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Mechanical Parts and Service

6450, 6458, 6464

**TG1L/R (AH), TS1L/R,
TT1L/R**



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1 Safety

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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.

ANY SALE OR FURNISHING OF ANY EQUIPMENT BY MILNOR IS MADE ONLY UPON THE EXPRESS UNDERSTANDING THAT MILNOR MAKES NO EXPRESSED OR IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR USE OR PURPOSE OR ANY OTHER WARRANTY IMPLIED BY LAW INCLUDING BUT NOT LIMITED TO REDHIBITION. MILNOR WILL NOT BE RESPONSIBLE FOR ANY COSTS OR DAMAGES ACTUALLY INCURRED OR REQUIRED AS A RESULT OF: THE FAILURE OF ANY OTHER PERSON OR ENTITY TO PERFORM ITS RESPONSIBILITIES, FIRE OR OTHER HAZARD, ACCIDENT, IMPROPER STORAGE, MIS-USE, NEGLIGENCE, POWER OR ENVIRONMENTAL CONTROL MALFUNCTIONS, DAMAGE FROM LIQUIDS, OR ANY OTHER CAUSE BEYOND THE NORMAL RANGE OF USE. REGARDLESS OF HOW CAUSED, IN NO EVENT SHALL MILNOR BE LIABLE FOR SPECIAL, INDIRECT, PUNITIVE, LIQUIDATED, OR CONSEQUENTIAL COSTS OR DAMAGES, OR ANY COSTS OR DAMAGES WHATSOEVER WHICH EXCEED THE PRICE PAID TO MILNOR FOR THE EQUIPMENT IT SELLS OR FURNISHES.

THE PROVISIONS ON THIS PAGE REPRESENT THE ONLY WARRANTY FROM MILNOR AND NO OTHER WARRANTY OR CONDITIONS, STATUTORY OR OTHERWISE, SHALL BE IMPLIED.

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

BNUUUU02 / 2023296

BNUUUU02 0000158094 G.2 7/20/23, 10:58 AM Released

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™	RecircONE®
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™	

BNDUUS06 / 2021243

BNDUUS06

0000349888

A.3

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Released

1.3 Safety — Pass Through Dryer

BNDUUS06.C01 0000349887 A.2 A.3 6/8/21, 4:02 PM Released

1.3.1 Safety Alert Messages—Internal Electrical and Mechanical Hazards

BNDUUS01.C03 0000239033 A.2 A.3 1/2/20, 1:40 PM Released

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



WARNING: Electrocutation 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

BNDUUS02.C01 0000239083 A.2 A.3 1/2/20, 1:40 PM Released

1.3.3 Safety Alert Messages—Unsafe Conditions

BNDUUS03.C01 0000239106 A.2 A.3 1/2/20, 1:40 PM Released

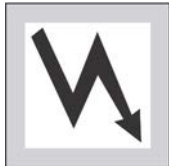
1.3.3.1 Hazards Resulting from Inoperative Safety Devices

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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)

BNDUUS03.C06 0000239114 A.2 A.3 1/2/20, 1:40 PM Released



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.

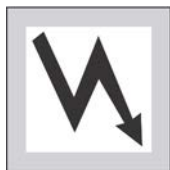


CAUTION: Goods Damage and Wasted Resources — Entering incorrect cake data can cause improper processing, routing, and accounting of batches.

- ▶ 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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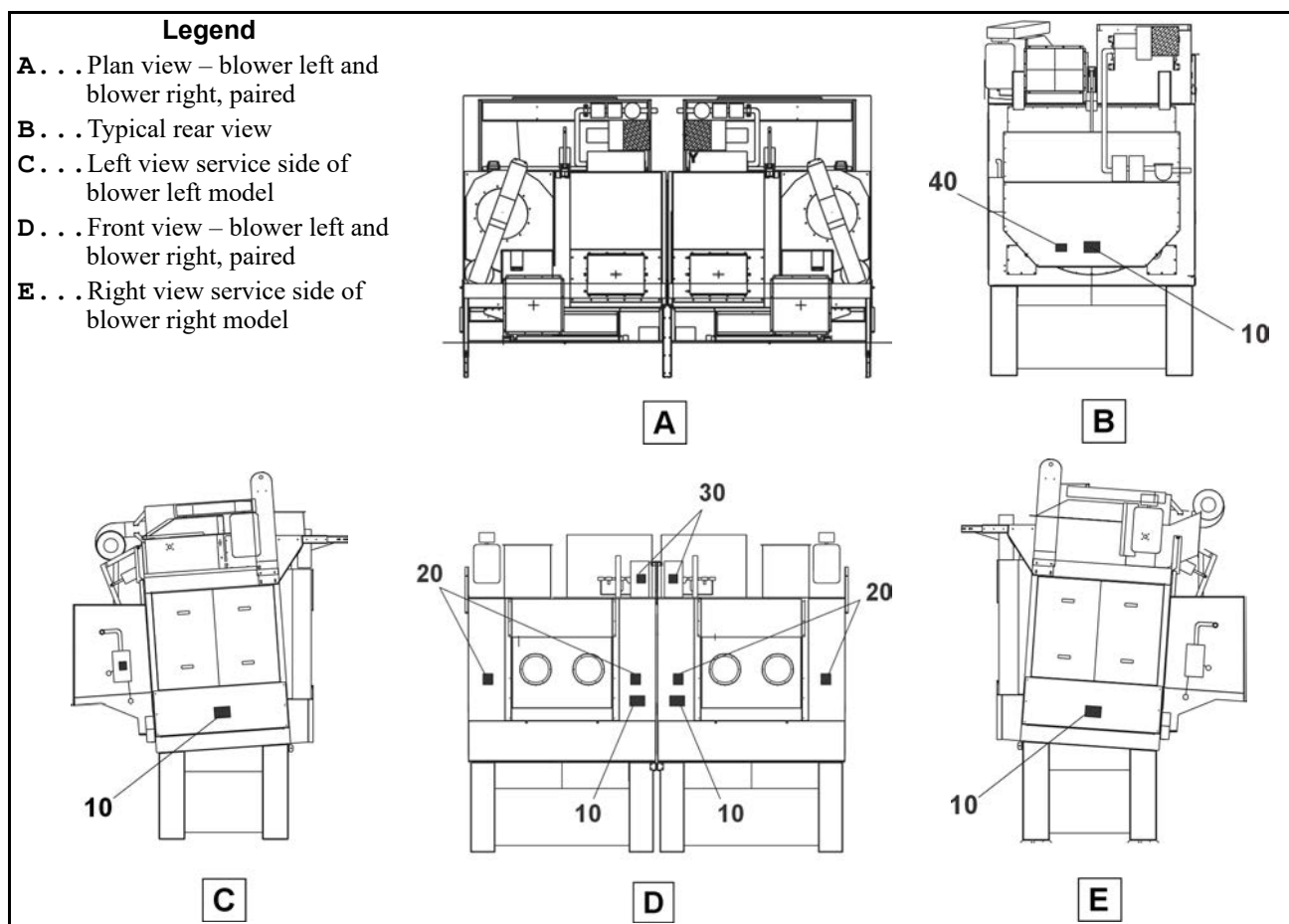
Safety Placard Use and Placement

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.

**Table 2. 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	

BPDUUM02 / 2022244

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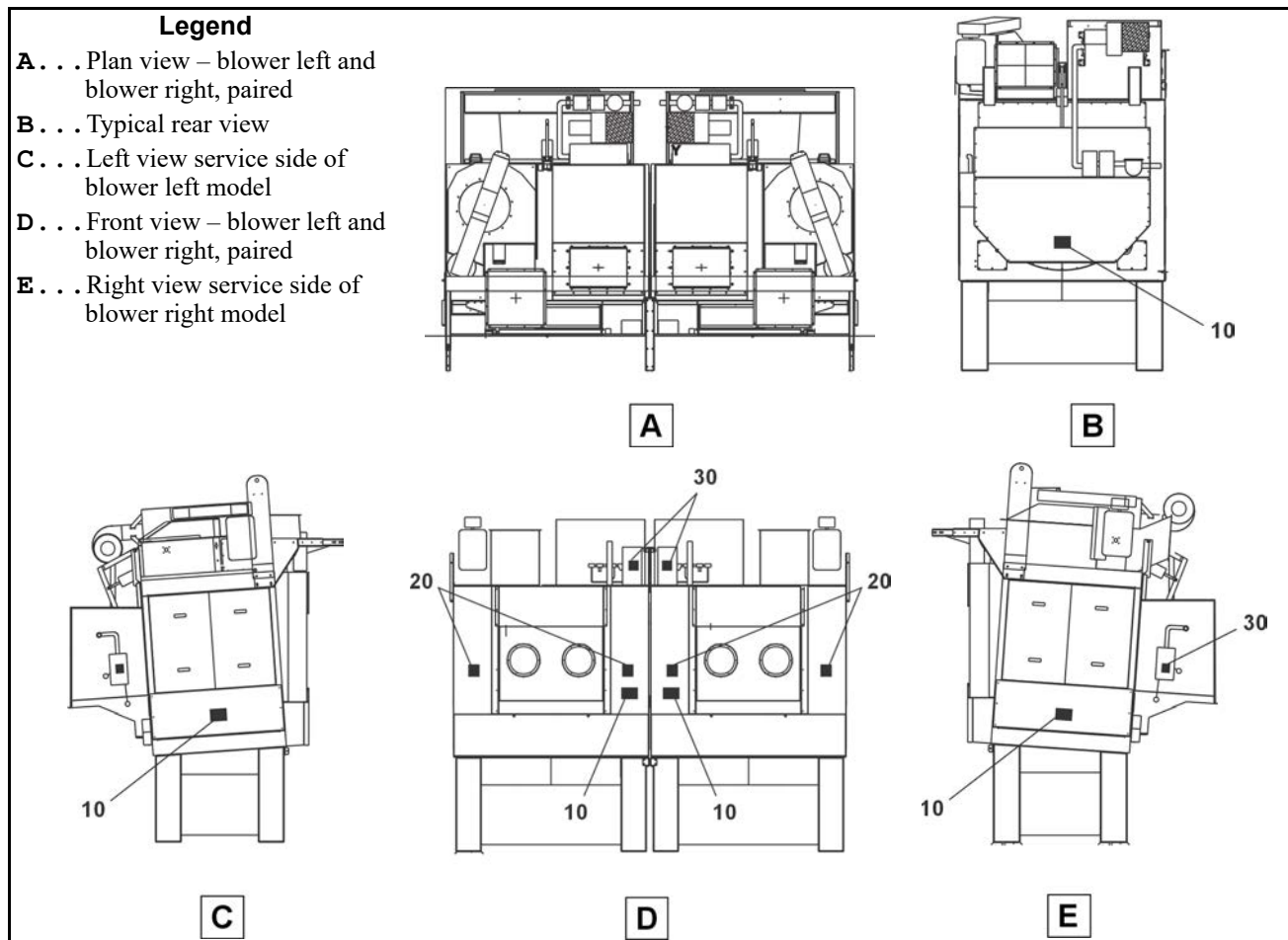
Safety Placard Use and Placement - ISO

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.

**Table 3. 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 and Maintenance

BNDGUM01 / 2023393

BNDGUM01 0000336888 D.2 9/26/23, 9:39 AM Released

2.1 Set the Heating System—Air Heat Dryer

BNDGUM01.C01 0000336887 A.3 A.5 D.2 4/29/21, 10:11 AM Released

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

BNDGUM01.C10 0000344550 C.2 A.3 D.2 9/26/23, 9:36 AM Released

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

Table 4. 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 5. 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 6. 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	GGG	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)
	Combustion air damper		full open	full open	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)
	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)
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)	1.3 (3.2)

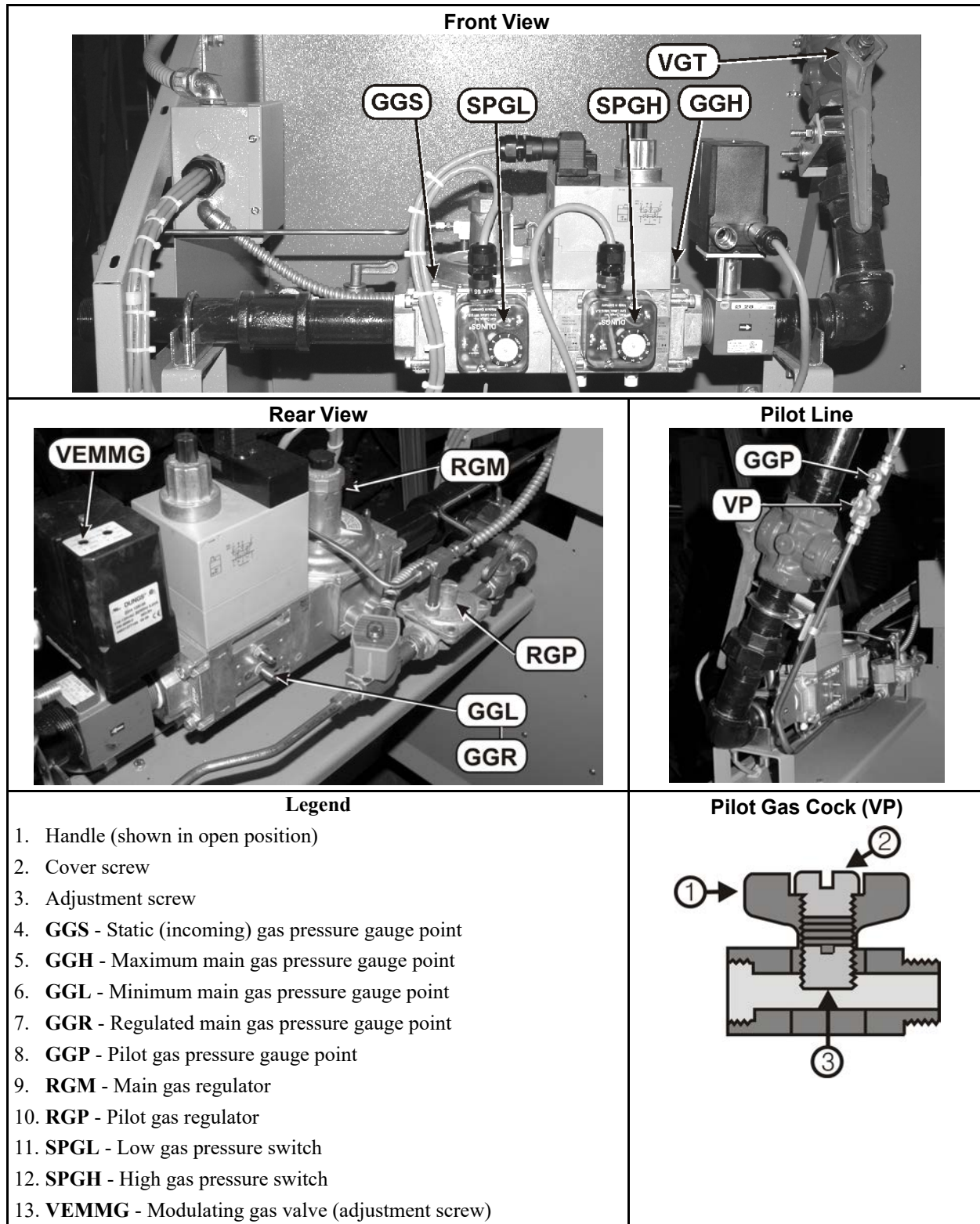
Table 6 Applicable Models (cont'd.)

