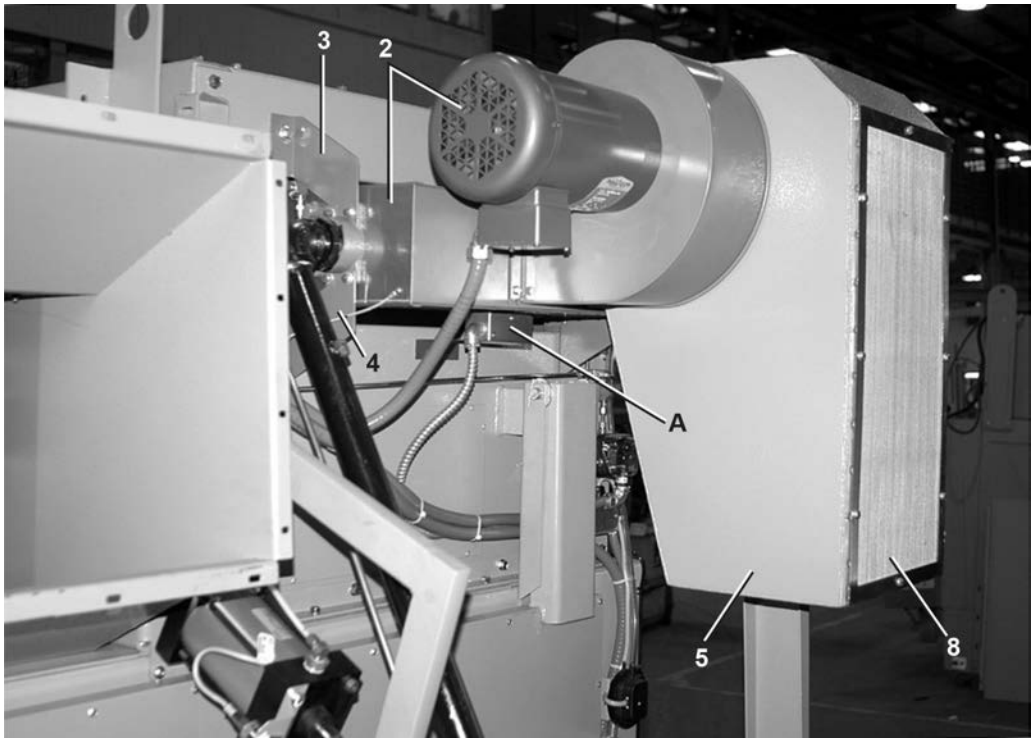
Firebox, Burner, and Combustion Air

3 Sheets

5050TG1R, TG1L



6458 Dryer Shown



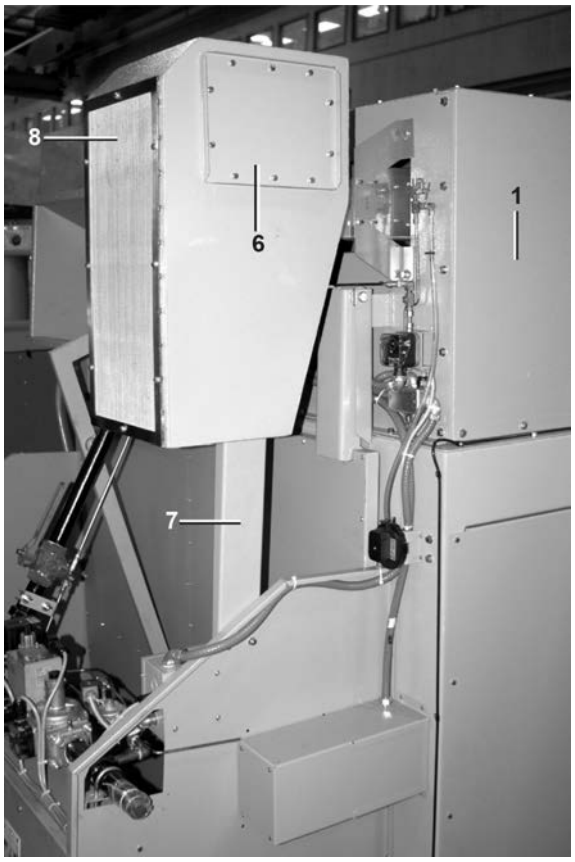
Legend

A . . . Firebox thermostat
B . . . Pilot input
C . . . Burner input
D . . . Spark plug or igniter
E . . . Flame rod

Firebox, Burner, and Combustion Air

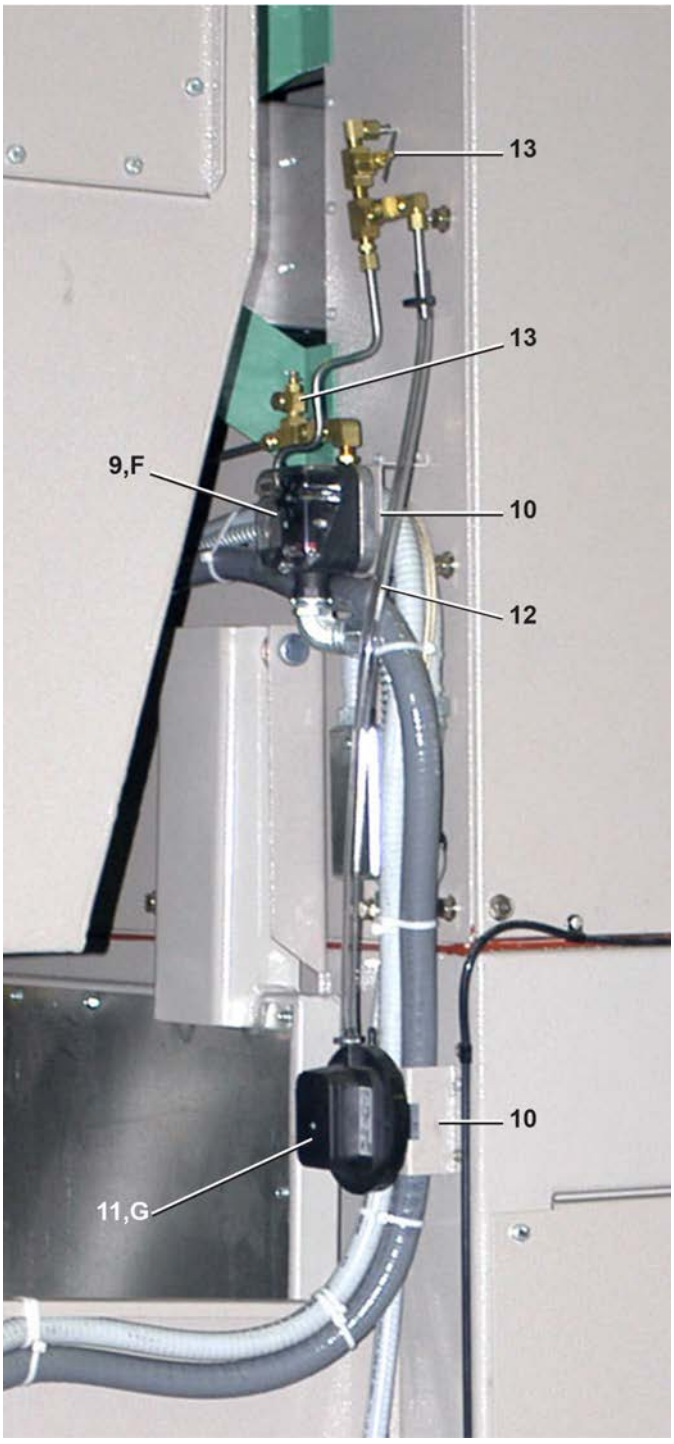
3 Sheets

5050TG1R, TG1L



Legend

F . . . Combustion pressure switch
G . . . Firebox back-pressure switch



Firebox, Burner, and Combustion Air

3 Sheets

5050TG1R, TG1L

Table 43. Parts List—Firebox, Burner, and Combustion Air

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	A74FB005	5040 BURNER ASSEMBLY	5050TG1L/R
	B	A74CP001	5040 COMB. PRES. SW. ASSY	5050TG1L/R
			Components	
all	1	A74FB004	5040 FIREBOX ASSEMBLY	BLOWER LEFT
all	1	A74FB004A	5040 FIREBOX ASSY RIGHT	BLOWER RIGHT
all	2	25AB241	BURNER/BLOWERWHEEL MODEL 80AH	
all	3	07 71067	6458 BURNER SUPP BKT TOP LF	
all	4	07 71067A	6458 BURNER SUPP BKT TOP LF	
all	5	A74FB006	5040 FIREBOX FILTER BOX L	BLOWER LEFT
all	5	A74FB006A	5040 FIREBOX FILTER BOX R	BLOWER RIGHT
all	6	07 71014	COVER=CLEAN OUT 6458COMB AIR	
all	7	07 71015	64" DRYER LF COMB AIR MOUNT	BLOWER LEFT
all	7	07 44164	5040 COMB AIR MNT RIGHT	BLOWER RIGHT
all	8	W7 71035	WLMT=6458 COMB AIR SCREEN	
all	9	09N19106B	GAS PRESS SW RANGE .2-2.4"WC	U.S.
all	9	09N19106C	GAS PRESS SW RANGE .2-2.4"WC=CE	CE (EUROPE)
all	10	03 BL3X4	PRESSURE SWITCH BRACKET 6458	
all	11	09N19111	AIR PRESSW RANGE .08-.4	U.S.
all	11	09N19111A	AIR PRESSW RANGE .08-.4 CE	CE (EUROPE)
all	12	60E005D	TUBING 1/4"IDX7/16"OD EXCELLON	
all	13	96H018	ANGLE NEEDLE VLV 1/4"T X 1/8MP,PARKER#NV104C-5-2 W/PIN HANDLE	
all	14	87Z00EX035	TUBE=1/4"ODX.035WL 316LSS*20RM	

8 Steam Assemblies

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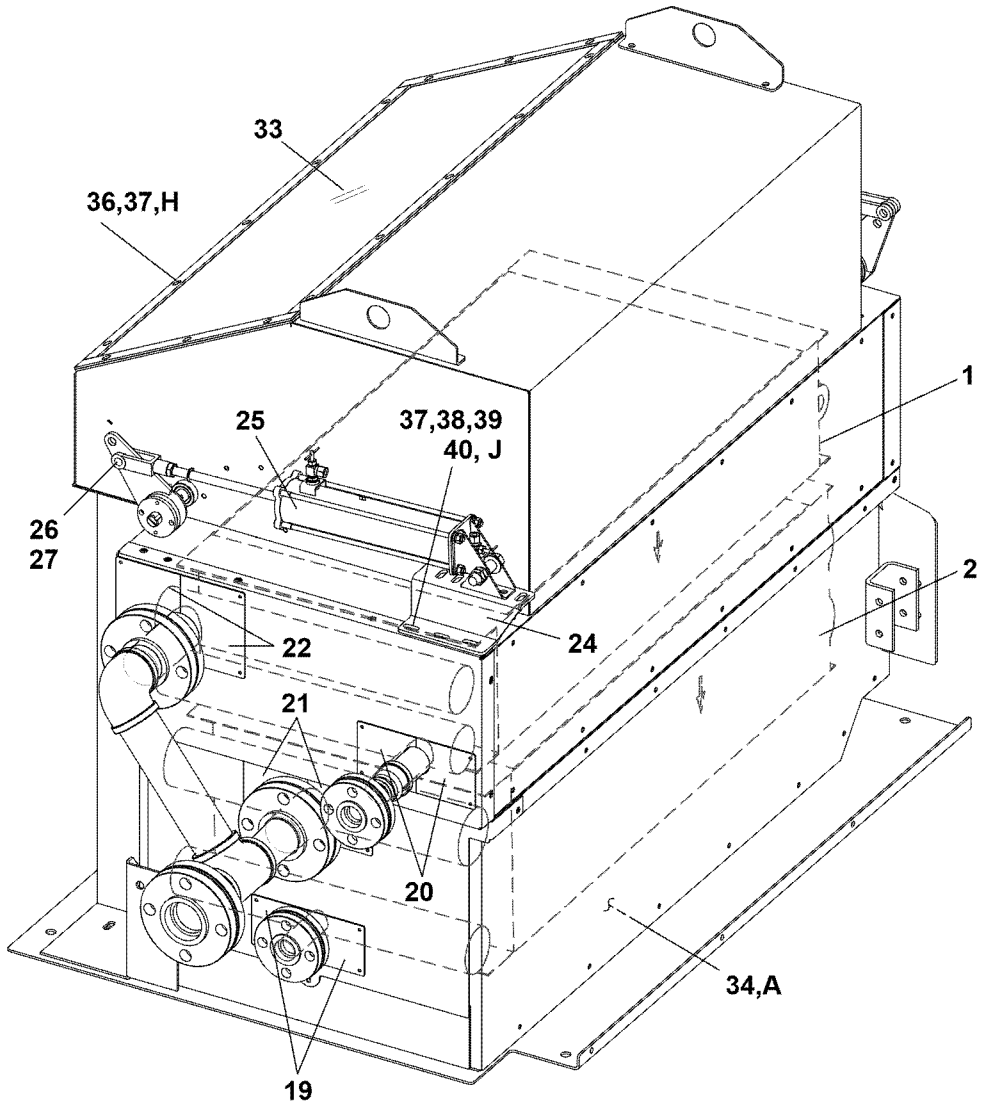
Steam Box & Coil with Booster

4 Sheets

5050TS1L, 5050TS1R

Figure 44. Rear View of Steam Box with Booster



Legend

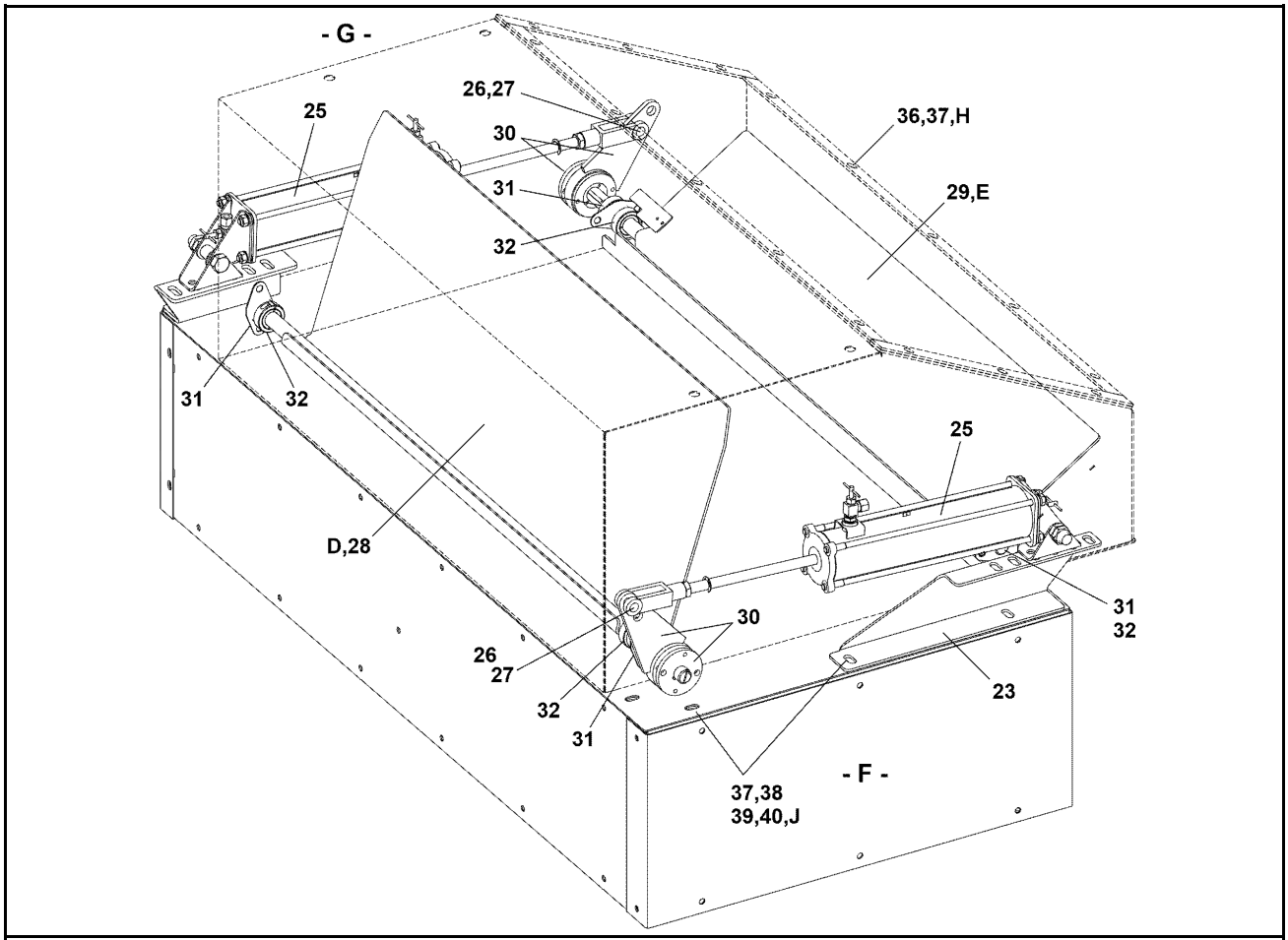
A . . . Within
B . . . 25 instances
C . . . 60 instances

Steam Box & Coil with Booster

4 Sheets

5050TS1L, 5050TS1R

Figure 45. Steam Box Inlet Dampers



Legend

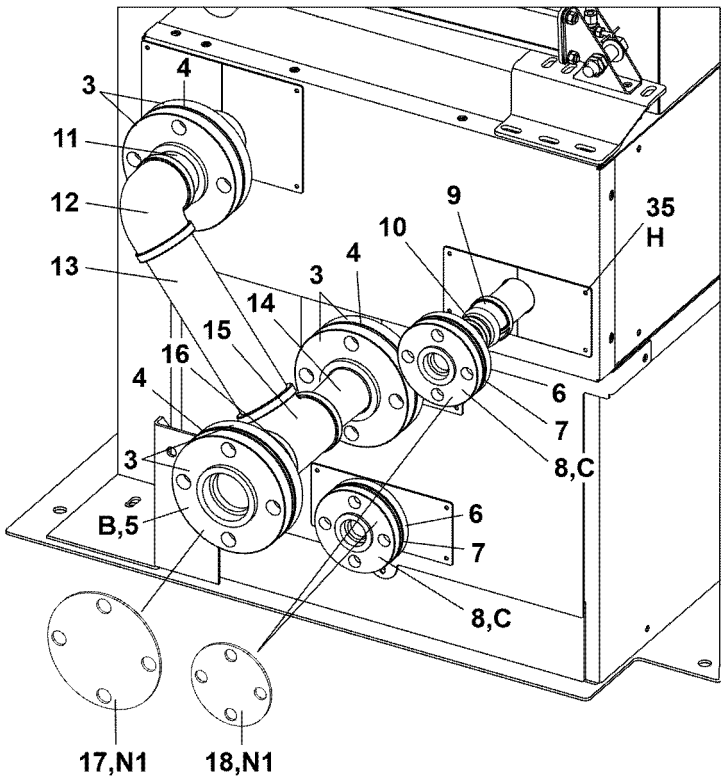
D . . . Steam box damper
E . . . Cooldown damper
F . . . Front
G . . . Rear
H . . . 25 instances
J . . . 60 instances

Steam Box & Coil with Booster

4 Sheets

5050TS1L, 5050TS1R

Figure 46. Detail of Steam Piping



Legend

B . . . Steam inlet

C . . . Steam condensate outlet

H . . . 16 instances

N1 . . Flanged connection and covers are shipped with the machine. Replace plugs with flanged connections. Install flange covers. Remove flange covers when final steam connections are made.

Table 44. Parts List—

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	A74SB002B	5050 LEFT STEAMBOX LG BOOSTER COIL ASSMBLY	5050TS1L
	B	A74SB002C	5050 RIGHT STEAMBOX LG BOOSTER COIL ASSMBLY	5050TS1R
	C	A74SB001E	5050TS1L SHORT STEAM BOOSTER COIL	5050TS1L
	D	A74SB001E	5050TS1R SHORT STEAM BOOSTER COIL	5050TS1R
			Components	
all	1	27HS1936SC	STEAMCOIL 19.5X34.5 .049 S/S CENTER DRAIN CASTIC	
all	2	27HS0836SC	S-COIL 8X34.5 .049 S/S RIGHT SIDE DRAIN CASTIC	
all	3	51KE2ANA	NPTFLANGE 2"CS 150#RAISED FACE	
all	4	51KE2ANASA	2" SPIRAL GASKET #FGCCG-1GG	
all	5	51KE2ANAB	SOCKETFLG 2"CS 150# RAISEDFACE	
all	6	51KE1ANA	NPTFLANGE 1"CS, 150#RAISEDFACE	
all	7	51KE1ANASA	1" SPIRAL GASKET	

Steam Box & Coil with Booster

4 Sheets

5050TS1L, 5050TS1R

Table 44 Parts List— (cont'd.)

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
all	8	51KE1ANAB	SOCKETFLG 1"CS,150#RAISEDFACE	
all	9	5SR1ESF	NPT RED 1-1/4X1 304SS 150#	
all	10	5N1A03AF42	NPT NIP 1X3 TBE BLKSTL SK40	
all	11	5N2A02KB42	NPT NIP 2X2.5 TBE BLKSTL SK40	
all	12	5SL2AMFA	NPT ELB 90DEG 2" BLKMAL 150#	
all	13	5N2A10AB42	NPT NIP 2X10 TBE BLKSTL SCH40	
all	14	5N2A04KB42	NPT NIP 2X4.5 TBE BLKSTL SK40	
all	15	5S2AMFA	NPT TEE 2" BLKMAL 150#	
all	16	5N2A02AB42	NPT NIPPLE 2X3 TBE BLKSTL SCH40	
all	17	07 40609	2" NPT FLANGE COVER	
all	18	07 40608	1" NPT FLANGE COVER	
all	19	07 40612B	PIPE COVER HALF 1"	
all	20	07 40612A	PIPE COVER HALF 1.25"	
all	21	07 40612	PIPE COVER HALF 2"	
all	22	07 40612C	PIPE COVER HALF 2" SHORT	
all	23	07 44211B	5050TS1L SHORT STMBOX FRT AIRCYL BRKT	
all	24	07 44200J	5050TS1L SHORT STMBOX REAR AIRCYL BRKT	
all	25	A40 01800	* AIRCYL,2-WAY 7.13 STK=52DRYELL	
all	26	17A040	CLEVIS PIN 1/2"X1+3/8" DRILLED	
all	27	15H051	STDCOTTERPIN 1/8X1+1/2ZINCPL	
all	28	W7 44199G	WLMT=5050TG1L SHORT STM BOX DAPMER	
all	29	W7 44200H	5050TS1L SHORT STM BOX COOL DWN DAMPER	
all	30	G7 71098	DRYER DAMPER ARM INSTALL NORMAL	
all	31	5.40E+16	FLGMTBRG 3/4 BORE BRZ #FLB12	
all	32	54JH10750C	SHFTCOLLAR 3/4"CLPTYP	
all	33	W7 44345A	WLMT=5050 SHORT STM BOX SCREEN FRAME	
all	34	98P031	INSUL 1-1/2"X48"X12-1/2' 6LB DURABLANKET 2300F	
all	35	15P010	TRDCUT PHILPANHDSCR 10-24X1/2S	
all	36	17N059	KNURRIVNUT 1/4-20 ZN.027"-.165 .386	
all	37	15K039	HXCAPSCR 1/4-20UNC2AX3/4 GR5 Z	
all	38	15U185	FLATWASHER(USS STD) 1/4" ZNC P	
all	39	15U180	LOCKWASHER MEDIUM 1/4 ZINCPL	
all	40	15G004HD	1/4-20 USHORT NUT P/R .025-.15	