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: 70° F (21° C) to 80° F (27° 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

BNDGUM01.C03 0000336987 A.3 A.4 D.2 3/24/21, 9:39 AM Released

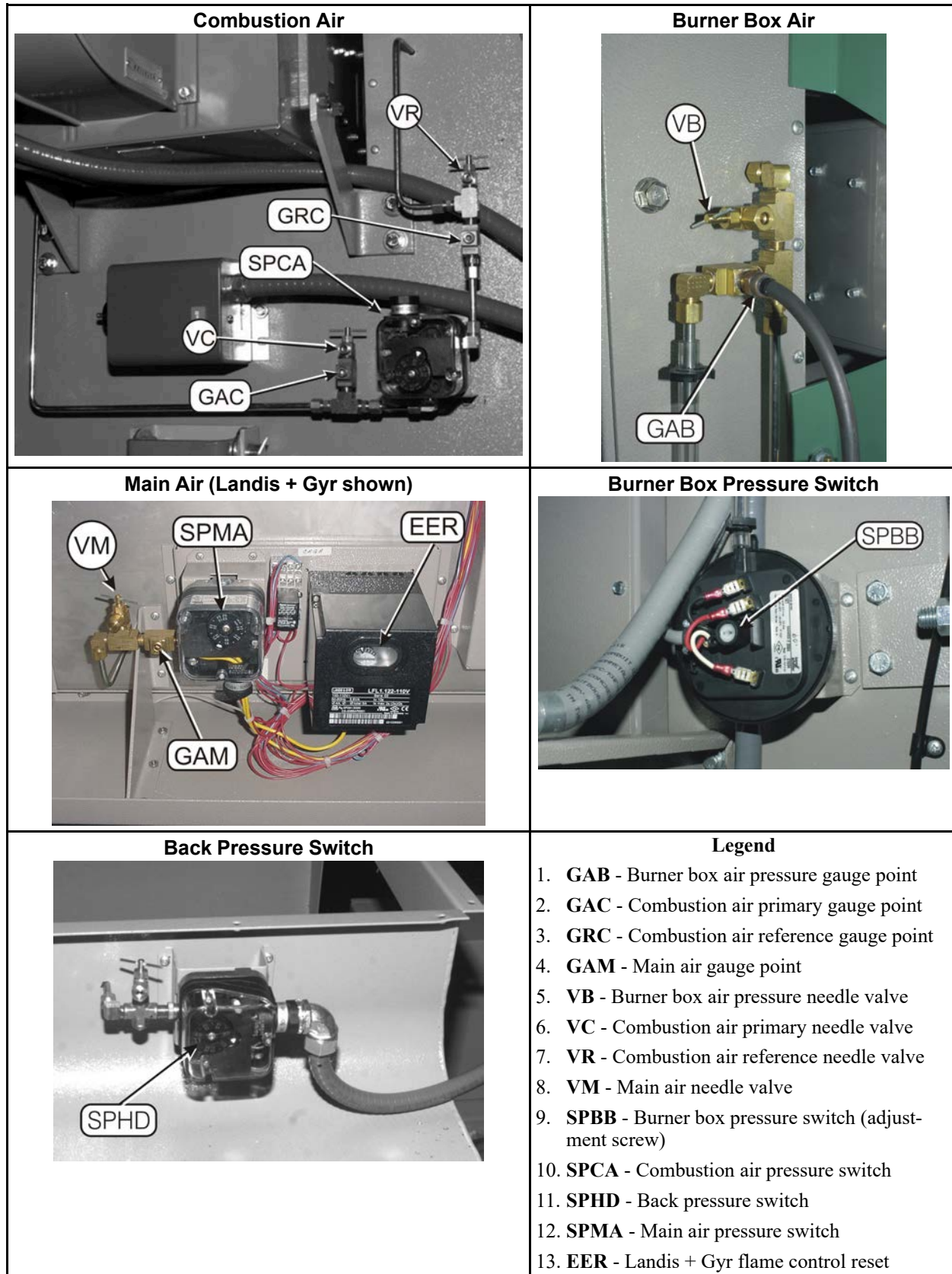
Figure 1. Gas Adjustment Components (5040TG2_ shown. Other models are similar.)



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

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

Figure 2. Air Adjustment Components (5040TG2_ shown. Other models are similar.)



2.1.4 Setup Methods—Fireye or Landis + Gyr Flame Control

BNDGUM01.C04 0000337011 A.3 A.4 D.2 3/24/21, 1:08 PM Released

Do Step 1 (see [Section 2.1.5 : Adjustment Steps, page 25](#)) 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 23](#)). 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 24](#)).



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**.

Resulting display

SETUP PROCEDURE

12



Selects “RETURN TO AUTOMATIC”



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

WAITING FOR LOAD

Explanation

The display after the power up sequence.



Accesses the **manual load** menu

SELECT DRY CODE
00 REDRY



Accepts the default dry code 00 and prompts for load size

ENTER LOAD SIZE
0 FULL LOAD



Accepts the default load size (full load).

LOAD DRYER WITH REDRY

Ignore this prompt.



Starts the cycle.

LOADING

This display appears.

00F TIC TOC 000 VP
xx xxxAxxx xxx xxx

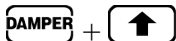
This display appears. The VP value alternates with an air value.

Wait for the burner to ignite.



Stops the timer and accesses the manual control panel for temperature, damper and basket rotation.

TICHTOC LDA MVP BSPD
xxx+xxx x0x 0x xxxx



Sets the damper position. Hold the keys until the damper position (D) = 2.

TICHTOC LDA MVP BSPD
xxx+xxx x2x xxx 000



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,



Returns to automatic

2.1.5 Adjustment Steps

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

Refer to [Section 2.1.2 : Summary of Steps and Required Values \(Air Heat\)](#), page 18 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 D.2 3/24/21, 9:39 AM Released

1. Remove electrical power and gas from the machine.
2. Look at [Figure 1](#), page 20. 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 18. This pressure is necessary for further adjustments. Pressures higher than specified can damage the regulator.

2.1.5.2 Step 2: Combustion air pressure

BNDGUM01.T01 0000337471 A.3 A.4 D.2 4/5/21, 4:24 PM Released

Fireye Start the Setup procedure and select **SETUP MODE A** ([Section 2.1.4.1](#), page 23). 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 24). 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 2](#), page 22. 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 18](#). 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

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Fireye machines Select SETUP MODE B (see [Section 2.1.4.1 , page 23](#)). The damper will fully open.

Landis + Gyr machines Set the damper fully open (D=0). See [Section 2.1.4.2 , page 24](#).

1. Look at [Figure 1, page 20](#). 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 18](#).
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 18](#).

2.1.5.4 Step 4A: Regulated pilot gas pressure

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

Fireye machines Select SETUP MODE C (see [Section 2.1.4.1 , page 23](#)). 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 1, page 20](#). 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 18](#).

2.1.5.5 Step 4B: Pilot flame gas pressure

BNDGUM01.T04 0000338566 A.2 A.3 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 1, page 20](#). 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 18](#).
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 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 23](#)). 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 24](#).

1. Make sure **VGT** is open fully
2. Look at [Figure 1, page 20](#). 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 18](#).

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 D.2 3/24/21, 9:39 AM Released

Fireye machines Select SETUP MODE E (see [Section 2.1.4.1 , page 23](#)). 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 24](#).

1. Look at [Figure 1, page 20](#). 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 18](#). 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 D.2 4/5/21, 4:26 PM Released

Fireye machines Select SETUP MODE E (see [Section 2.1.4.1, page 23](#)). 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 24](#).

1. Look at [Figure 1, page 20](#). 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 18](#).
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

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Fireye machines Select SETUP MODE E (see [Section 2.1.4.1, page 23](#)). 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 24](#).

1. Look at [Figure 1, page 20](#). 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 18](#).

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 23](#)). 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 24](#).

1. Look at [Figure 2, page 22](#). 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 18](#).
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 2, page 22](#)) is set at the factory to the value specified in [Section 2.1.2 , page 18](#). 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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BNDTUM01 0000532849 A.3 6/6/25, 1:48 PM Released

2.2 About The Steam and Hot Oil Control Systems for Milnor® Dryers

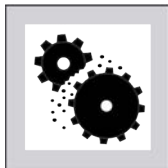
BNDTUM01.C01 0000532848 A.1 B.2 A.3 11/14/22, 8:50 AM Released

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 warranted.

- ▶ Maintain the bypass piping (machines with optional on/off valve, [Figure 3: Standard Steam Piping, page 32](#)) 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.

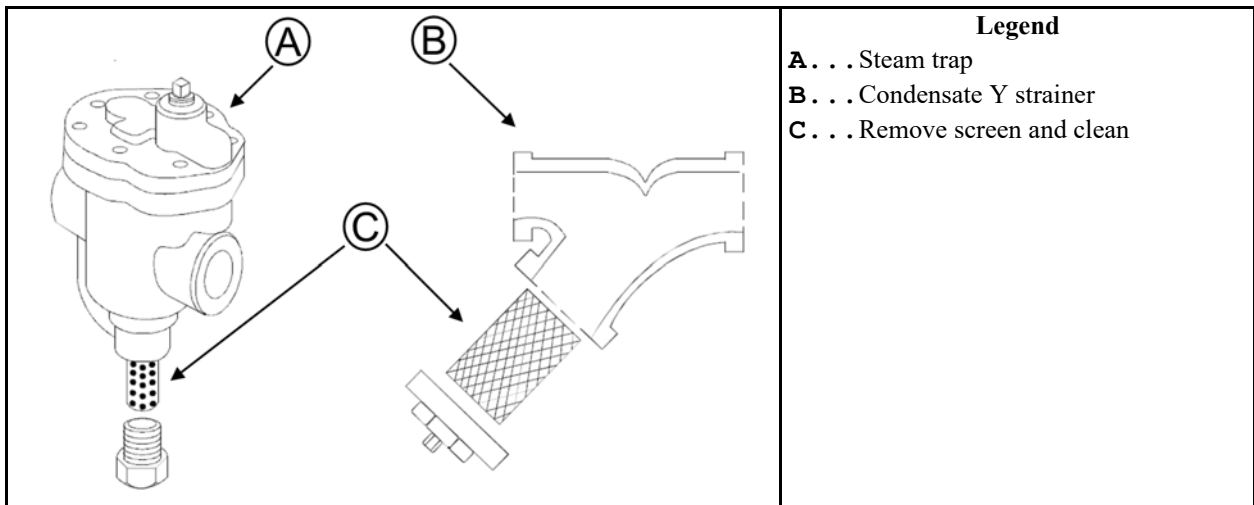
2.2.2 About The Standard Steam Control System

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Each dryer has a strainer and steam trap ([Figure 3: Standard Steam Piping, page 32](#)), 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.



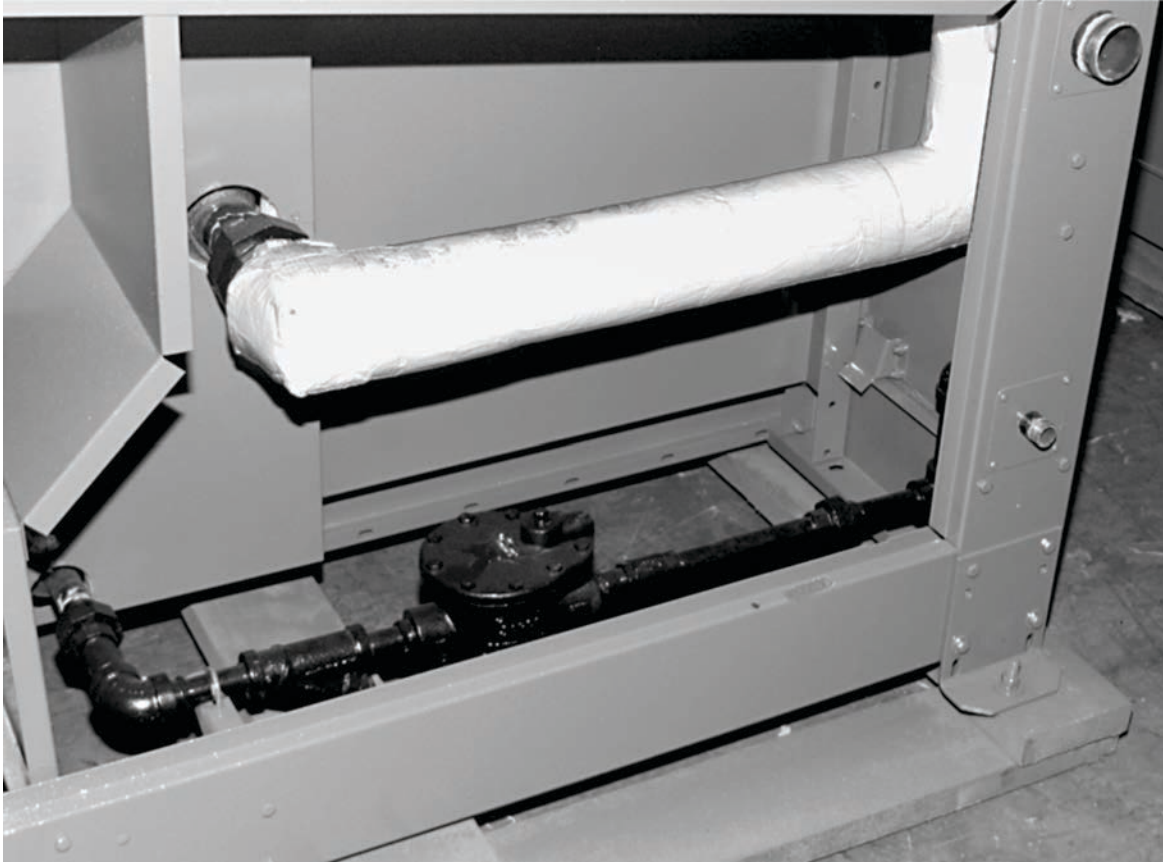
2.2.3 About The Optional On-Off Steam Control System with Y-Type, Air Operated Valve

BNDTUM01.C04 0000532845 B.2 A.3 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 bypass 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 3. Standard Steam Piping



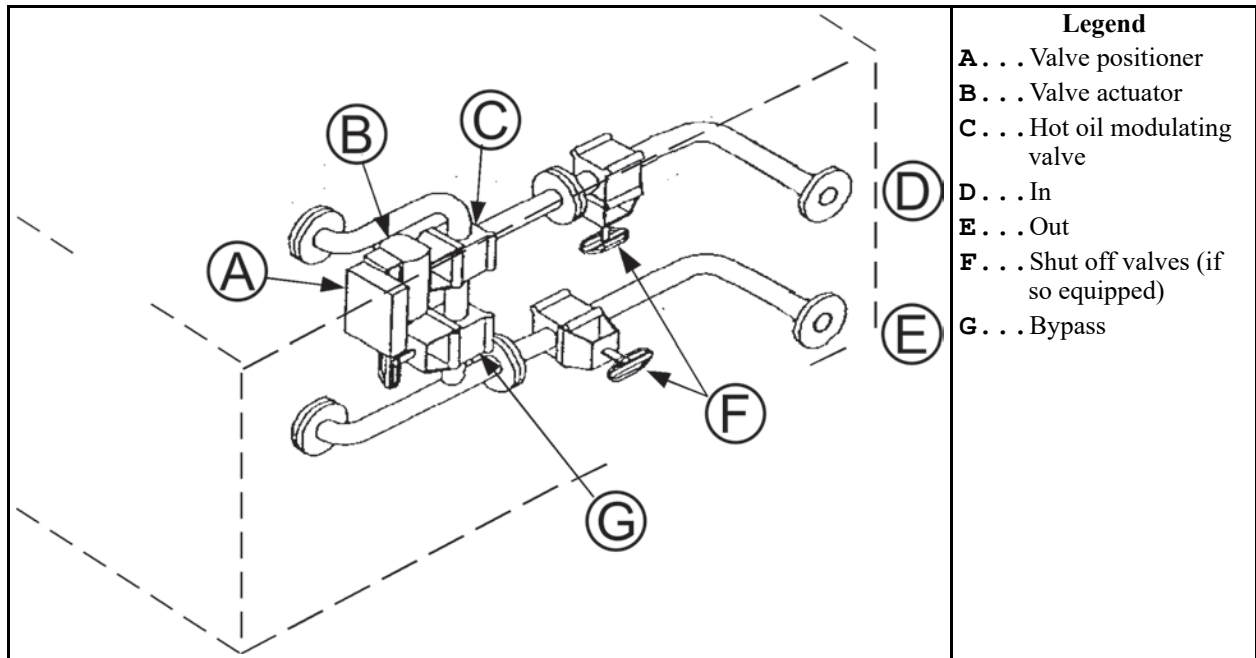
2.2.4 About the Modulating Hot Oil Valve

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

2.2.4.1 How Modulated Hot Oil Works

BNDTUM01.C06 0000532843 B.2 A.3 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 4. Hot Oil Piping

2.2.4.2 How to Manually Command a Modulating Valve Position

BNDTUM01.C07 0000532842 A.3 B.2 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

WAITING FOR LOAD

SELECT DRYCODE
00 REDRY

Explanation

After the power-up sequences, the display shows this screen.