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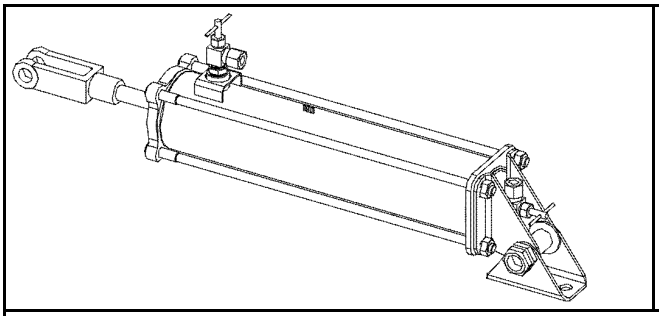
Air Cylinder 2 Way

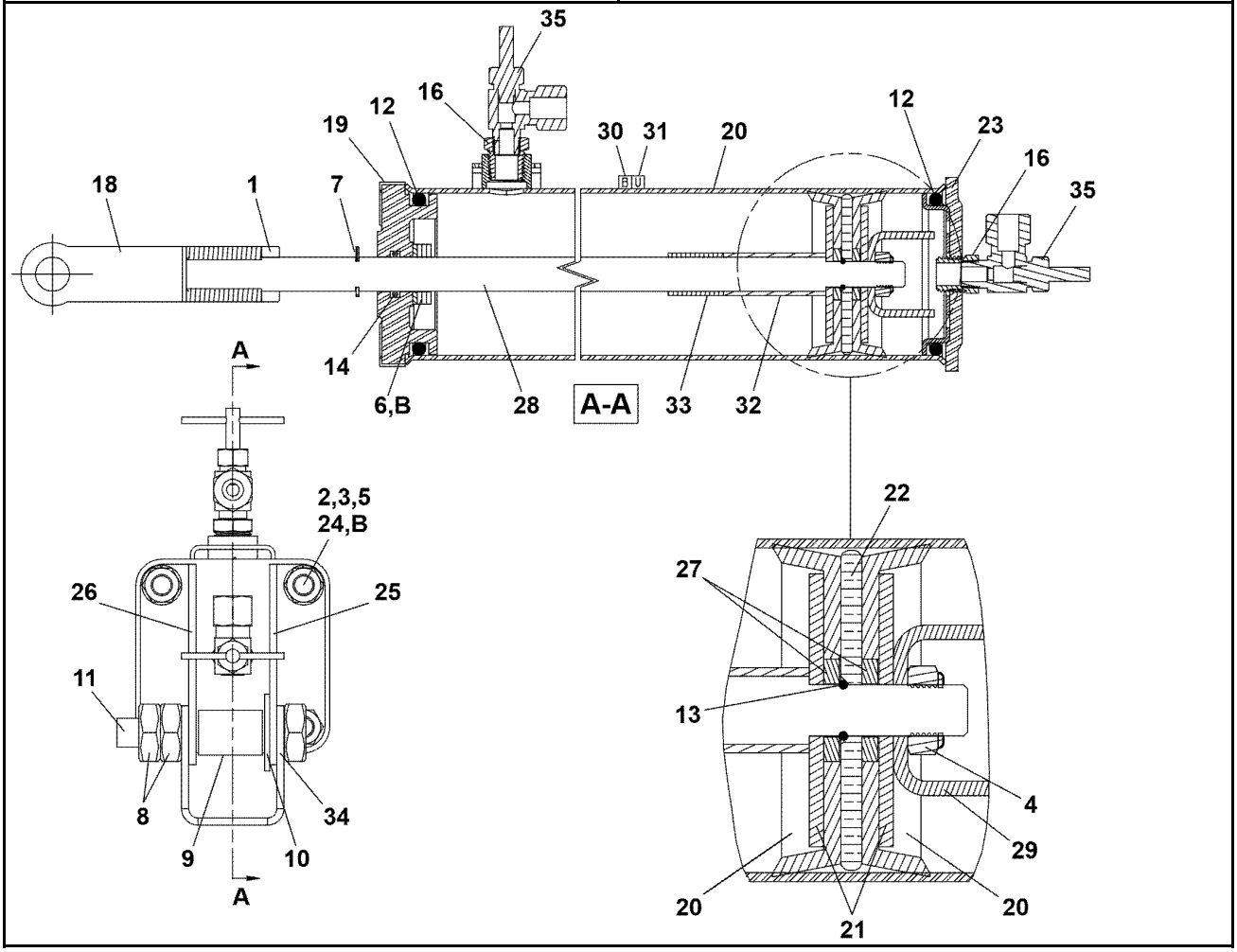
3 Sheet

5050TS1L, 5050TS1R



Legend

B . . . 4 Instances



Air Cylinder 2 Way

3 Sheet

5050TS1L, 5050TS1R

Table 45. Parts List—Air Cylinder 2 Way

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	A40 01800	* AIRCYL, 2-WAY 7.13 STK	
Components				
all	1	15G231	HXFINJAMNUT 1/2-13UNC2B ZINC G	
all	2	15G185	HXNUT 5/16-18UNC2B SAE ZINC GR	
all	3	15U210	LOKWASHER MEDIUM 5/16 ZINCPL	
all	4	15G220	NUTLOK THINHX 3/8-24 SS/NYL	
all	5	15U185	FLATWASHER(USS STD) 1/4" ZNC P	
all	6	15U243	FLTWASHER 7/8ODX33/64IDX16GA Z	
all	7	17B012	EXTRETRING IND#1000-50-ST-ZD Z	
all	8	15G235F	HXFNJAMNUT 9/16-12UNC2B ZINC G	
all	9	27B2750L0T	SPC RROLL.562ID.937L.048T ZNK	
all	10	15U311A	FLTWASHER9/16 ASME/B18.22.1TYP	
all	11	15K206	HEXCAPSCR 9/16-12X2.5 ZC GR5	
all	12	60C132	ORING 2"IDX3/16CS BUNA70 #329	
all	13	60C106	ORING 5/16ID 1/16CSBUNA70#011	
all	14	60C110	ORING 1/2IDX3/32CS BUNA70 #112	
all	15	W3 06315A	* AIRCYL=52 DRYELL	
all	16	5SB0E0CBEO	NPTHEXBUSH 1/4X1/8 BRASS 125#	
all	18	17A020	ADJ CLEVIS MACHINED 1/2-13 ZIN	
all	19	02 18660	CYLHEAD BRASS-DRILL AND TAP	
all	20	02 02194	PISTON CUP=DUMPVALVE 2+3/8"	
all	21	02 02085	UP WASHER=2"OD=PISTON CUP	
all	22	02 02105B	2.38"ACYL BRASS PISTONCUP WSHR	
all	23	02 02101	CYLHEAD W/TAPPED HOLE	
all	24	03 06314	TIEROD=AIR-CYL ACTUATOR-ZINC	
all	25	02 02550	BRKT=AIRCYL-RIGHT ZINC/CAD	
all	26	02 02547	BRKT=AIRCYL-LFT ZINC/CAD	
all	27	02 02185	WASHER=PISTON CUP COMP LIMIT	
all	28	03 06313	STEM=AIR CYL 304SS	
all	29	03 01313	STOP=AIR CYL W/2+11/16STROKE	
all	30	20L601B	ID TAG NAT'L#1614 ALUM EMB "B"	
all	31	20L601U	ID TAG NAT'L#1614 ALUM EMB "U"	
all	32	27B250	SPCRROLL.5ID1.5L.062T STLZNC	

Air Cylinder 2 Way

3 Sheet

5050TS1L, 5050TS1R

Table 45 Parts List—Air Cylinder 2 Way (cont'd.)

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**
all	33	27B240	SPCRROLL.5ID.813L.062T STLZNC	
all	34	02 02556	SUPPORT=AIRCYL 12GA ZINC PLT	
all	35	96H018	ANGLE NEEDLE VLV 1/4"T X 1/8MP,PARKER#NV104C-5-2 W/PIN HANDLE	

9 Water Assemblies

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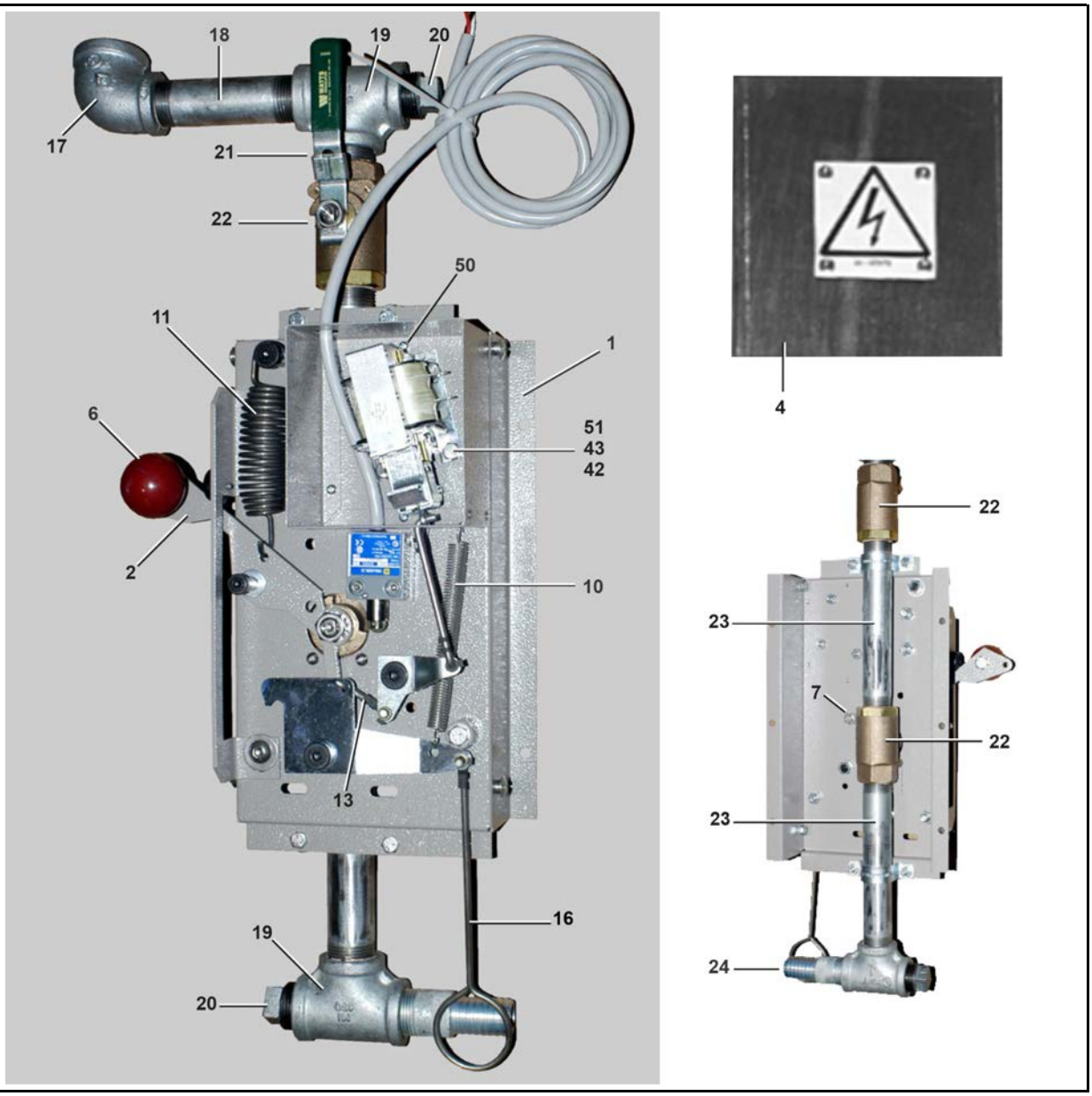
Sprinkler Assembly

4 Sheets

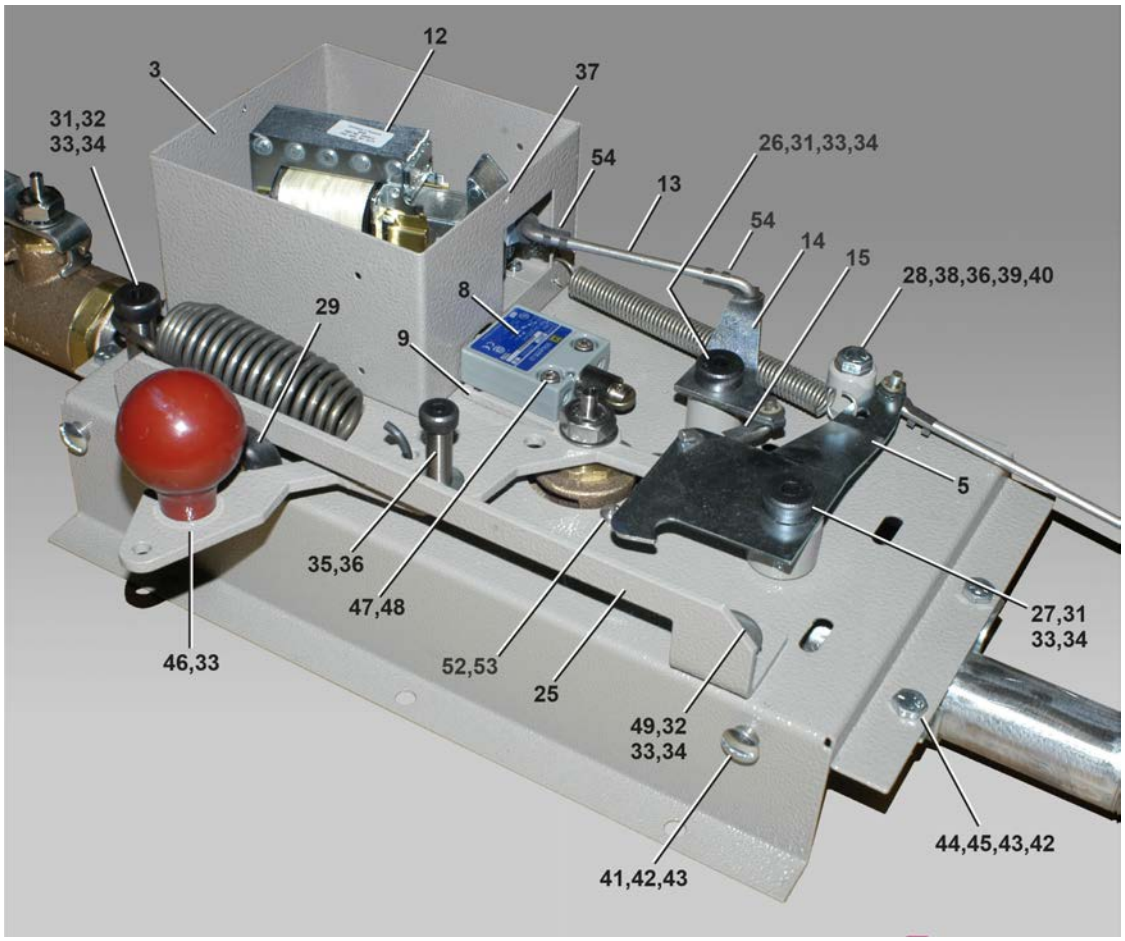
All Dryers



Sprinkler Assembly

4 Sheets

All Dryers



Sprinkler Assembly

4 Sheets

All Dryers

Table 46. Parts List—Sprinkler 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	A77SM005	ASSY=SPRINKLER 6458 LEFT	
			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 PART #0045AK	
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	NPTELB 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"BRZ WATT LFB6400-SS-Z107	
all	23	5N1A08AG42	NPT NIP 1X8 TBE GALSTL SK40	
all	24	51E099SP	DIXON#STC10-DIXON1"KINGCOMBNIP PLTD	
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	
all	29	60C001	RUBBER BUMPER-BLKW/WASHER #698	
all	31	15C061	HXSOKSTRIPBLT 1/2X1X3/8-16	
all	32	15U240	FLATWASHER(USS STD) 3/8" ZNC P	

Sprinkler Assembly

4 Sheets

All Dryers

Table 46 Parts List—Sprinkler Assembly (cont'd.)

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
all	33	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	34	15G205	HXNUT 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	HXNUT 5/16-18UNC2B SAE ZINC GR	
all	41	15N162A	TRUSMACSCR 1/4-20UNC2AX1/2 ZIN	
all	42	15G165	HXNUT 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	HXLOCKNUT NYLON 10-24 UNC SS N	
all	49	15K091	BTNHDSOKCAPSCR 3/8-16NCX1 ASTM F835-2020	
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	

10 Pneumatic Assemblies

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Internal Lint Screens

15 Sheets

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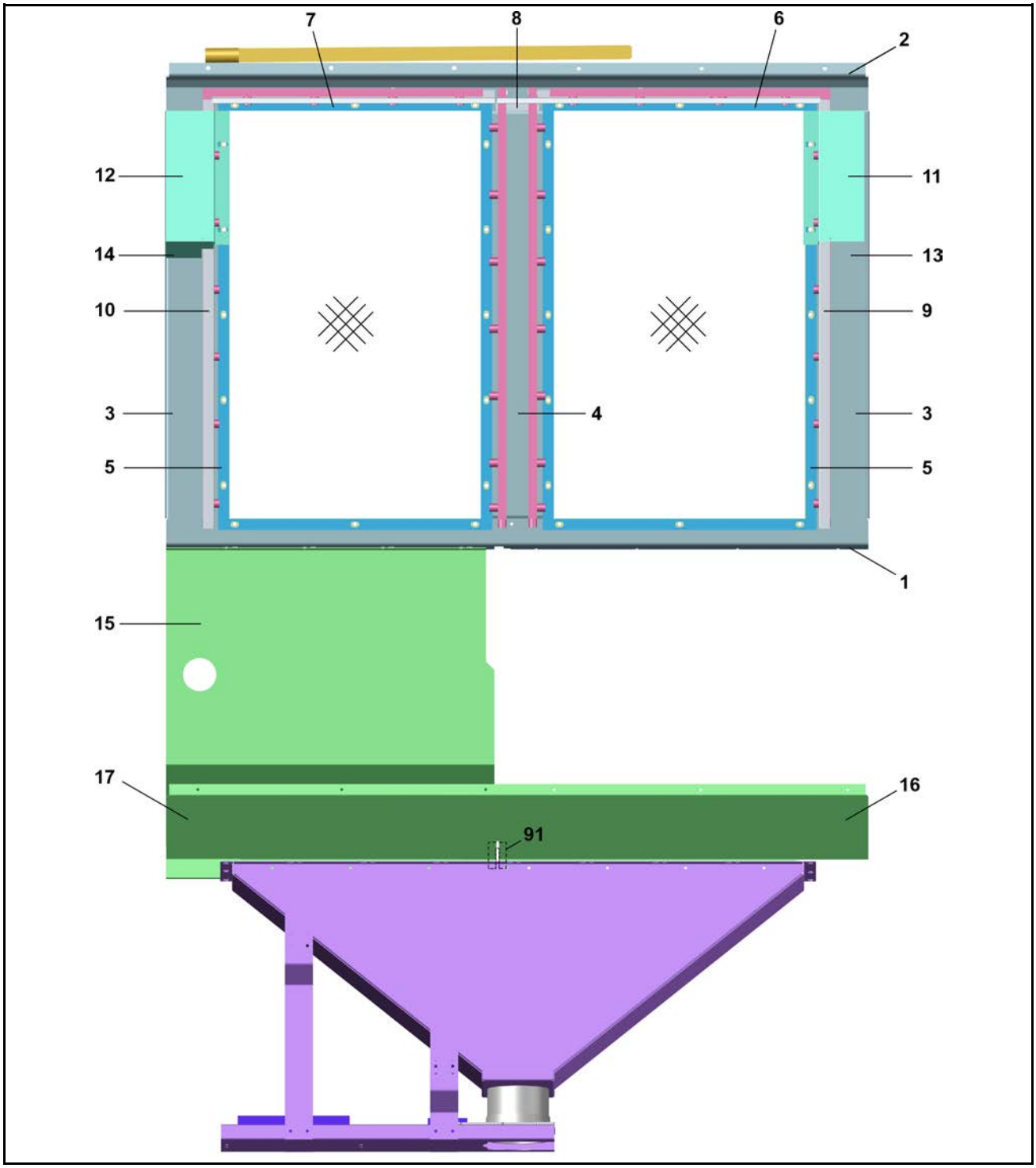
Figure 47. Installation Lint Screens



Internal Lint Screens

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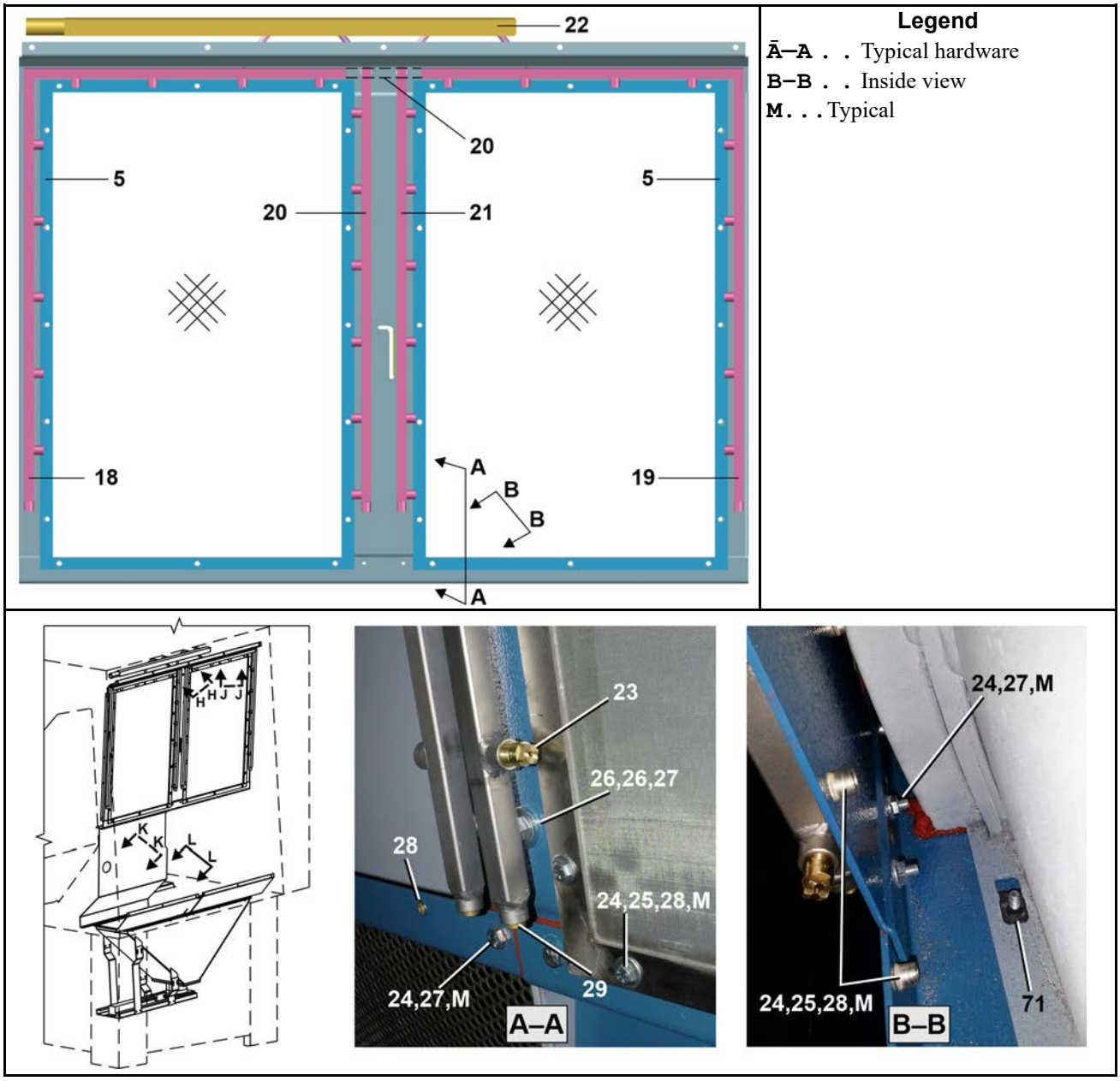
Figure 48. Air Nozzles, Hardware