MANUAL
LOAD

Accesses manual load menu

For Quick Return to Automatic from Manual Load menu

WAITING FOR LOAD
*

ENTER LOAD SIZE
0 FULL LOAD

LOAD DRYER WITH
REDRY

LOADING

CANCEL, ESCAPE, CANCEL, ESCAPE etc Returns to automatic

ENTER NEXT Accepts the default drycode 00 and prompts for load size.

ENTER NEXT Accepts the default load size (full load) and prompts the operator to load dryer. Ignore this prompt.

ENTER NEXT Starts the cycle. When loading sequence ends, display appears as shown below.

00F TIF TOF 000 VP
XXX XXXXXXX XXX XXX

Alternates with . . .

00F TIF TOF 0021 AIR
XXX XXXDXXX XXX

TIFHTOF LDA MVP BSPD
XXX+XXX XXX XXX XXXX



Stops the timer and accesses the manual control panel for temperature, damper, and basket rotation.

hold +

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.

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:



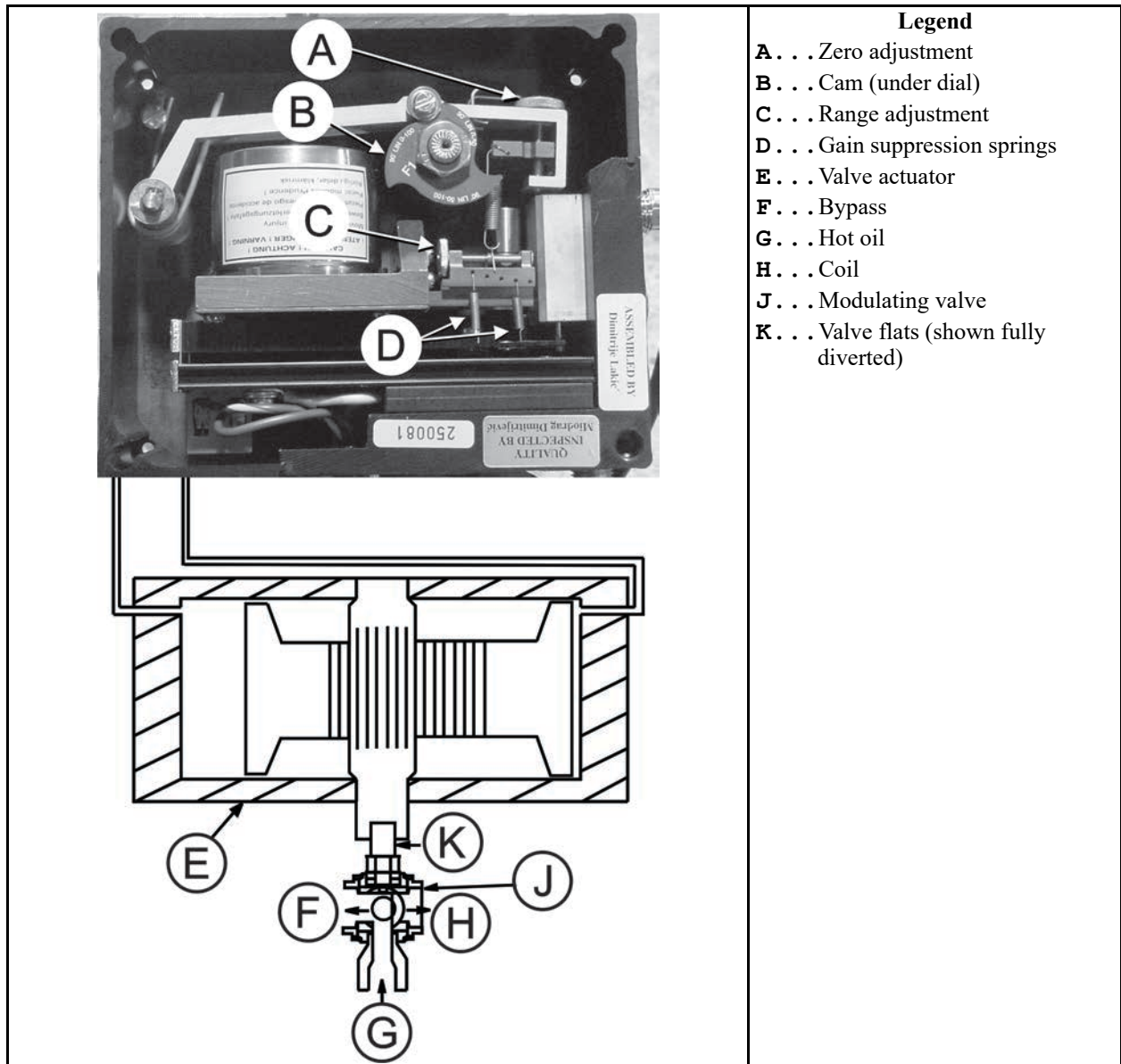
DANGER: Shock Hazard — Electrical power can cause death or severe injury. Lock off and tag out power to the dryer main bus at the wall disconnect before servicing.

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 6: Cam Setting at Modulating Valve Position 000, page 36](#).
5. Check that two gain suppression springs are mounted in positions 1 and 4 (as shown in [Figure 5: Hot Oil Modulating Valve and Positioner, page 35](#)).

Figure 5. Hot Oil Modulating Valve and Positioner

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 33](#) 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
XXXX+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 6, page 36](#). If not, move the zero adjustment thumbwheel ([Figure 5: Hot Oil Modulating Valve and Positioner, page 35](#)) 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 5: Hot Oil Modulating Valve and Positioner, page 35](#) and [Figure 8: Modulating Valve Flats, page 38](#)). 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
XXXX+XXX XXX 255 XXXX

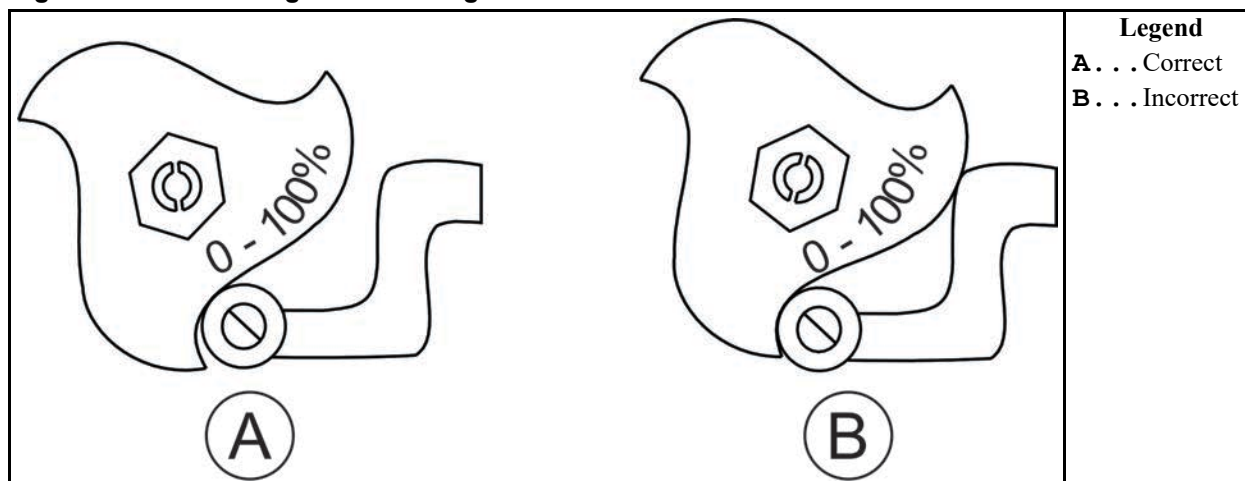
hold MOD VALVE POSITION +

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 6. Cam Setting at Modulating Valve Position 000

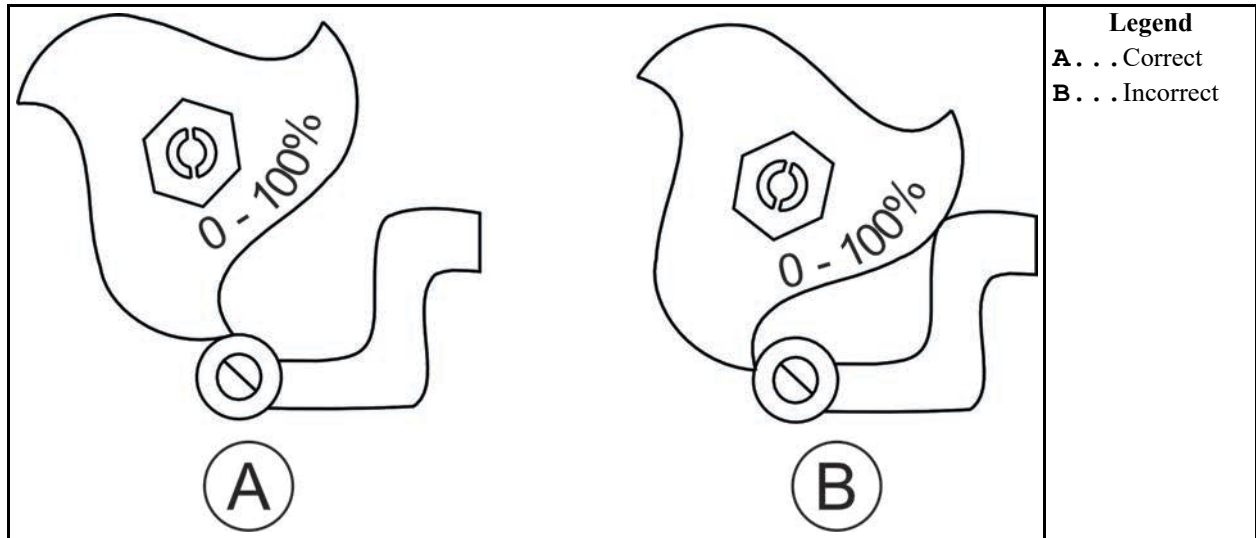


2.2.5.2 Calibrating the Positioner/Valve For Maximum Temperature

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1. Check that the lower arm ball bearing rests on the highest part of the cam curve (Figure 7: [Cam Setting at Modulating Valve Position 255, page 37](#)). If the ball bearing is not at the tip, turn the range adjustment (Figure 5, page 35).
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 7. Cam Setting at Modulating Valve Position 255



2.2.5.3 Verifying Positioner/Valve Settings

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Display or Action

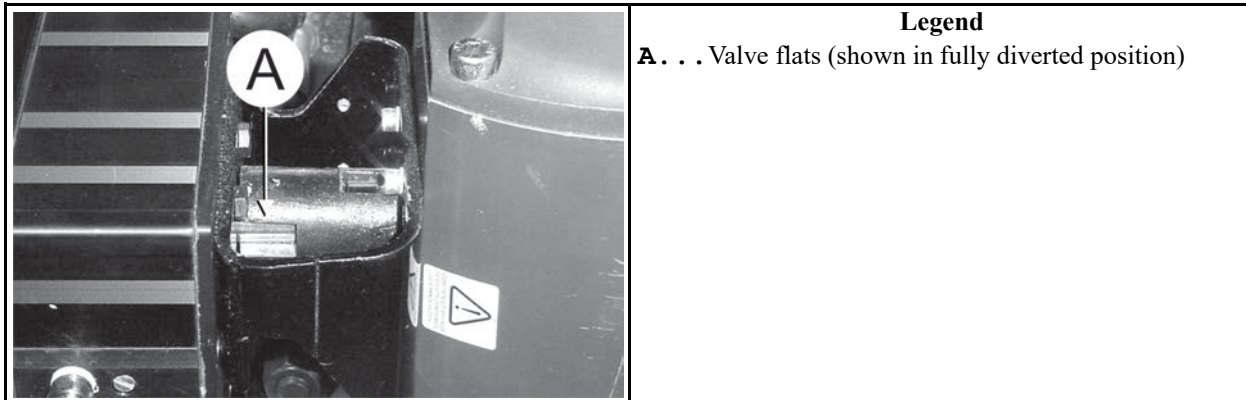
TIFHTOF LDA MVP BSPD
 XXX+XXX XXX 200 XXX

Explanation

hold  +  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 8. Modulating Valve Flats

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2.3 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 2.3.5 : If Water Flow Occurs, page 43](#).

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 2.3.1 : Fire Safety Functions and Components, page 38](#). You can also start it manually. Pull the operation handle or use the control panel as told in [Section 2.3.4 : How to Do a Test of the Fire Safety System, page 41](#). 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.

2.3.1 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 7. 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 9, page 39, Figure 11, page 40, Figure 12, page 40)	Inlet duct (Figure 9, page 39, Figure 10, page 40)	At burner (Figure 9, page 39, Figure 13, page 40)	Outlet duct (Figure 11, page 40)
Safety limit (the temperature or condition that	225° F (107° C)	550° F (288° C)	175° F (79° C)	—Three safety limits in software—

Table 7 Fire Safety Functions for 6464_ and 7272_ Dryer Models (cont'd.)

Sensor type	Temperature switch (closes at specified temperature)			Thermocouple (gives continuous temperature data to the controller)		
causes the given result)				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 2.3.5 : If Water Flow Occurs, page 43	If the error given in the line above this one occurs, see “Error Messages” in the operator guide.		See Section 2.3.2 : About the Min Fire and Outlet Temperature Exceeded 220° Faults, page 40		See Section 2.3.5 : If Water Flow Occurs, page 43
* This does not apply to steam dryers.						
** This does not apply to steam dryers if they do not use modulation.						