Internal Lint Screens

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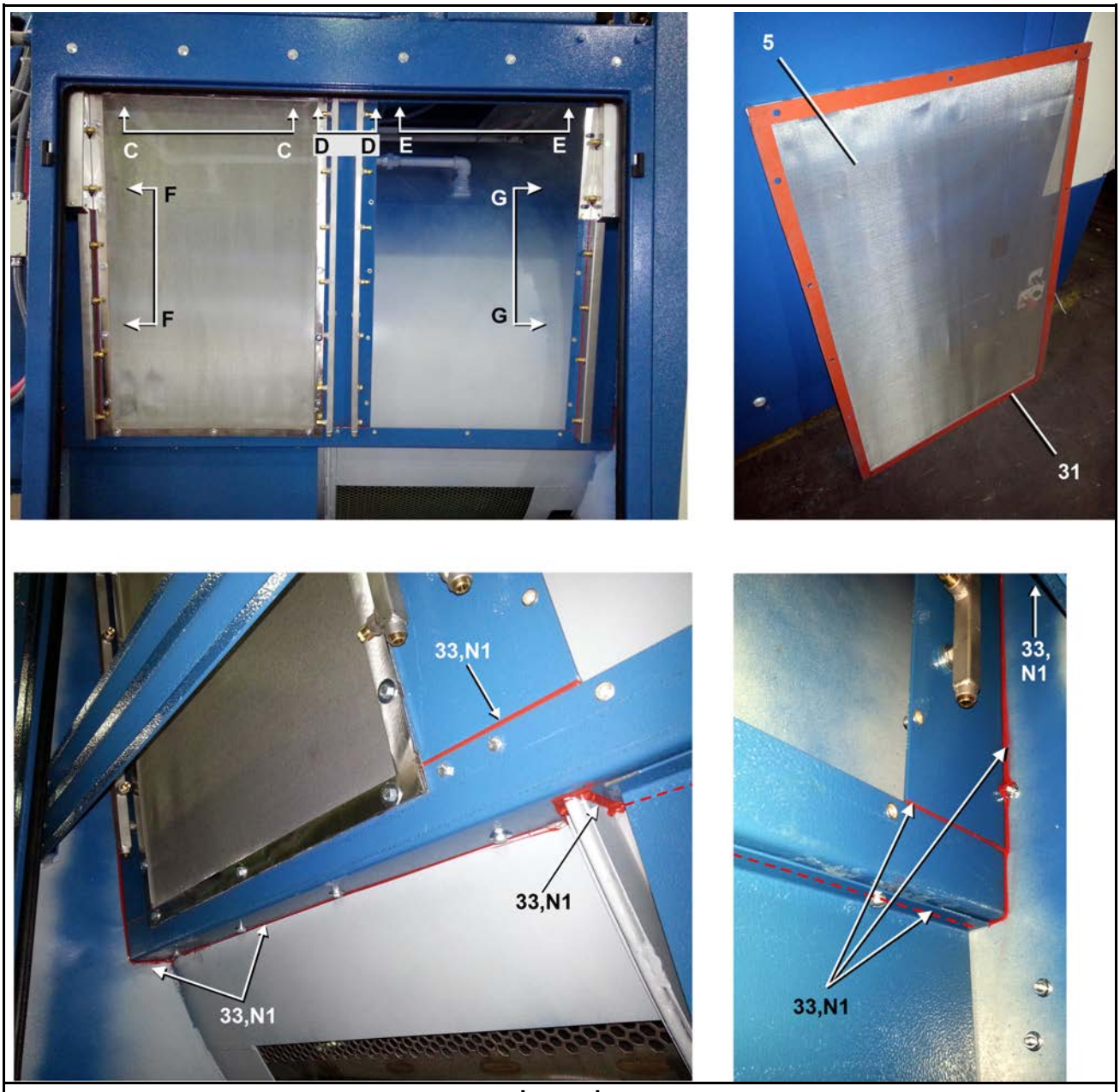
Figure 49. Silicone Sealing



Legend

N1 . . Completely seal all seams and gaps with silicone (item 33) as shown.

Internal Lint Screens

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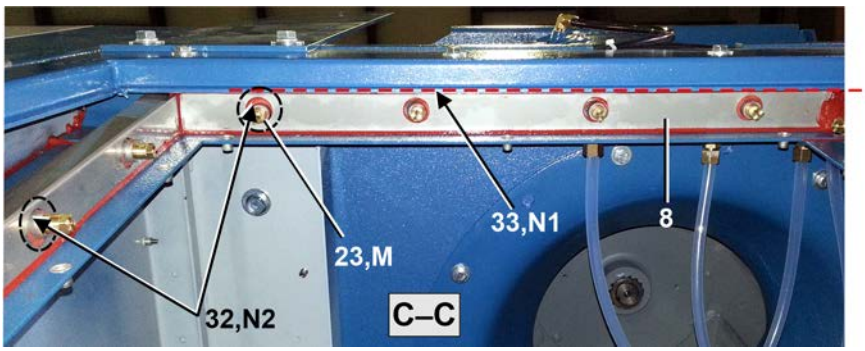
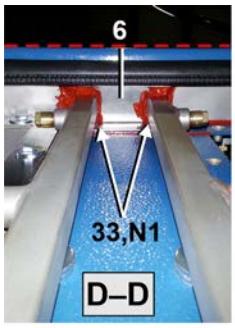
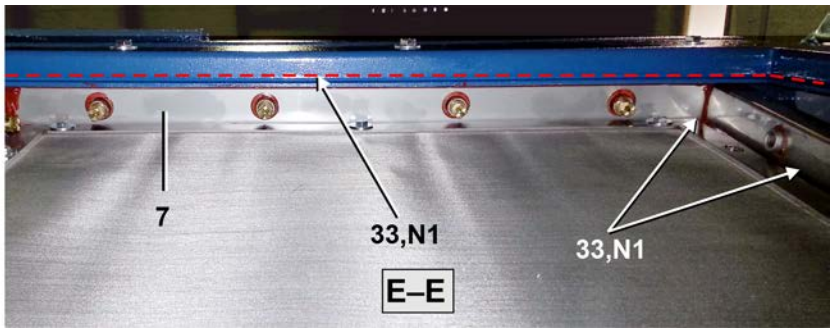
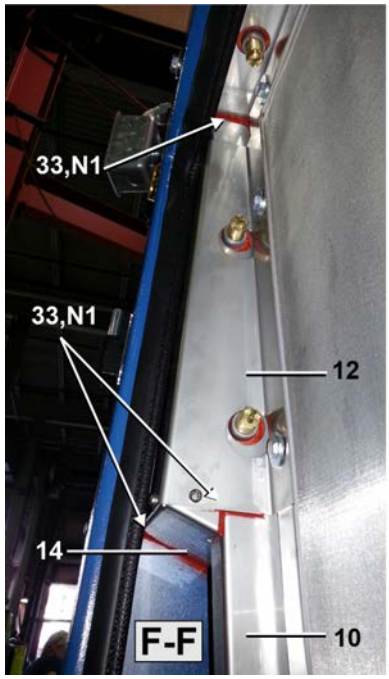
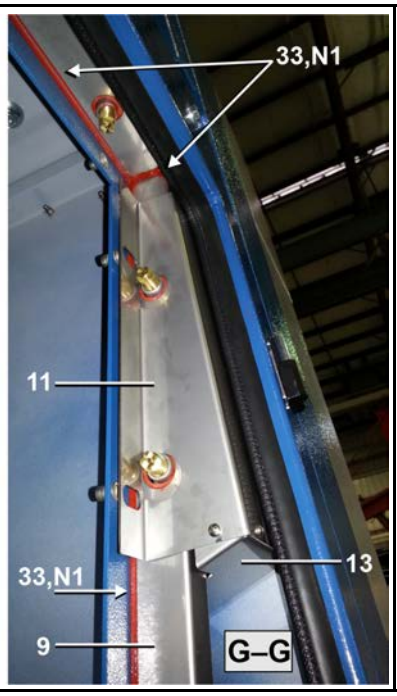
Figure 50. Silicone Sealing Continued











Legend

M . . . Typical

N1 . . Completely seal all seams and gaps with silicone (item 33) as shown.

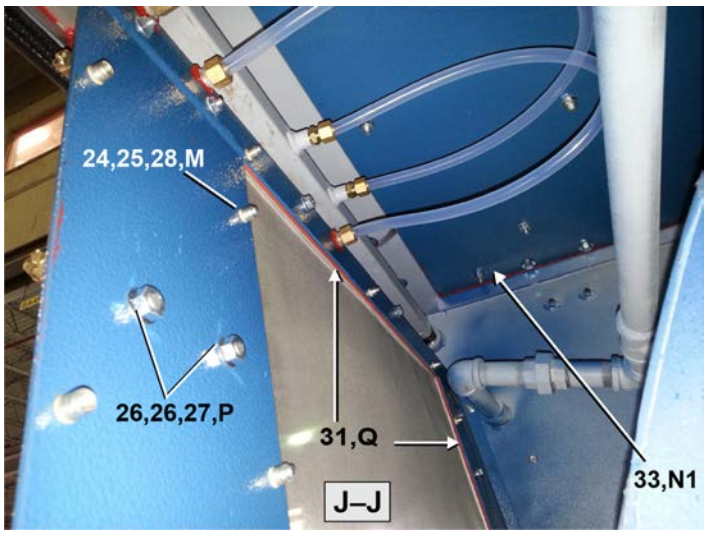
N2 . . Silicone washers (item 32) within. Adhered to manifold with silicone (item 33). (Typical 20 places)

Internal Lint Screens

15 Sheets

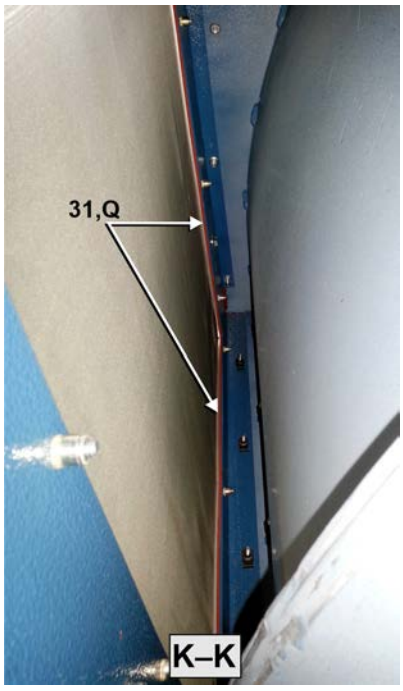
50050, 64058, 64064, 76076, 82082 Dryers

Figure 51. Lint Screens, Air Nozzles, Silicone Sealing



Legend

H-H . . Upper nozzle manifold
J-J . . Inside view of Upper nozzle and screw
K-K . . Inside view bottom of screen
M. . . Typical
N1. . Completely seal all seams and gaps with silicone (item 33) as shown.
P. . . Manifold stud
Q. . . Typical between frame and screen



Internal Lint Screens

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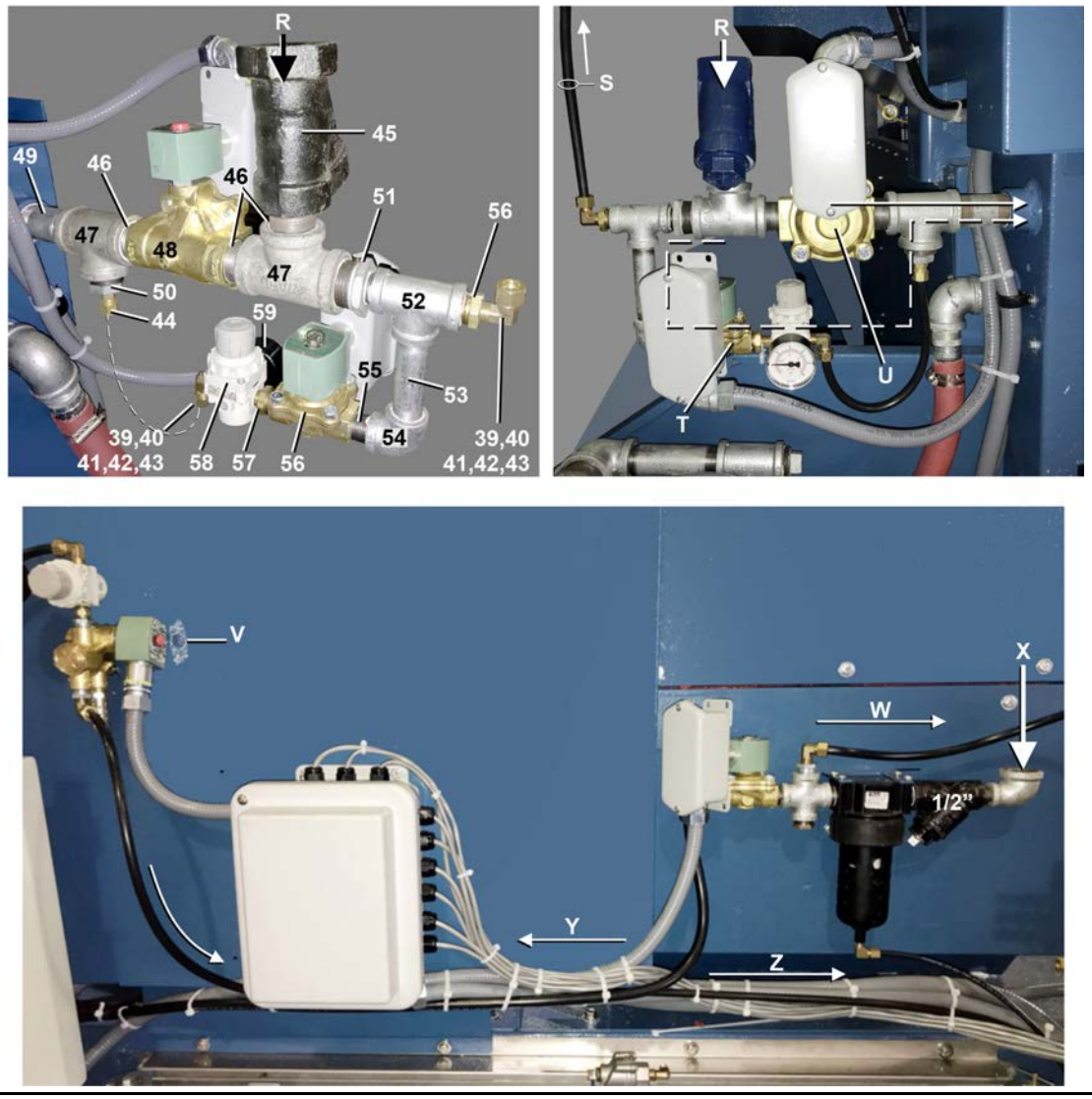
Figure 52. Internal Lint Air Inlet and Valves



Legend

R . . . 1” Air inlet
S . . . To air blade valve assembly
T . . . Nozzle cleaning: low pressure air to the nozzles
U . . . Screen cleaning: high pressure air to blow off the screens
V . . . Air blade valve assembly
W . . . To valve box
X . . . 1” Main air
Y . . . To blower blow down
Z . . . To air blade

Internal Lint Screens

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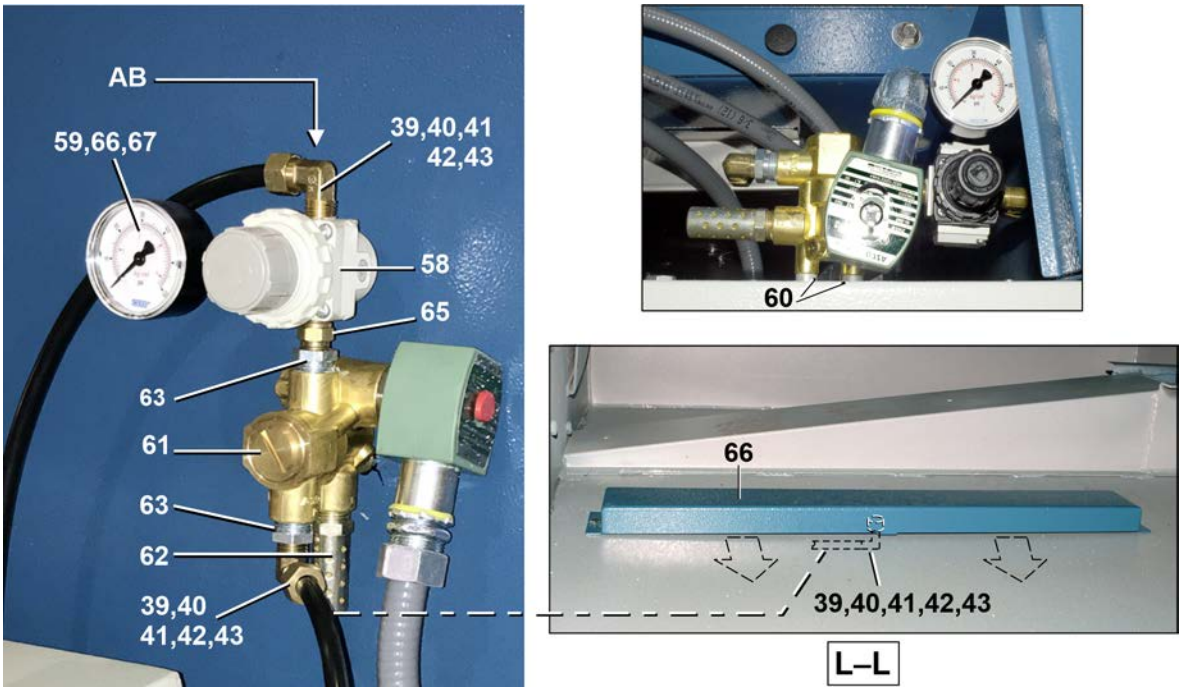
50050, 64058, 64064, 76076, 82082 Dryers

Figure 53. Air Blade Valve Assembly and Lint Collector Pilots



Lint Collector Gate Valve Pilots

Legend

AB . . From internal lint air inlet
L-L . . View air blade manifold
VEEGU . . Normally open
VEEGV . . Normally closed

Internal Lint Screens

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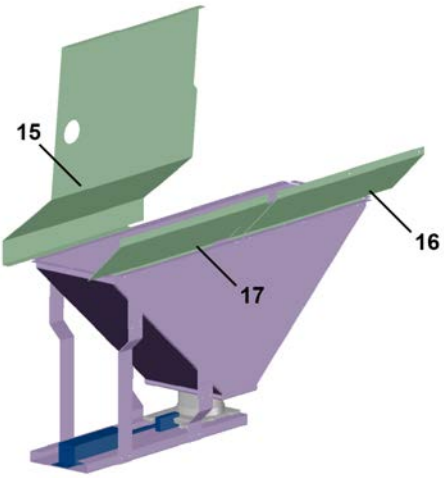
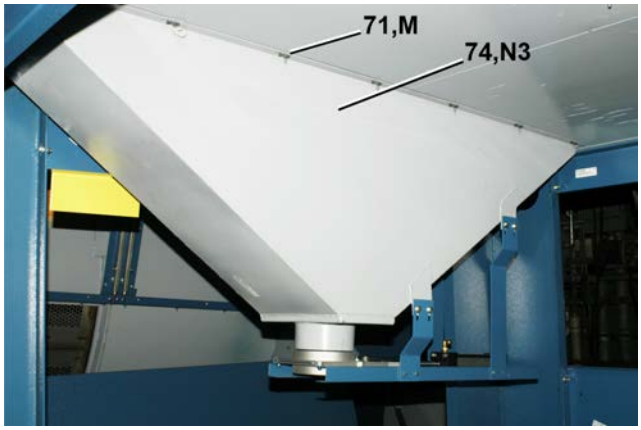
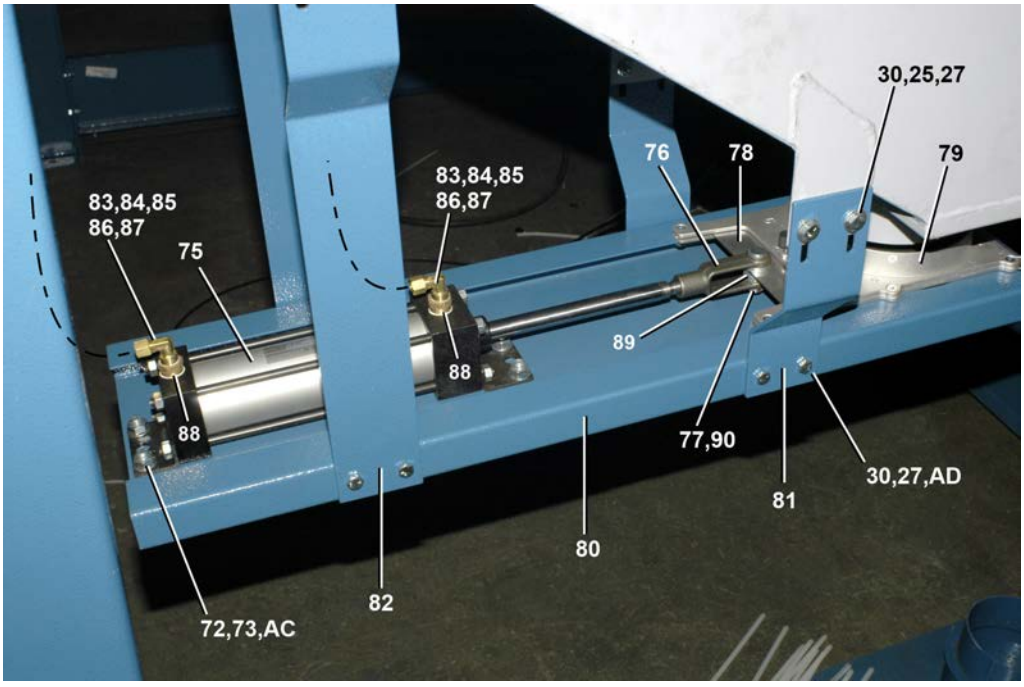
50050, 64058, 64064, 76076, 82082 Dryers

Figure 54. Lint Collector





Air Cylinder and Gate Valve



Legend

AC . . 4 places
AD . . 20 places
M . . . Typical
N3 . . The Lint Collector is mounted under the Dryer at installation. The 6” flexible hose connection pipes to DRYVAC or lint collector by others.