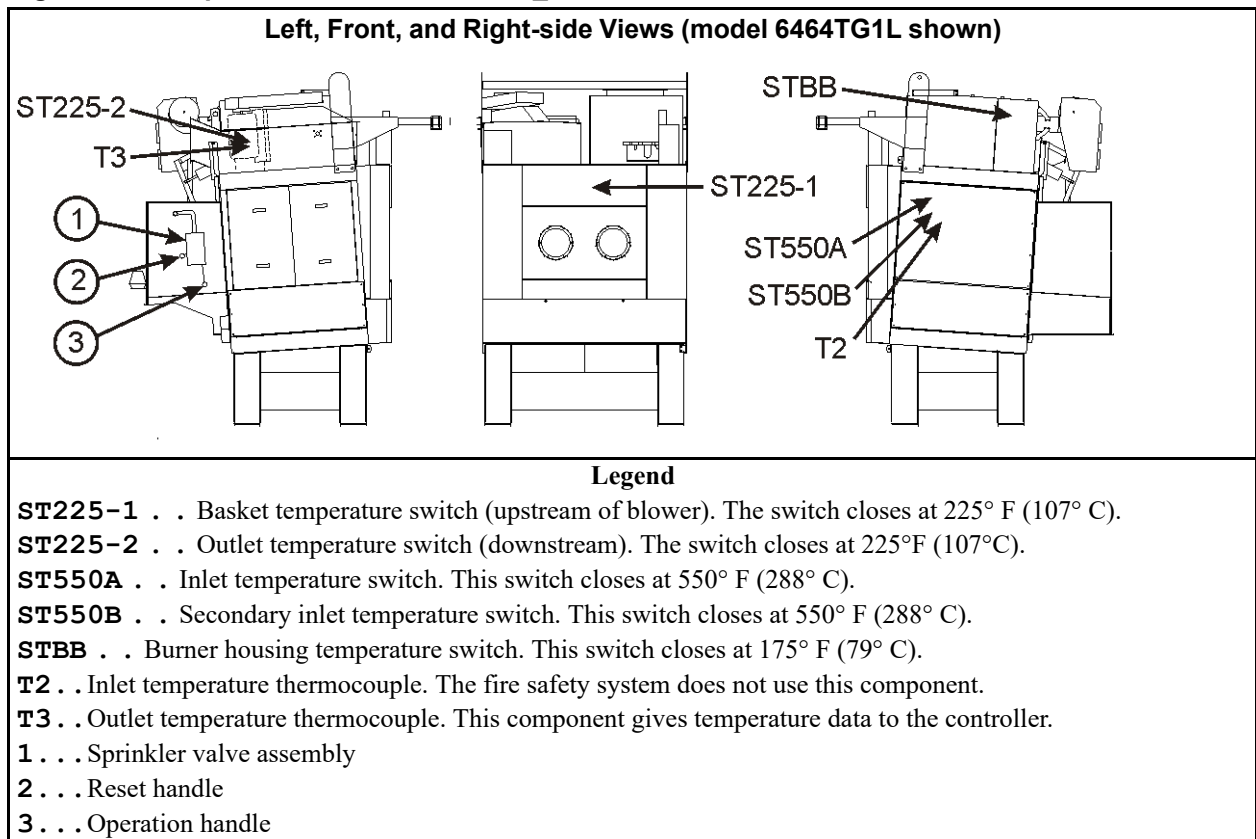
Figure 9. Component Locations for 6464_ Models

Figure 10. View of ST550A, ST550B and T2

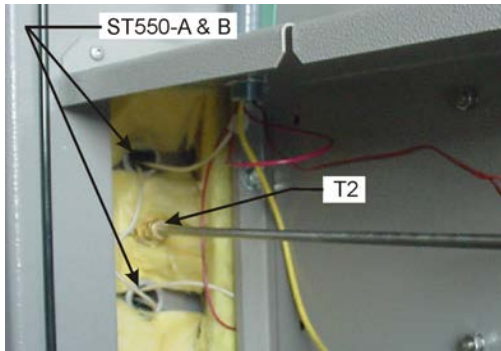


Figure 11. View of ST225-1

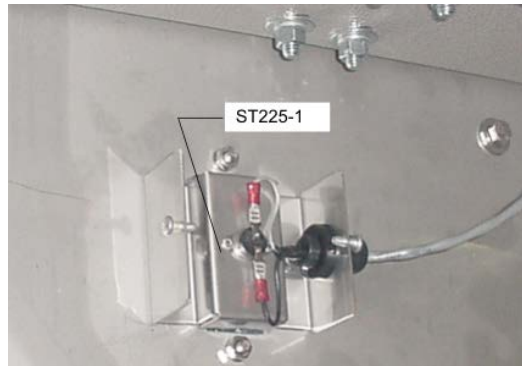


Figure 12. View of ST225-2 and T3



Figure 13. View of STBB



2.3.2 About the Min Fire and Outlet Temperature Exceeded 220° Faults

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

2.3.2.1 Min Fire (MINF)

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

- **The goods are held against the basket**—The correct condition is that the goods tumble in the basket. If the basket speed is too high, centrifugal force can hold the goods against the basket. Then the part of the goods that is against the basket can become too hot.

- **The gas valve does not operate correctly**—For example, the valve throttle cannot move down fully because it is damaged. This can prevent the min fire position.
- **Min fire is set too high**—The min fire position must be adjusted correctly when the gas and air as told in the procedure to set the heat system. Damage to components can cause this adjustment to change.

2.3.2.2 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.

2.3.3 How to Prevent Water Flow When No Fire Occurs

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

- **A temperature switch is damaged.** This is the usual cause. For example, material can hit a temperature probe and bend it. This can be a piece of goods that goes through a space where seals are worn. It is necessary to replace a damaged probe. The probe can also give an incorrect value if it has plastic contamination. It is necessary to remove the contamination.
- **Temperatures are not in the correct range.** The conditions described in [Section 2.3.2.1 : Min Fire \(MINF\), page 40](#) 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.

2.3.4 How to Do a Test of the Fire Safety System

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1. **Prevent a new load:** Set the Load Allowed/ Not Allowed (/) switch to Not Allowed () to prevent a new load.
2. **Let the dryer empty:** Let the dryer operate until it releases the load it has.
3. **Close the manual water valve:** Close the valve to prevent water flow. This valve is on the sprinkler assembly. The assembly is usually on the side of the dryer discharge shroud.
4. **Start a test of sprinkler AUTOMATIC operation:**
 - If there is a controller on the dryer, see “Manual Mode Menu Functions” in the reference manual.
 - If this dryer is part of a Dryer/Shuttle (Drynet™) system, do the steps listed below at the Drynet™ controller:

- a. Select **Admin Logon** and enter the administrator password.
 - b. Select (click) the display for the dryer you will do the test on.
 - c. Select (click) **Manual** mode.
 - d. Go to **Sprinkler Functions** on the right side of the screen and select (click) **Sprinkler [Off]** to release the sprinkler valve. This is a toggle. The display shows **Sprinkler [On]**.
5. Examine the automatic sprinkler valve.



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

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

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



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

9. **Operate the fire safety system manually:** When the heat source starts to make heat, pull down the sprinkler operation handle.
10. **Make sure that a shutdown occurs:**
- The automatic valve opens (the reset handle releases).
 - The THREE WIRE DISABLED message appears.
 - The operator alarm sounds.
 - All dryer functions stop.

11. **Stop the dry code.**
12. **Set the system again:** Pull the sprinkler reset handle down fully. It must latch.
13. **Open the manual valve.**



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

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

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

This concludes the fire safety system test.

2.3.5 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** (①). The operator alarm stops and the display shows WAITING FOR LOAD . LOADING NOT ALLOWED.
- c. Set the **Automatic/Manual Rotation** (↔ / ↶) 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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2.4 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.

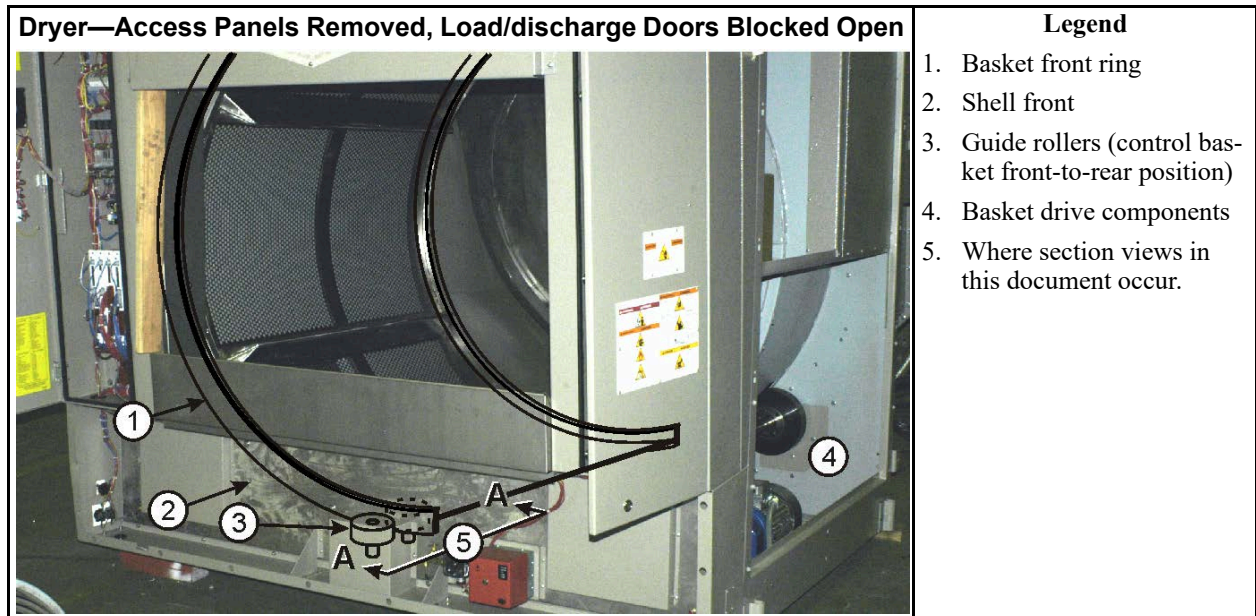


WARNING: Explosion hazard — If the basket seals deteriorate or spread apart, goods can become caught between the basket and shell front or get sucked into the blower wheel causing blower to fail and expel metal fragments at high speed. Bystanders can be struck.

- ▶ 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 14: Dryer Components Pertinent To This Work, page 45](#).

Figure 14. Dryer Components Pertinent To This Work



2.4.1 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.

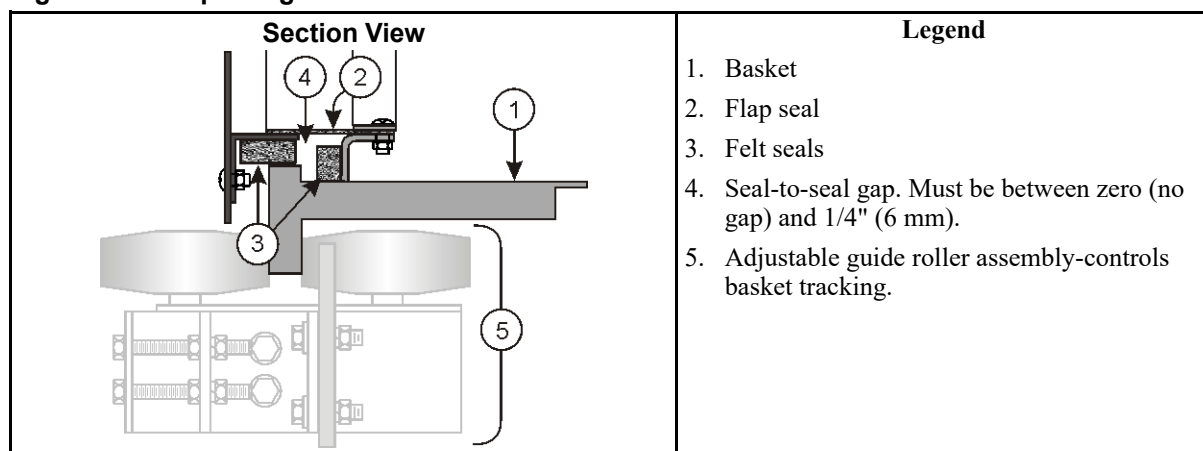


WARNING: Burn hazard — Hot goods and machine surfaces within a recently operated dryer can cause serious burns on contact.

- ▶ 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 15: Inspecting Seals, page 46](#), lift the flap seal and inspect the felt seals.
 - If the seals are deteriorated, replace them as explained in [Section 2.4.2 : Seal Replacement, page 46](#).
 - If the seals are in good condition, but the seal-to-seal gap exceeds 1/4" (25 mm), add felt, as explained in [Section 2.4.3 : How To Close a Front Seal Gap, page 48](#).
 - Otherwise, return the dryer to service.

Figure 15. Inspecting Seals

2.4.2 Seal Replacement

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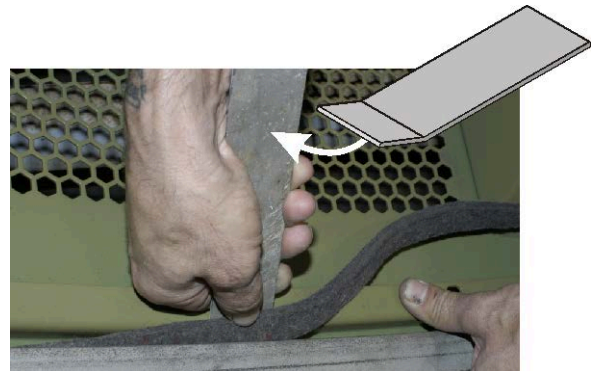
Refer to your "Cylinder Installation" parts document for seal and related component part identification. If you order the silicone rubber flap seal used on older models, you will receive the newer Nomex® seal, which should be used instead. 3M Rubber and Gasket Adhesive #1300, used to glue the felt seals 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 16, page 47](#) and [Figure 17, page 47](#).

Figure 16. Adhesive applicator—1" paint brush, bristles held at an angle with tape

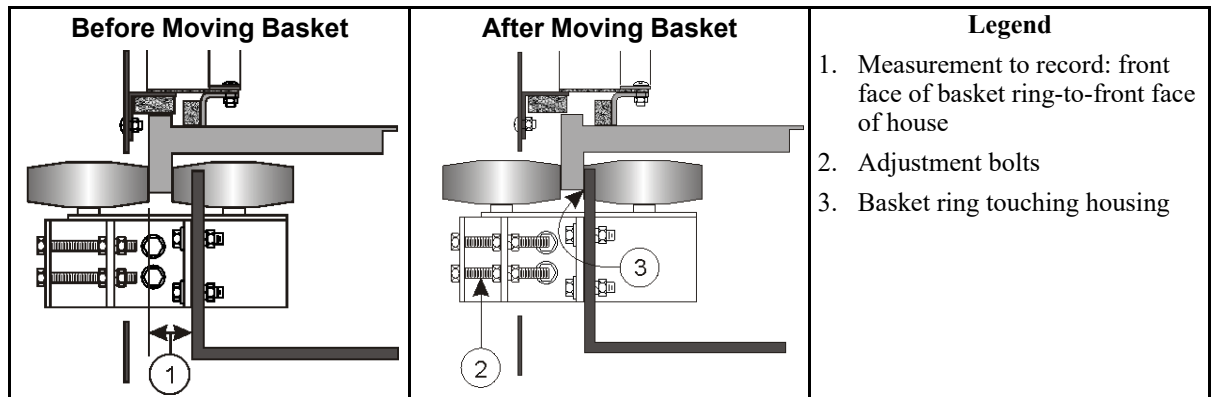


Figure 17. Seal installation tool—2" x 8" (5 x 20 cm) x 12 gauge steel plate, bent up on one end



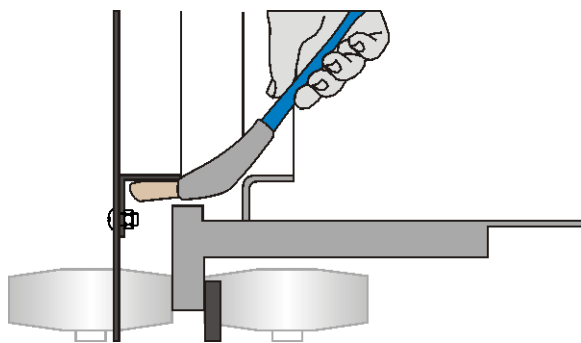
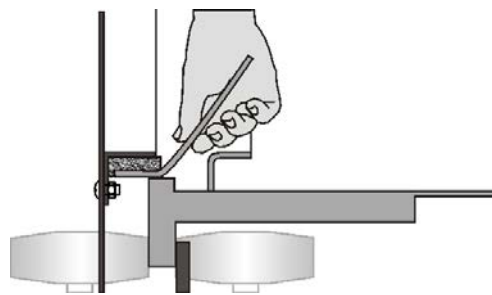
2. To provide more working room, widen the gap between the basket and shell front as follows:
 - a. Remove covers as needed to gain access to the guide roller assembly (Figure 14, page 45).
 - b. Measure and record the face of house-to-face of basket dimension (Figure 18, page 47, item 1). **When returning the dryer to operable condition, restore this dimension.**
 - c. Use the guide roller adjustment bolts (Figure 18, page 47, item 2) to move the basket rearward until it is **lightly** touching the house (Figure 18, page 47, item 3).