Internal Lint Screens

15 Sheets

50050, 64058, 64064, 76076, 82082 Dryers

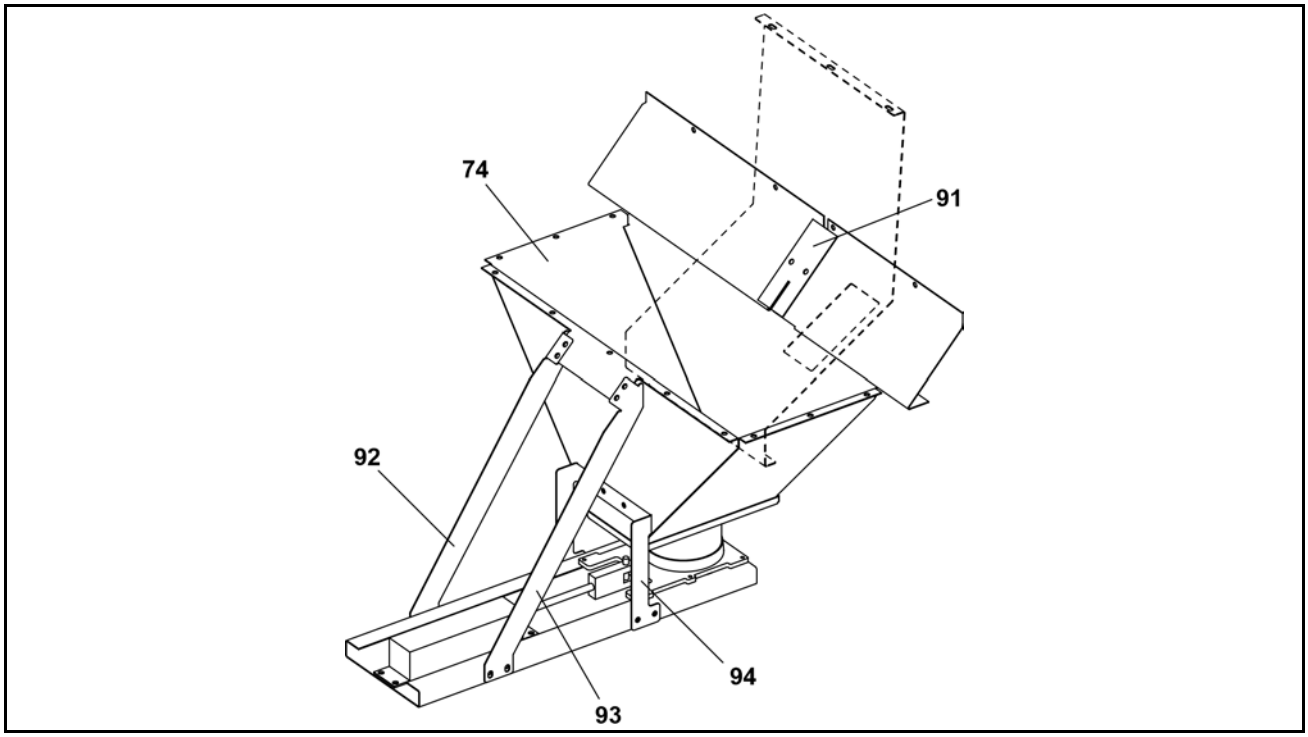


Table 47. Parts List—Internal Lint Screens

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	G74LS001	5040 INTERNAL LINT SCREEN LEFT	5050 LEFT
	B	G74LS001A	5040 INTERNAL LINT SCREEN RIGHT	5050 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 SCRN LT	6464 LEFT
	F	G77LS002C	INST= 6464 NL INT LINT SCRN RT	6464 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 SCRN SUPPORT LEFT	

Internal Lint Screens

15 Sheets

50050, 64058, 64064, 76076, 82082 Dryers

Table 47 Parts List—Internal Lint Screens (cont'd.)

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
D	1	A77RN001A	ASSY=LOWER SCRN SUPPORT RIGHT	
E	1	A77RN005	ASSY=6464 LOWER SCREEN SUPPORT LF	
F	1	A77RN005A	ASSY=6464 LOWER SCREEN SUPPORT RT	
J	1L	A79RN025	ASSY=7676 LEFT LINT SCREEN BRKT BTTM-REAR	
K	1L	A79RN022A	ASSY=7676 RITE LINT SCREEN BRKT BTTM-FRONT	
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 SCRN SUPPORT	
EF	2	A77RN006	ASSY=6464 UPPER SCREEN SUPPORT	
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	
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	
CD	4L	A77RN004	ASSY=DR CNTR SCREEN SUPPORT LT	
CD	4R	A77RN004A	ASSY=DR CNTR SCREEN SUPPORT RT	
EF	4	A77RN004B	ASSY=CENTER SCREEN SUPPORT NEW - LOOK	
JK	4	A79RN024	ASSY=7676 LINT SCREEN 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	
JK	5L	W7 85590	WELD=7676 LINT SCREEN FRAME-FRONT	
JK	5R	W7 85591	WELD=7676 LINT SCREEN FRAME-REAR	

Internal Lint Screens

15 Sheets

50050, 64058, 64064, 76076, 82082 Dryers

Table 47 Parts List—Internal Lint Screens (cont'd.)

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
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	
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 LINT BLOCKER UNLOAD LF	
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 LINT BLOCKER UNLOAD RT	
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 LOAD LT	
F	16	07 72052E	6464 NL LINT DIVERTER LOAD 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 LINT DIVERTER UNLOAD LF	

Internal Lint Screens

15 Sheets

50050, 64058, 64064, 76076, 82082 Dryers

Table 47 Parts List—Internal Lint Screens (cont'd.)

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
F	17L	07 72053C	6464 LINT DIVERTER UNLOAD RT	
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	
F	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	
F	19	W7 81561A	WLMT=BLOW NOZZLE UNLOAD SIDE OPP	
LM	19	W7 88147	8282 BLOW NOZZLE OUTER WLMT LEFT	
CDEF	20	W7 71862	WLMT=BLOW NOZZLE INNER LEFT	
JK	20	W7 85562	WELD=7676 LINT SCREEN BLOW NOZZLE-REAR	
CDEF	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	
F	21	W7 81560	WLMT=BLOW NOZZLE TOP	
JK	21	W7 85560	WELD=7676 LINT SCREEN BLOW NOZZLE TOP	
A	22	W7 44247	5040 LINT SCREEN MANIFOLD WELDMENT	
CDEF	22	W7 71850	WLMT=LINT SCREEN MANIFOLD	
F	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 #12	
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 .386 (13/32 HOLE)	
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 (25FT/ROLL)	
all	32	15U356	FLATWASHER SILICONE 1.50 O.D X .75 ID	

Internal Lint Screens

15 Sheets

50050, 64058, 64064, 76076, 82082 Dryers

Table 47 Parts List—Internal Lint Screens (cont'd.)

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
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	NPTELB 90DEG 1/2 GALMAL 150#	
all	55	5N0KCLSG42	NPT NIP 1/2XCLS TBE GALSTLSK40	
all	56	96TDC2AA37	1/2"N/C2WY120V50/60C VLV	
all	57	5SB0K0EHEO	NPTHEXBUSH 1/2X1/4 STLZNC 125#	
all	58	96J019E	1/4" REG 7-100 PSI #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	

Internal Lint Screens

15 Sheets

50050, 64058, 64064, 76076, 82082 Dryers

Table 47 Parts List—Internal Lint Screens (cont'd.)

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
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	
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	15E006	KEY #6 WOODRUFF 5/32X5/8 SAE10	
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	
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	
AB	91	07 44255	5040 DEFLECTOR COVER	
JK	91	07 85564	7676 LINT BOTTOM CORNER COVER	
AB	92	07 44257	5040 LINT CYL ARM LF	

Internal Lint Screens

15 Sheets

50050, 64058, 64064, 76076, 82082 Dryers

Table 47 Parts List—Internal Lint Screens (cont'd.)

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**
AB	93	07 44257A	5040 LINT CYL ARM RT	
AB	94	07 44256	5040 LINT SCREEN CYL BRKT	

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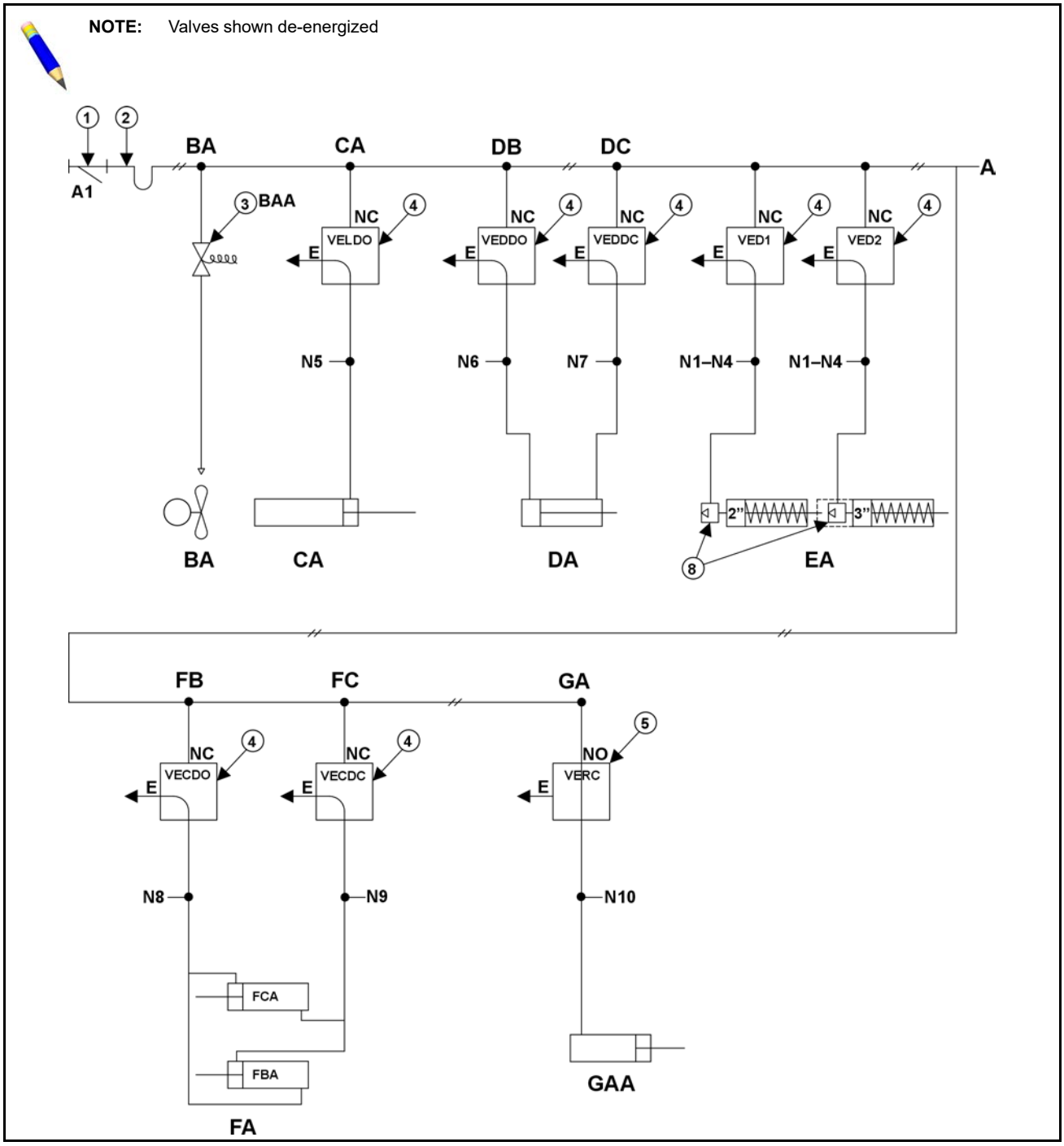
Pneumatic Schematic