Figure 18. 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 15: Inspecting Seals, page 46).
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 16, page 47](#) and [Figure 19, page 48](#).
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 17, page 47](#) and [Figure 20, page 48](#).

Figure 19. Section View: Applying Adhesive**Figure 20. 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.**

2.4.3 How To Close a Front Seal Gap

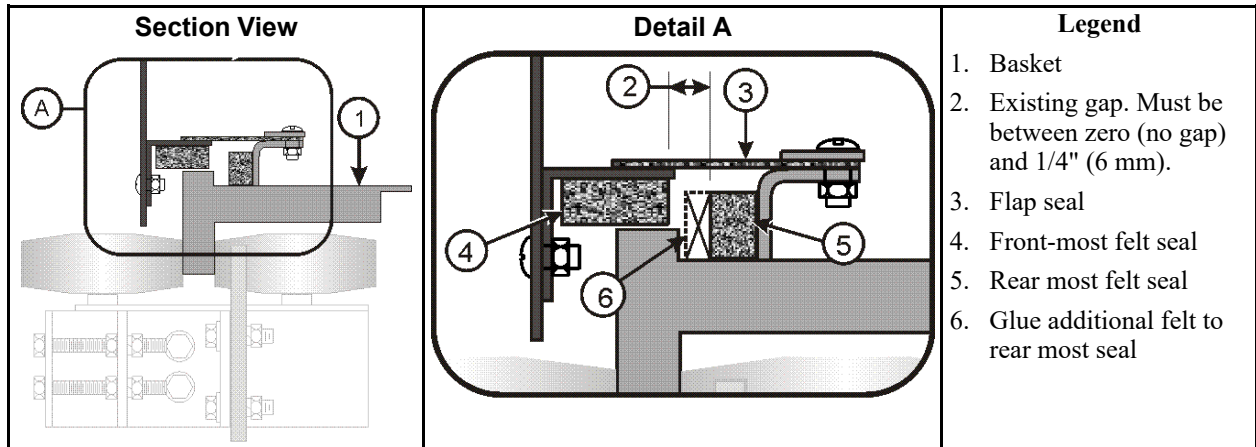
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This instruction applies to all Milnor® dryer models.

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 21: Adding Felt to Existing Seal, page 49](#). It is not necessary to replace the existing seals unless they are deteriorated.

Table 8. 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 21. 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 8: Materials Available from Milnor® for Closing Seal Gap, page 48](#)) to the rear most felt seal as follows:
 - a. Cut length to fit around the circumference of the basket.
 - b. Apply adhesive (see [Table 8, page 48](#)) 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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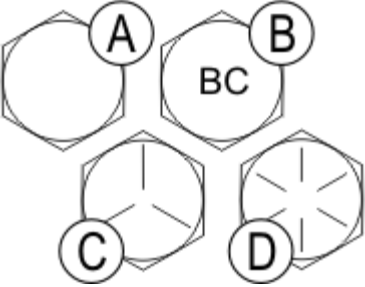
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2.5 Torque Requirements for Fasteners

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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 22. 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

2.5.1 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).

2.5.1.1 Fasteners Made of Carbon Steel

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2.5.1.1.1 Without a Threadlocker

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

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

Table 10. Torque Values for Standard Fasteners Larger Than 5/16-inch Diameters and No Lubricant

Dimension	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
	Pound-Feet	N-m	Pound-Feet	N-m	Pound-Feet	N-m	Pound-Feet	N-m
3/8 x 16	20	27	31	42	44	59	38	52
3/8 x 24	23	31	35	47	50	68	—	—
7/16 x 14	32	43	49	66	70	95	61	83
7/16 x 20	36	49	55	75	78	105	—	—
1/2 x 13	49	66	75	102	107	145	93	126
1/2 x 20	55	75	85	115	120	163	—	—

Table 10 Torque Values for Standard Fasteners Larger Than 5/16-inch Diameters and No Lubricant (cont'd.)

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
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 11. Torque Values for Plated Fasteners with Maximum 5/16-inch Diameters and No Lubricant

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

Table 12. Torque Values for Plated Fasteners Larger Than 5/16-inch Diameters and No Lubricant

Dimension	The Grade of the Bolt							
	Grade 2		Grade 5		Grade 8		Grade BC	
	Pound-Feet	N-m	Pound-Feet	N-m	Pound-Feet	N-m	Pound-Feet	N-m
3/8 x 16	15	20	23	31	33	44	29	38
3/8 x 24	17	23	26	35	37	49	—	—
7/16 x 14	24	32	37	50	52	71	46	61
7/16 x 20	27	36	41	55	58	78	—	—
1/2 x 13	37	49	56	76	80	106	70	93

Table 12 Torque Values for Plated Fasteners Larger Than 5/16-inch Diameters and No Lubricant (cont'd.)

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
1/2 x 20	41	55	64	85	90	120	—	—
9/16 x 12	53	70	81	110	115	153	101	134
9/16 x 18	59	79	91	122	128	174	—	—
5/8 x 11	73	97	113	150	159	212	139	186
5/8 x 18	83	110	127	172	180	240	—	—
3/4 x 10	129	173	200	266	282	376	246	329
3/4 x 16	144	192	223	297	315	420	—	—
7/8 x 9	125	166	322	430	455	606	398	531
7/8 x 14	138	184	355	474	501	668	—	—
1 x 8	188	250	483	644	682	909	597	796
1 x 12	205	274	528	716	746	995	—	—
1 x 14	210	280	542	735	765	1037	—	—
1 1/8 x 7	266	354	595	807	966	1288	845	1126
1 1/8 x 12	298	404	668	890	1083	1444	—	—
1 1/4 x 7	375	500	840	1120	1363	1817	1192	1590
1 1/4 x 12	415	553	930	1261	1509	2013	—	—
1 3/8 x 6	491	655	1102	1470	1787	2382	1564	2085
1 3/8 x 12	559	758	1254	1672	2034	2712	—	—
1 1/2 x 6	652	870	1462	1982	2371	3161	2075	2767
1 1/2 x 12	733	994	1645	2194	2668	3557	—	—

2.5.1.1.2 With a Threadlocker

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Table 13. 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 14. 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 15. 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 16. 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 17. 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	–	–

Table 17 Torque Values if You Apply LocTite 272 (High-Temperature) (cont'd.)

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
1-3/8 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 18. 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	—	—

2.5.1.2 Stainless Steel Fasteners

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Table 19. 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 20. 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

Table 20 Torque Values for Stainless Steel Fasteners Larger Than 5/16-inch (cont'd.)

Dimension	316 Stainless		18-8 Stainless		18-8 Stainless with Loctite 767	
	Pound-Feet	N-m	Pound-Feet	N-m	Pound-Feet	N-m
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

2.5.2 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.

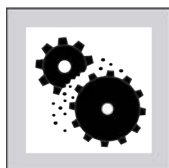


NOTE: LocTite 7649 Primer™ or standard solvents will remove grease from parts.

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.

2.5.3 How to Apply a Threadlocker

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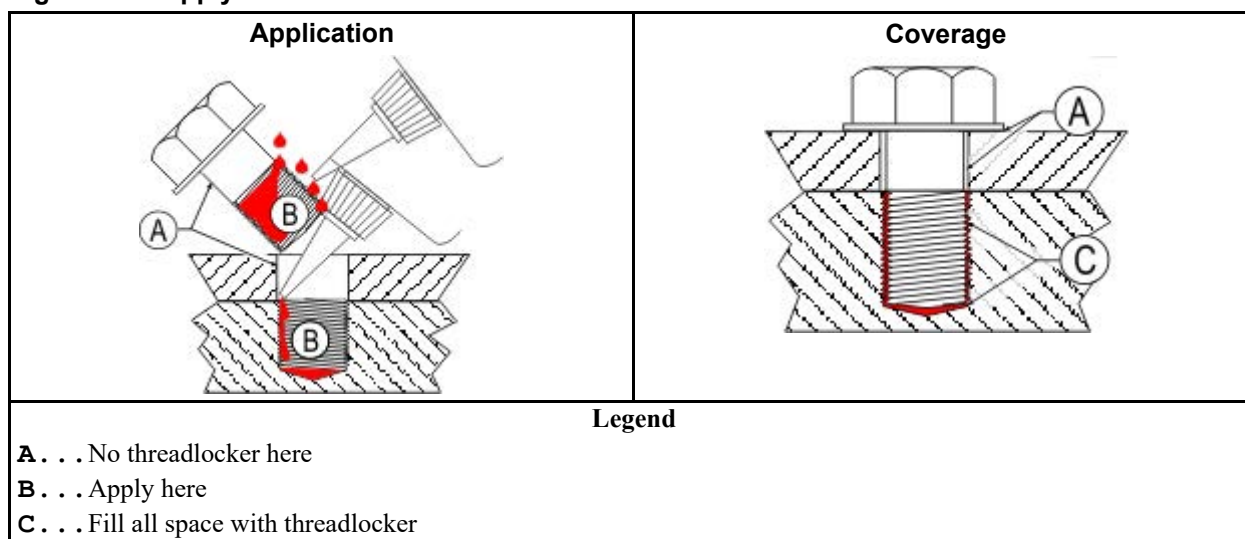


CAUTION: Malfunction Hazard — Heat, vibration, or mechanical shocks can let the fasteners loosen if you do not apply the threadlocker correctly. Loose fasteners can cause malfunctions of the equipment.

- ▶ 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 23. Apply Threadlocker in a Blind Hole



2.5.3.1 Blind Holes

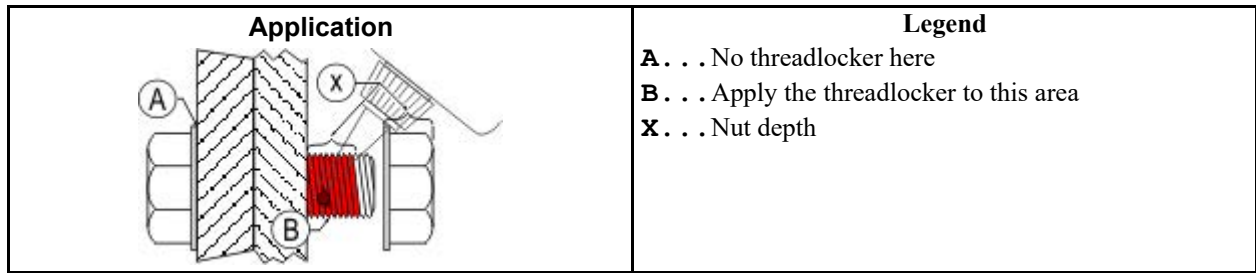
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1. Apply the threadlocker down the threads to the bottom of the hole.
2. Apply the threadlocker to the bolt.
3. Tighten the bolt to the value shown in the correct table ([Table 13: Threadlocker by the Diameter of the Bolt \(see below Note \), page 52](#) to [Table 19: Torque Values for Stainless Steel Fasteners 5/16-inch and Smaller, page 54](#)).

2.5.3.2 Through Holes

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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 13: Threadlocker by the Diameter of the Bolt \(see below Note \), page 52](#) to [Table 19: Torque Values for Stainless Steel Fasteners 5/16-inch and Smaller, page 54](#)).

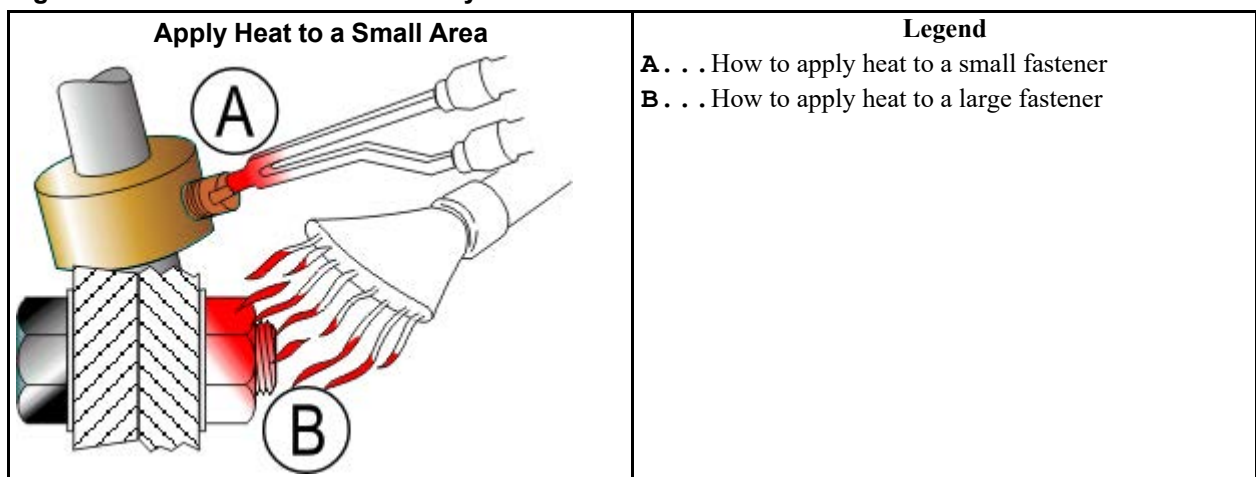
Figure 24. Apply Threadlocker in a Through Hole

2.5.3.3 Disassembly

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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 25. Use heat for disassembly of fasteners with threadlocker.

3 Covers and Shipping Brackets

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Lifting Brackets

2 Sheets

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

Figure 26. 5050, 6450, 6458, 6464, 7676, and 8282 Dryers (7676 Shown)

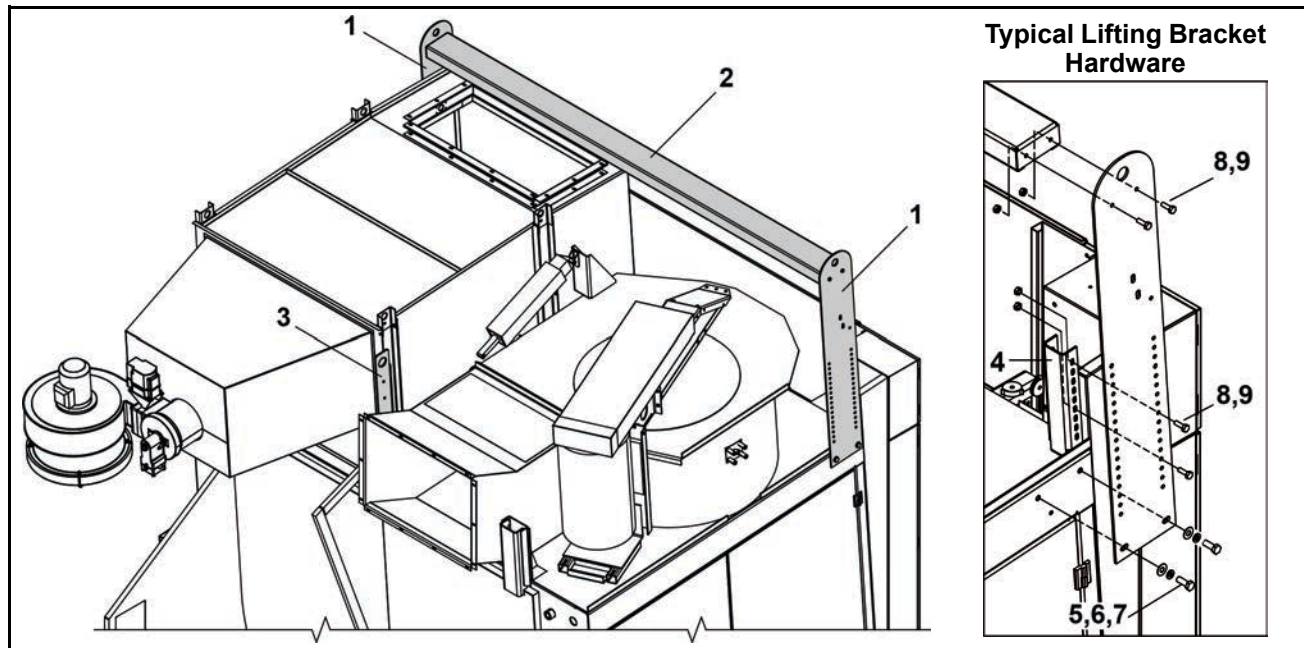
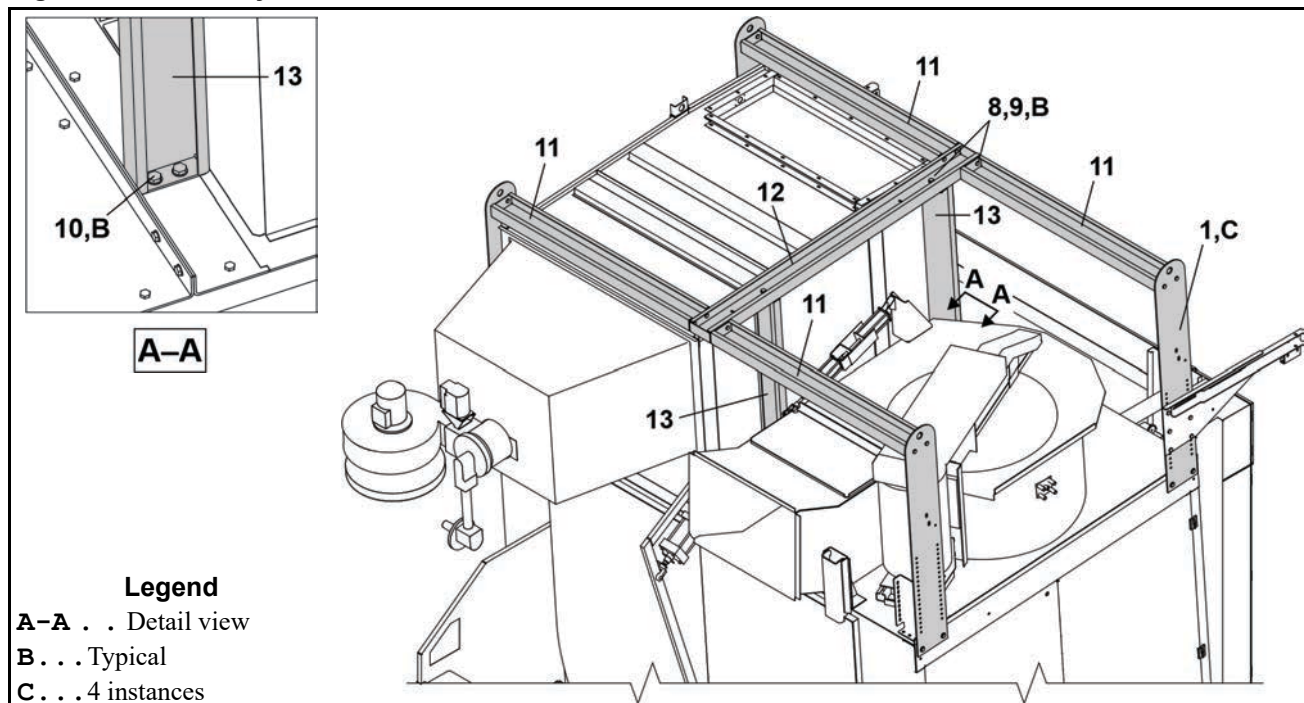


Figure 27. 8282 Dryers



Lifting Brackets

2 Sheets

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

Table 21. 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	

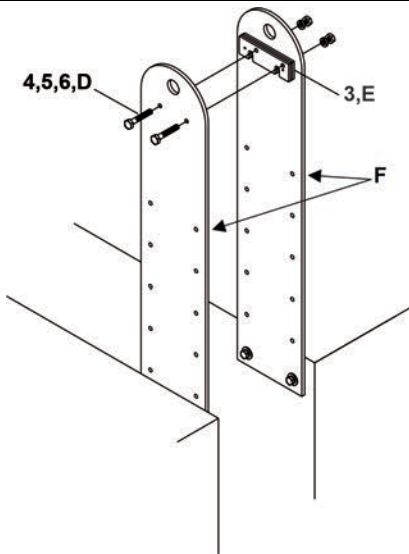
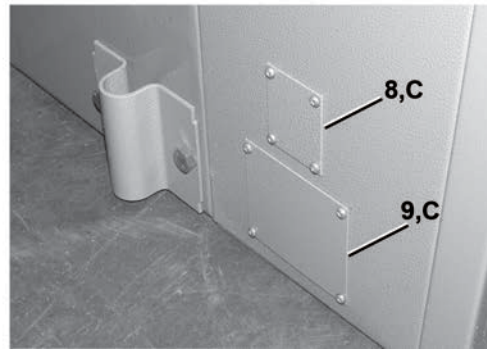
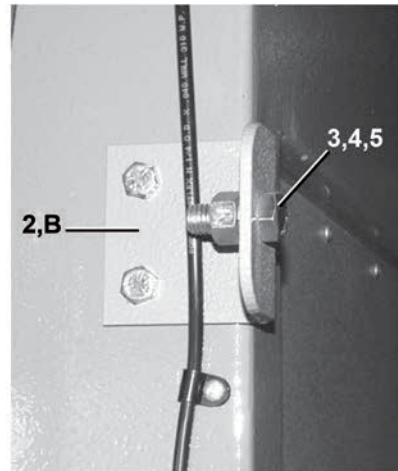
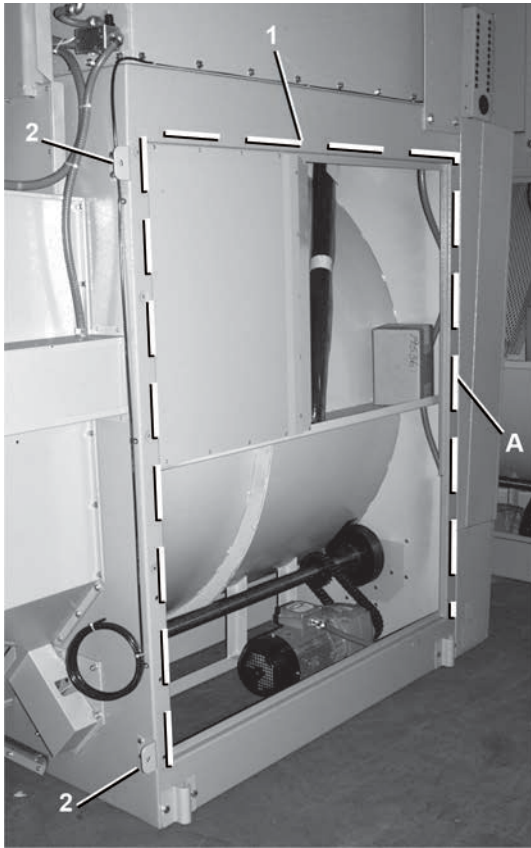
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Dryer to Dryer Mounting Parts

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 22. 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	

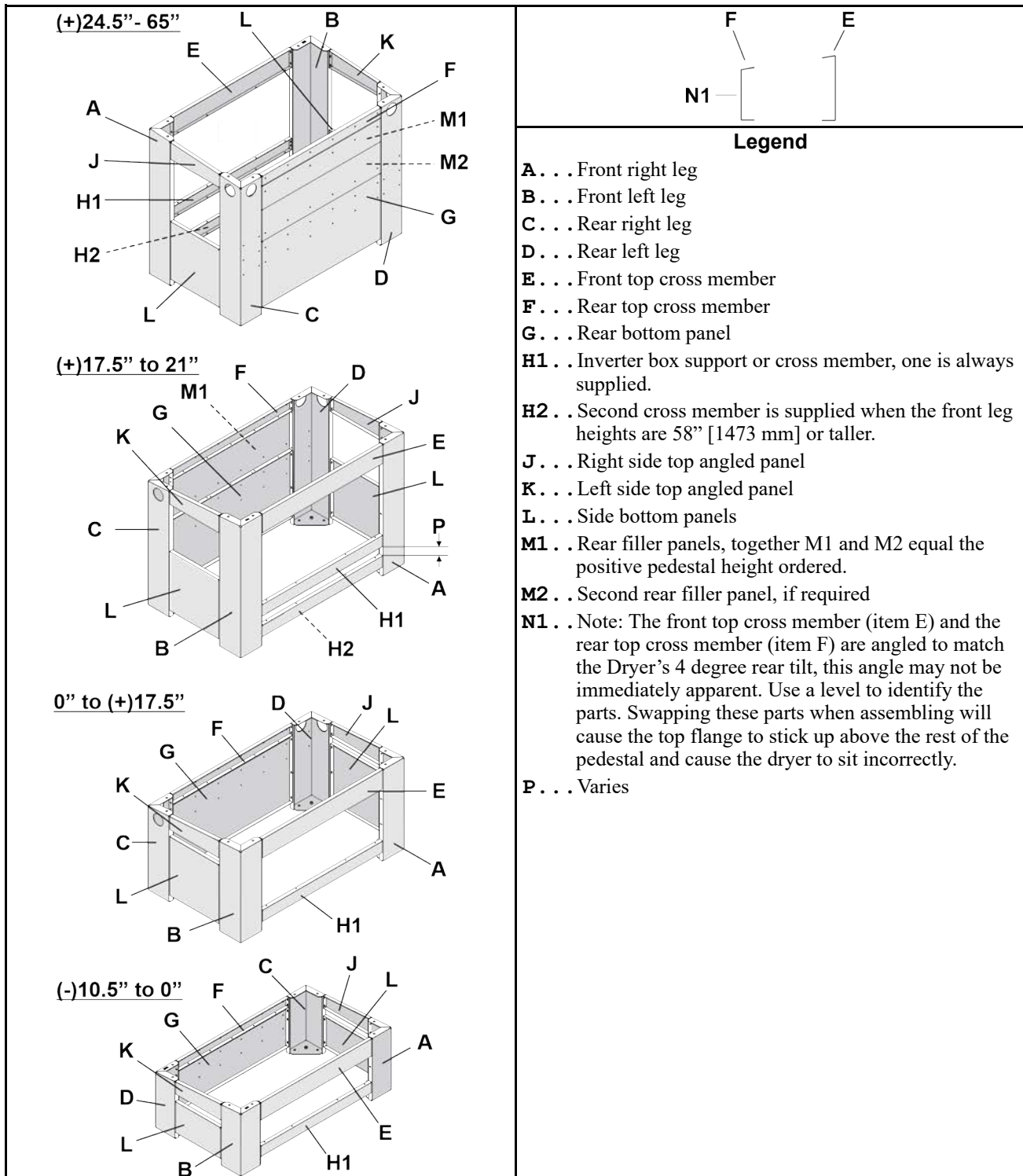
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Pedestal Base Installation

4 Sheet

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

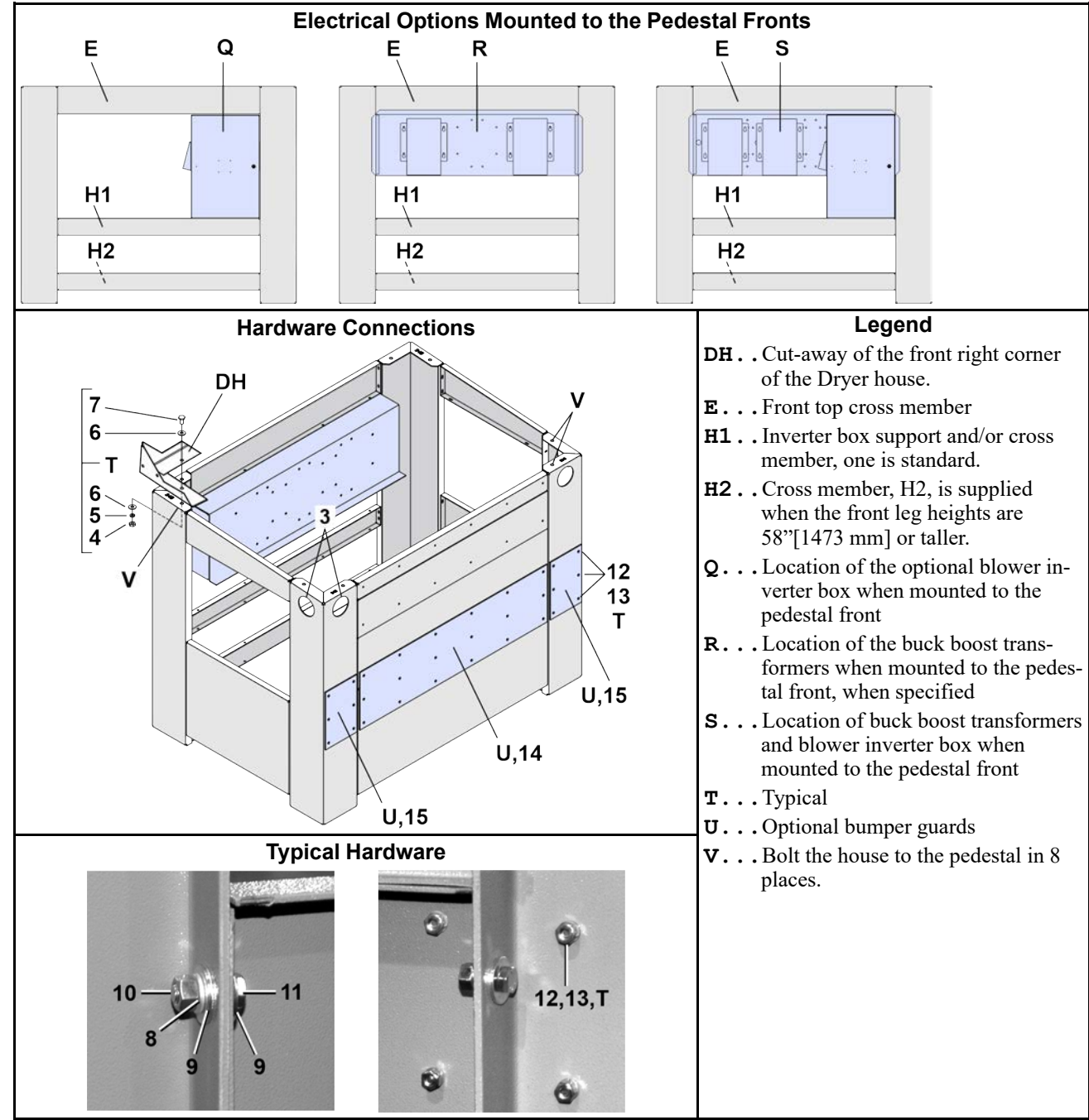
Figure 28. Placement of Components with Regard to Pedestal Height