5 Sheets

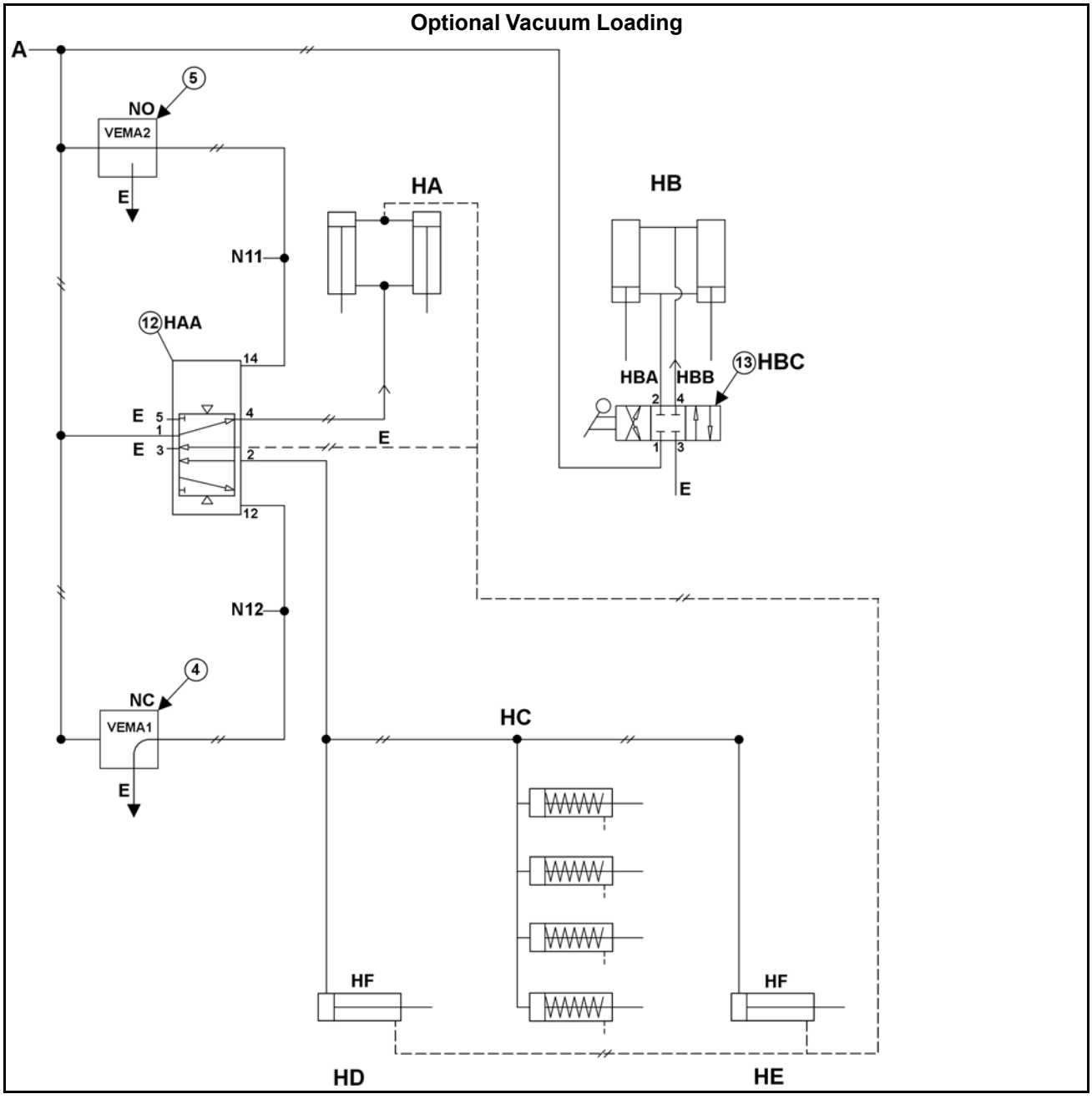
5050TG1L/R, TS1L/R; 6458TG1L/R, TS1L/R; 6464TG1L/R, TS1L/R; 7676TG1L/R; 8282TG1L/R



Pneumatic Schematic

5 Sheets

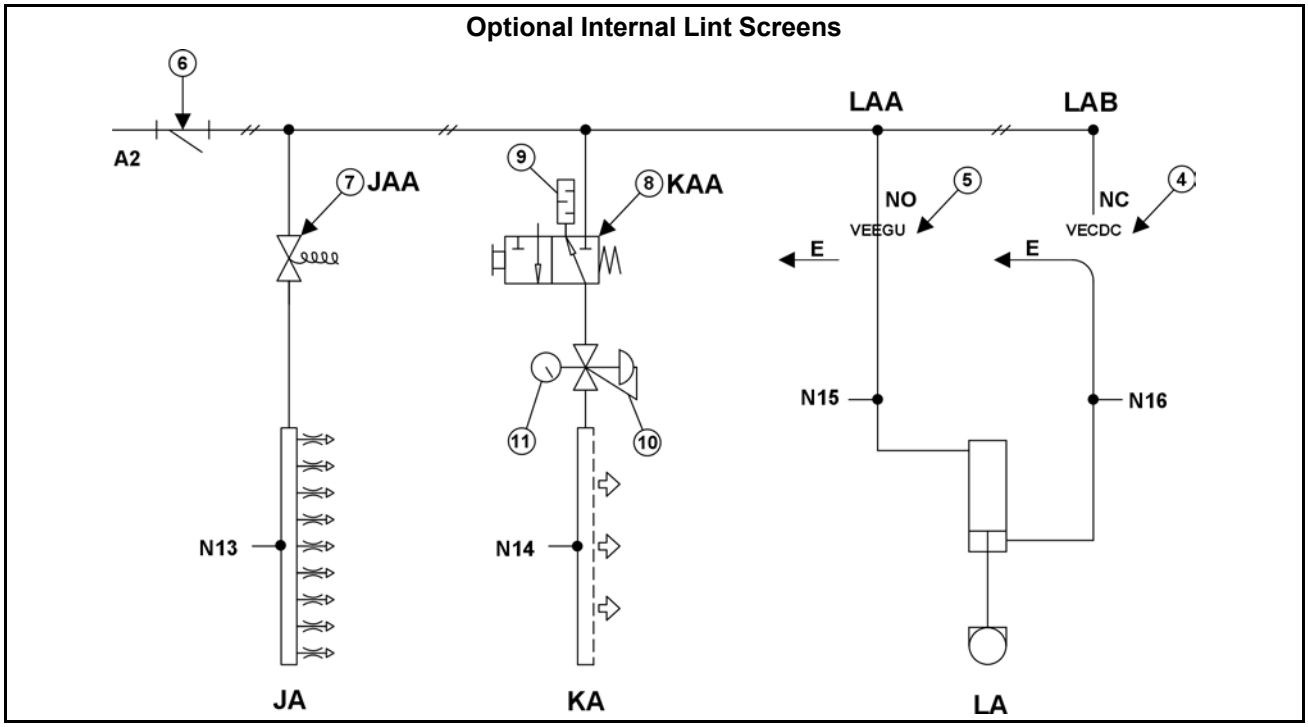
5050TG1L/R, TS1L/R; 6458TG1L/R, TS1L/R; 6464TG1L/R, TS1L/R; 7676TG1L/R; 8282TG1L/R



Pneumatic Schematic

5 Sheets

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



Pneumatic Schematic

5 Sheets

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

Legend	Legend
A . . . Connection point between schematic pages.	**N1 . .** Minimum air flow occurs when pressure is applied to all blower damper air cylinder actuators.
A1 . . Main air 80–100 PSI	**N2 . .** More than minimum air flow occurs when pressure is applied only to the 3” blower damper air cylinder actuator.
A2 . . Secondary air inlet 80–100 PSI	**N3 . .** Less than maximum air flow occurs when pressure is applied only to the 2” blower damper air cylinder actuator.
BA . . Blower blow down	**N4 . .** Maximum air flow occurs when no pressure is applied to actuators.
BAA . . N/C 2-way valve 1/2”	**N5 . .** Pressure is applied to actuator to open load door when pilot is energized.
CA . . Load door	**N6 . .** Pressure is applied to actuator to close unload door when pilot is energized.
DA . . Unload door	**N7 . .** Pressure is applied to actuator to open unload door when pilot is energized.
DB . . Discharge door open	**N8 . .** When the pilot is energized, air pressure is applied to the main coil damper air cylinder to retract and close damper. Air is also applied to the cooldown damper air cylinder to extend and open damper.
DC . . Discharge door closed	**N9 . .** When the pilot is energized, air pressure is applied to the main coil damper air cylinder to extend and open damper. Air is also applied to the cooldown damper air cylinder to retract and close the damper.
E . . . Exhaust	**N10 . .** The normally open pilot allows air to cylinder to close damper for no recirculation. When the pilot is energized, air exhausts from the cylinder to allow recirculation.
EA . . Blower damper	**N11 . .** When the pilot is de-energized, air positions the shuttle valve to send air to extend the unload door blast gate cylinders and close the blast gate.
FA . . Steam Dampers (TS1 models only)	**N12 . .** When the pilot is de-energized, no air goes to the shuttle valve. The air cylinders are retracted and the vacuum loading dampers remain open.
FB . . Cooldown damper open	**N13 . .** When the 2-way valve is energized, air flows to the lint screen blow down manifolds.
FBA . . Cooldown damper	**N14 . .** When the 3-way valve is energized, air flows to the pressure regulator and to the air blade.
FC . . Cooldown damper closed	**N15 . .** The normally open pilot allows the air to extend the cylinder and keep the gate valve closed. When the pilot is energized, the cylinder exhausts.
FCA . . Main coil damper	**N16 . .** When the pilot is energized, air is allowed to retract the cylinder and open the gate valve.
GA . . Optional recirculation	
GAA . . Recirculation duct damper	
HA . . Unload door blast gate	
HAA . . Air-operated 4 way 2 position	
HB . . Vacuum nozzle	
HBA . . Retract	
HBB . . Extend	
HBC . . Hand-operated 3 position closed center (shown)	
HC . . Burner seal dampers	
HD . . Combustion duct damper	
HE . . Firebox inlet damper	
HF . . 2–way cylinder	
JA . . Lint screen blow down	
JAA . . N/C 2-way valve 1”	
KA . . Air blade	
KAA . . N/C 3-way valve 3/8”	
LA . . Lint outlet gate valve	
LAA . . Gate valve closed	
LAB . . Gate valve open	
NC . . Normally closed pilot valve	
NO . . Normally open pilot valve	

General Service & Safety Related Components

5 Sheets

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

Table 48. Parts List—Pneumatic Schematic

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	AVA712DT37	VALVE ASSY 64" DRYER OL	
Components				
all	1	51T025	Y-STRAINER 1/2" CAST IRON	
all	2	30N601	1/2"AIRLINE FILTER	
all	3	51T040	Y STRAINER 1" CAST IRON 20 MESH (DUCT. IRON ACCEPTABLE)	
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(DRYVC)	
all	8	96TCC3AA37	3/8" N/C 3WAY 120V50/60C VALVE	
all	9	27A005	MUFFLER 3/8"	
all	10	96J019E	1/4" REG 7-100 PSI	
all	11	30N101	PRESSGAUGE 1/8"BACKCN.0-60PSI	