Pedestal Base Installation

4 Sheet

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

Figure 29. Pedestal Options and Hardware Connections



Pedestal Base Installation

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

Figure 30. Anchoring

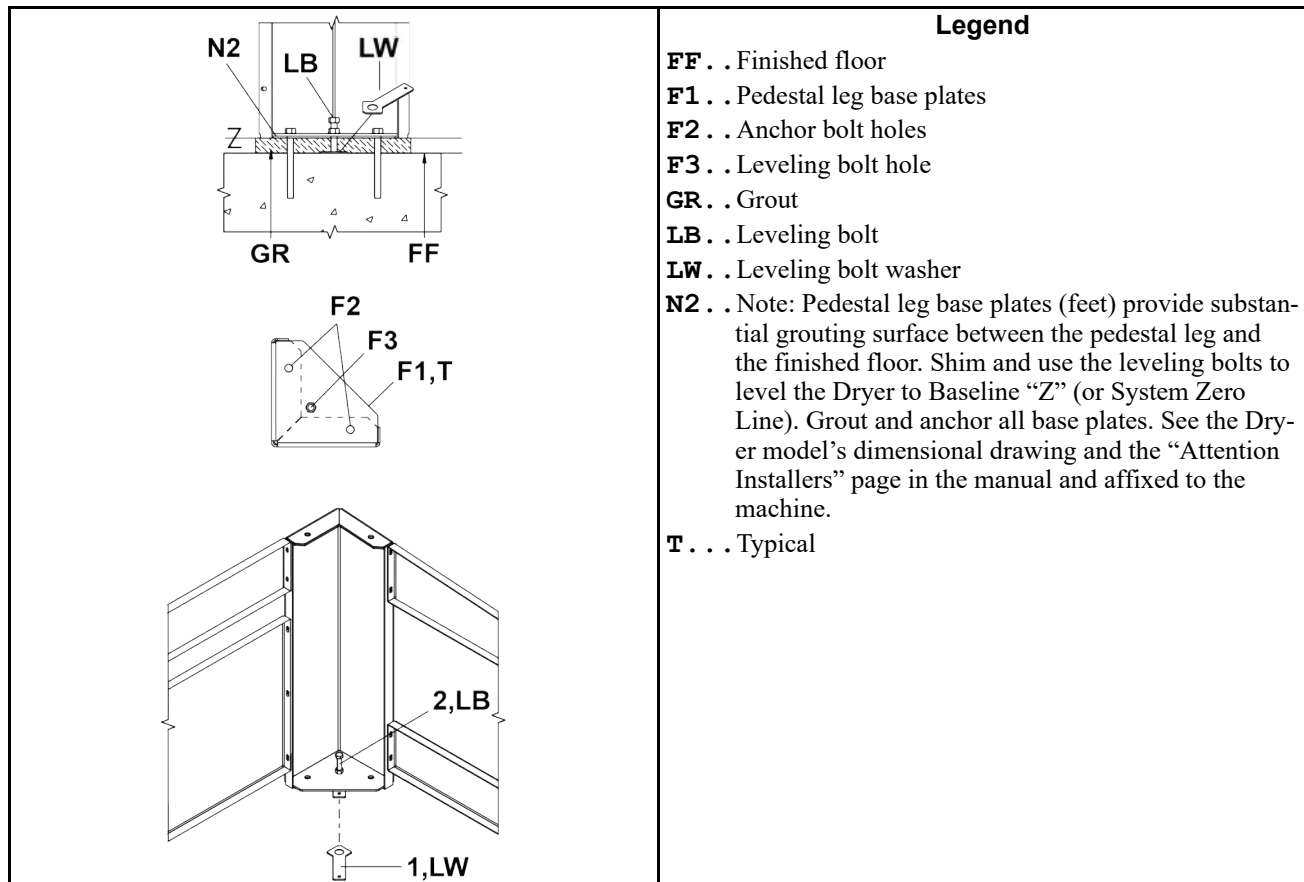


Table 23. Parts List—Pedestal Base Installation

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

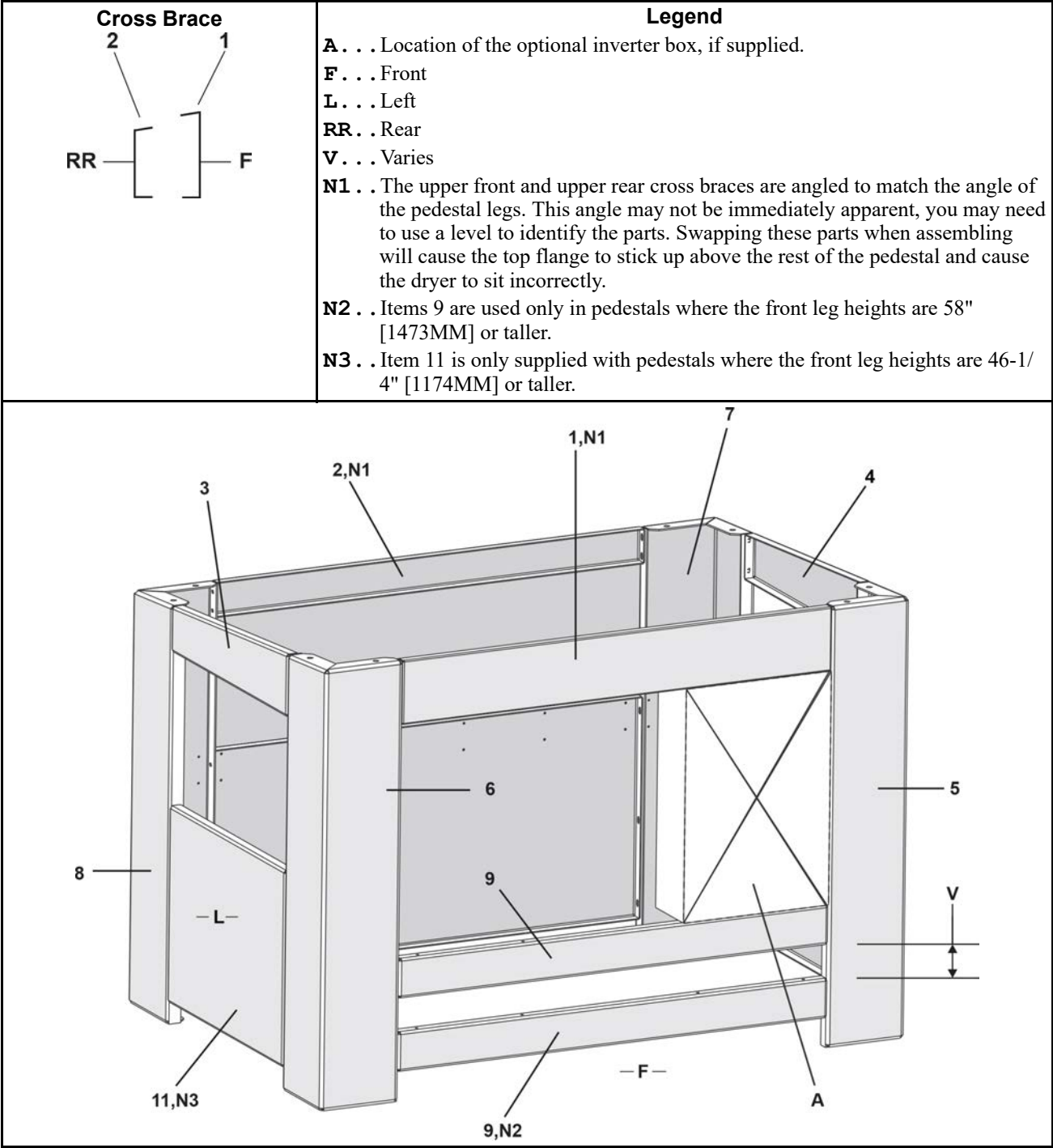
Table 23 Parts List—Pedestal Base Installation (cont'd.)

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	5050, 6450, 6458, 6464 Dryers 7676 Dryers
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	
	14	07 81403	7272 BUMPER PAD	
all	15	07 71404	6458 BUMPER PAD-16"WX10"LG	

Pedestal Base

6 Sheets

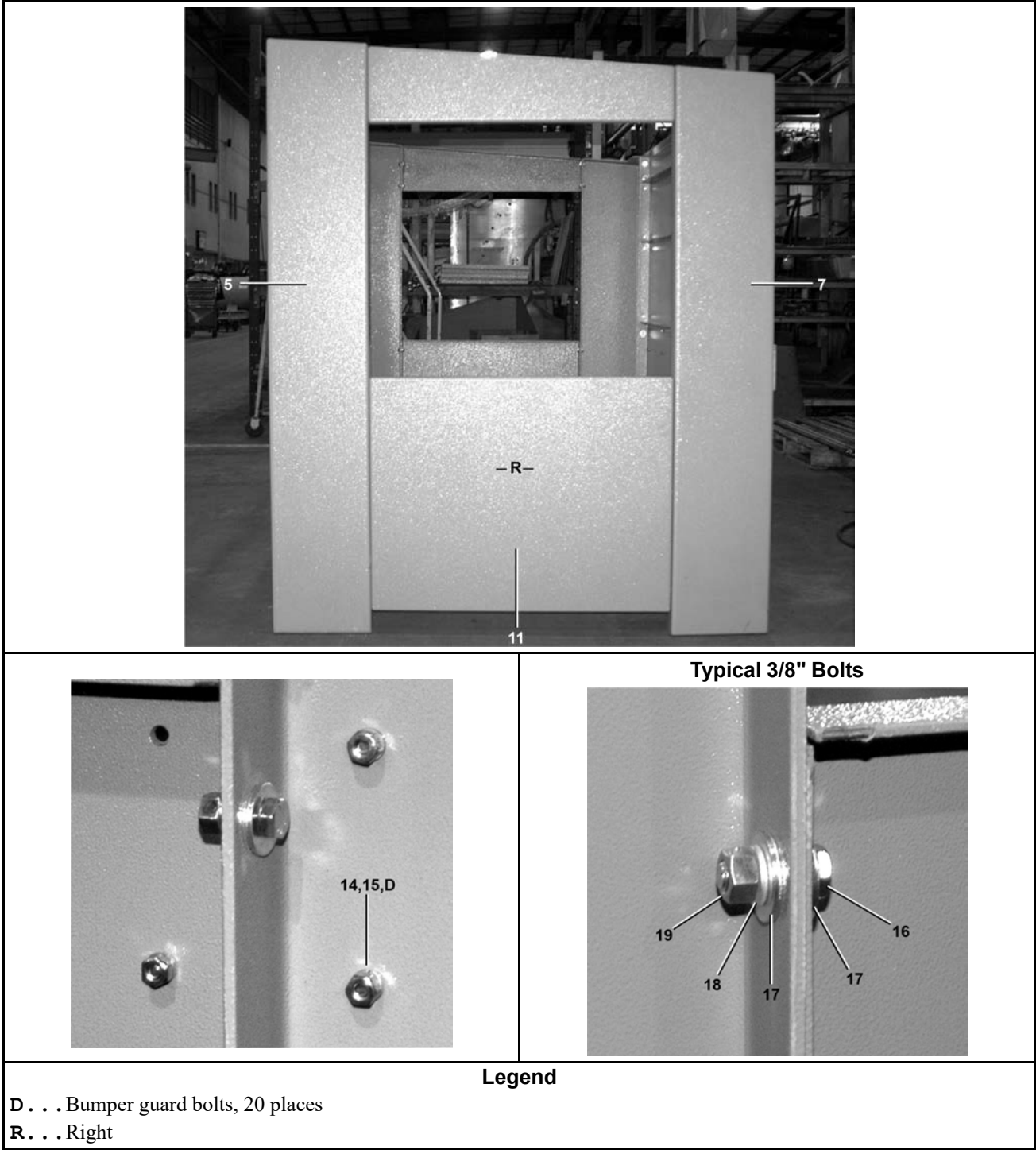
6458TG1L/R,TS1L/R 6464TG1L/R,TS1L/R



Pedestal Base

6 Sheets

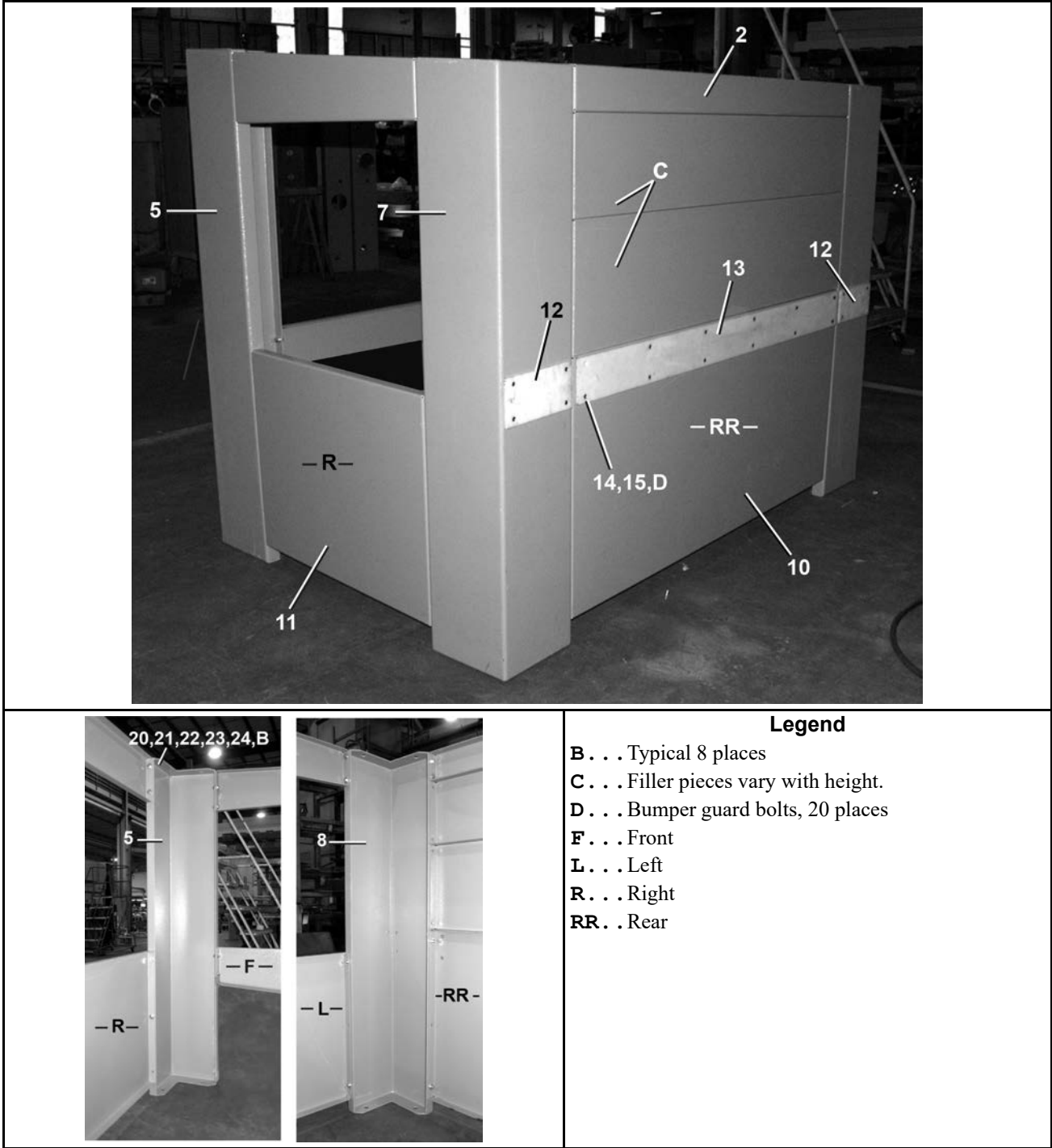
6458TG1L/R ,TS1L/R 6464TG1L/R ,TS1L/R



Pedestal Base

6 Sheets

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



Pedestal Base

6 Sheets

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

Table 24. Front Legs

Pedestal Order Height (inches)	Leg Length (inches)	Item 5 Part Number	Item 6 Part Number
0.0	40.968	07-71320	07-71320A
1.75	42.718	07-71322	07-71322A
3.5	44.468	07-71324	07-71324A
5.25	46.218	07-71326	07-71326A
7.0	47.968	07-71328	07-71328A
8.75	49.718	07-71330	07-71330A
10.5	51.468	07-71332	07-71332A
12.25	53.218	07-71334	07-71334A
14.0	54.968	07-71336	07-71336A
15.75	56.718	07-71338	07-71338A
17.5	58.468	07-71340	07-71340A
19.25	60.218	07-71342	07-71342A
21.0	61.968	07-71344	07-71344A
22.75	63.718	07-71346	07-71346A
24.5	65.468	07-71348	07-71348A
26.25	67.218	07-71350	07-71350A
28.0	68.968	07-71352	07-71352A
29.75	70.718	07-71354	07-71354A
33.25	74.218	07-71356	07-71356A
35.00	75.968	07-71358	07-71358A
36.75	77.718	07-71360	07-71360A
38.50	79.468	07-71362	07-71362A
31.50	72.468	07-71300	07-71300A
-3.5	34	07-71389B	07-71389C
-7	30.5	07-71389	07-71389A

Pedestal Base

6 Sheets

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

Table 25. Rear Legs

Pedestal Order Height (inches)	Leg Length (inches)	Item 7 Part Number	Item 8 Part Number
0.0	37.8	07-71321	07-71321A
1.75	39.55	07-71323	07-71323A
3.5	41.3	07-71325	07-71325A
5.25	43.05	07-71327	07-71327A
7.0	44.8	07-71329	07-71329A
8.75	46.55	07-71331	07-71331A
10.5	48.3	07-71333	07-71333A
12.25	50.05	07-71335	07-71335A
14.0	51.8	07-71337	07-71337A
15.75	53.55	07-71339	07-71339A
17.5	55.3	07-71341	07-71341A
19.25	57.05	07-71343	07-71343A
21.0	58.8	07-71345	07-71345A
22.75	60.55	07-71347	07-71347A
24.5	62.3	07-71349	07-71349A
26.25	64.05	07-71351	07-71351A
28.0	65.8	07-71353	07-71353A
29.75	67.55	07-71355	07-71355A
33.25	71.05	07-71357	07-71357A
35.00	72.80	07-71359	07-71359A
36.75	74.55	07-71361	07-71361A
38.50	76.30	07-71363	07-71363A
31.50	69.300	07-71301	07-71301A
-3.5	30.8	07-71390B	07-71390C
-7	27.3	07-71390	07-71390A

Pedestal Base

6 Sheets

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

Table 26. Parts List—Pedestal Base

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	07 71391	6458 DRYER BASE FILLER TOP FT	
all	2	07 71392	6458 DRYER BASE FILLER TOP RR	
all	3	07 71395	6458 DRYER BASE FILL DRV RITE	6458 DRYERS
all	3	07 72041	6464 DRYER BASE FILL DRV RIGHT	6464 DRYERS
all	4	07 71395A	6458 DRYER BASE FILL DRV LEFT	6458 DRYERS
all	4	07 72041A	6464 DRYER BASE FILL DRV LEFT	6464 DRYERS
all	5	07 71300	6458/64 = 31.5" PED FRONT RIGHT	
all	6	07 71300A	6458/64=31.5" PED FRONT LEFT	
all	7	07 71301	64" DRYER=31.5" PED REAR RIGHT	
all	8	07 71301A	64" DRYER=31.5" PED REAR LEFT	
all	9	07 71418	6458 DRYER FILLER INVERTER BOX	(2) USED FOR 17.5" PEDESTALS & HIGHER
all	10	07 71402	6458 DRYER BASE FILLER-REAR	
all	11	07 71396	6458 DRYER BASE FILL DRV LOW	6458 DRYERS
all	11	07 72042	6464 DRYER BASE FILL DRV LOW	6464 DRYERS
all	12	07 71404	6458 BUMPER PAD-16"WX10"LG	
all	13	07 71403	6458 BUMPER PAD-16"WX60"LG	
all	14	15G164NE	HEXLOKNUT NYL 1/4-20 UNC2A SS.	
all	15	15N176	FLATMACSCR 1/4-20NCX3/4SS18-8	
all	16	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	17	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	18	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	19	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	20	15K162	HXCAPSCR 1/2-13UNC2AX1.5 GR5 P	
all	21	15U490	FLTWASH 1+1/2X17/32X1/4 ZINC	
all	22	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	23	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	24	15U280	FL+WASHER(USS STD)1/2 ZNC PL+D	

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Guards and Covers

4 Sheets

6450, 6458, 6464, 7676, 8282 Dryers

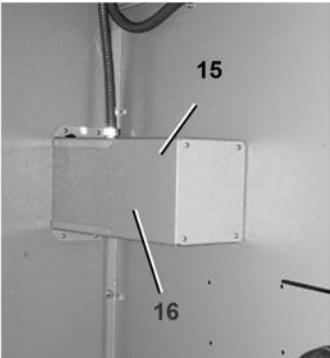
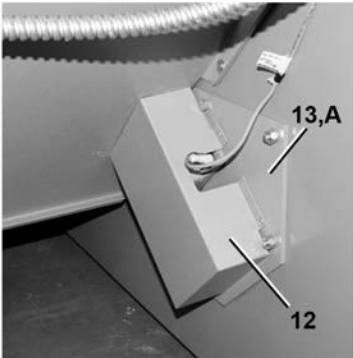
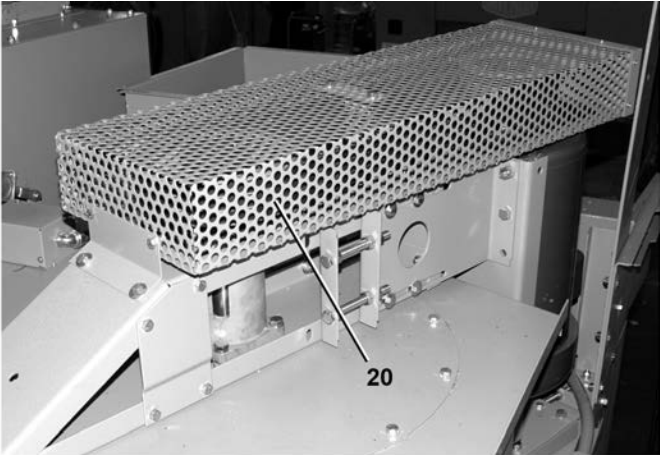


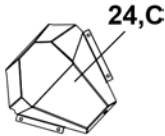
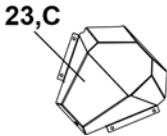
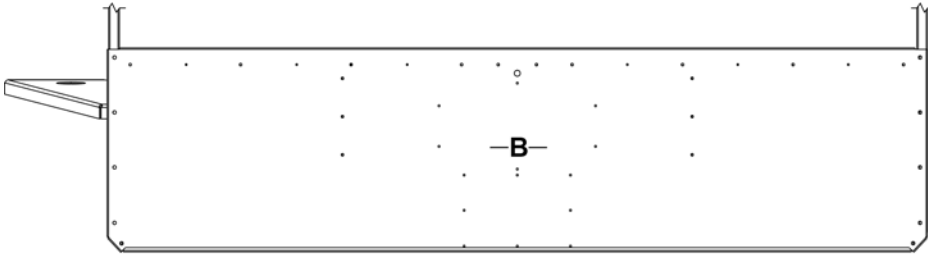
NOTE: Dryer side panels are only supplied on Stand-Alone Dryers and used on the side opposite the blower.

Guards and Covers

6450, 6458, 6464, 7676, 8282 Dryers

4 Sheets





Legend

A . . . Standard shroud bearing cover

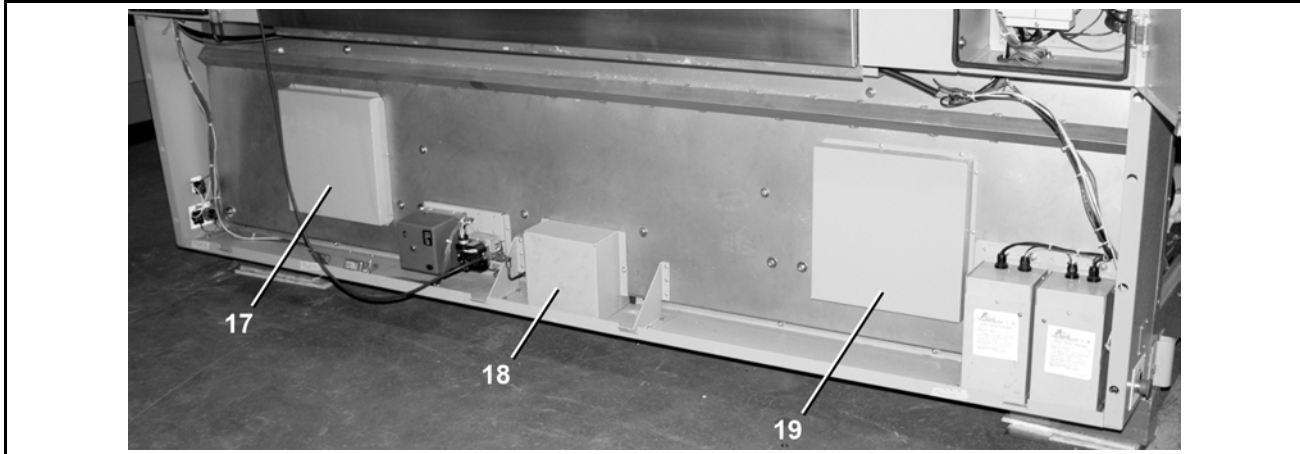
B . . . Short shroud

C . . . Short shroud bearing

Guards and Covers

6450, 6458, 6464, 7676, 8282 Dryers

4 Sheets


Table 27. Parts List—Guards and Covers

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			6450 Dryers
	B			6458 Dryers
	C			6464 Dryers
	E			7676 Dryers
	F			8282 Dryers
Components				
B	3	A77SC001	6458 LOWER SIDE COVER ASSY	
C	3	A77SC010	6464 LOWER SIDE COVER ASSY	
E	3	A79SC001	7272 LOW CVR BLOWER SIDE	
B	4	07 71397	6458 HOUSE SIDE PLATE UPPER	
AC	4	07 72029	6464 HOUSE SIDE PLATE UPPER	
E	4	07 85397	7676 HOUSE SIDE PLATE	
F	4	07 88073	8282 HOUSE SIDE PANEL	
B	5	07 71435	6458 LINT SIDE LOWER COVER	
AC	5	07 72028	6464 LOWER SIDE COVER	
E	5	07 85397	7676 HOUSE SIDE PLATE	
F	5	07 88073	8282 HOUSE PANEL	
ABC	6	W7 71205A	64" DRYER FRONT COSMETIC LOWER DOOR WELD	
E	6	W7 85205	7676 FRONT COSMETIC LOWER DOOR HINGED WLMT	
F	6	W7 88102	8282 FRONT COSMETIC LOWER DOOR HINGED WLMT	
all	7	W3 D1356L	WELD:DOOR 6458TG1 DRYER LF LV	

Guards and Covers

4 Sheets

6450, 6458, 6464, 7676, 8282 Dryers

Table 27 Parts List—Guards and Covers (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
A	8	07 71201A	6464 FRONT COSM UPPER	
BC	8	07 71201W	6458 FRONT COSM UPPER	
E	8	07 85201	7676 COSMETIC UPPER MID COVER	
F	8	W7 88111	8282 FRONT COSMETIC UPPER MID COVER WLMT	
all	9	03 D1356R	DOOR: 6458TG1L DRYER HV	
ABC	10	07 71204W	6458 COSM LOWER THRESHOLD	
EF	10	07 81204	7272 FRONT COS THRESHOLD	
all	11	07 50428	SPRINKLER VALVE COVER DRYER	
ABC	12	07 71317	6458 REAR BEARING COVER	STANDARD SHROUD
E	12	07 81317	64,72,76" DRYER REAR BEARING COVER	STANDARD SHROUD
F	12	07 88125	8282 REAR BEARING COVER	STANDARD SHROUD
all	13	07 81280	64-76" DRYER SUPPORT BEAR MTG PLT	
all	15	07 71306	6458 TEMP PROBE BOX	
all	16	07 71307	6458 TEMP PROBE BOX COVER	
ABCE	17	07 71231	COVER BRG NO HOLE LF END	
F	17	07 88110	8282 FRONT BEARING COVER	
ABCE	18	W7 50129	64" DRYER GUIDE ROLLER COVER	
F	18	07 88117	8282 GUIDE ROLLER COVER	
all	19	07 71231A	COVER BRG NO HOLE RT END	
A	20	A7 50268C	6450 LF BLWR BELT GUARD ASMBLY - ANGLED	LEFT
A	20	A7 50268CA	5050 LF BLOWER BELT GUARD- ANGLED ASMBLY	RIGHT
BC	20	A77BA002	64" DRYER BLOWER BELT GUARD ASSY	
EF	20	A79BA002	72/76/82" DRYER BLOWER BELT GUARD ASSY	
all	21	27A108A	HINGE LIFTOFF LH EMKA#1056-U62 BLACK	
all	22	27A108B	HINGE LIFTOFF RH EMKA#1056-U63 BLACK	
E	23	W7 71317B	50-76" DRYER BRNG CVR SHORT-LEFT	SHORT SHROUD
F	23	A82BC001	8282 BRNG COVER SHORT ASSEMBLY	SHORT SHROUD
E	24	W7 71317D	50-76" DRYER BRNG CVR SHORT-RIGHT	SHORT SHROUD
F	24	A82BC001	8282 BRNG COVER SHORT ASSEMBLY	SHORT SHROUD
all	25	60A114	SELF-GRIP GASKET EMKA 1011-17	

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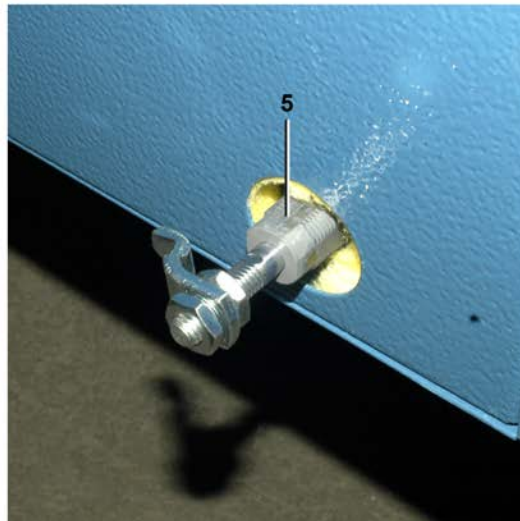
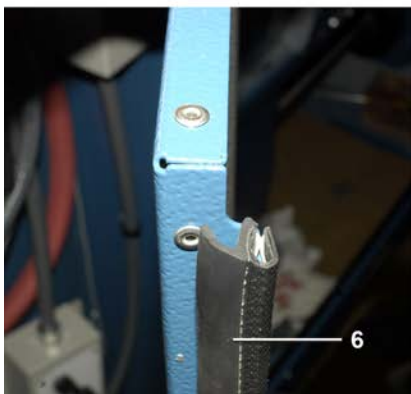
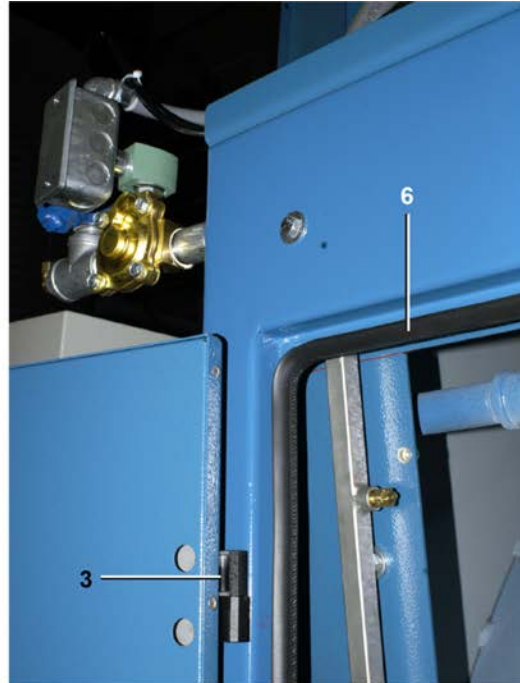
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Side Doors

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 28. 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	WISE-ACT.DBBIT.LATCH#E3-12-27	
all	6	60A114	SELF-GRIP GASKET EMKA 1011-17	

Unload Shrouds

3 Sheets

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

6458TG1L/R, TS1L/R; 6464TG1L/R, TS1L/R A B	7676TG1L/R; 8282TG1L/R A B
11	Legend A . . . Standard shroud B . . . Short shroud D . . . Typical hardware all shrouds

Unload Shrouds

3 Sheets

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

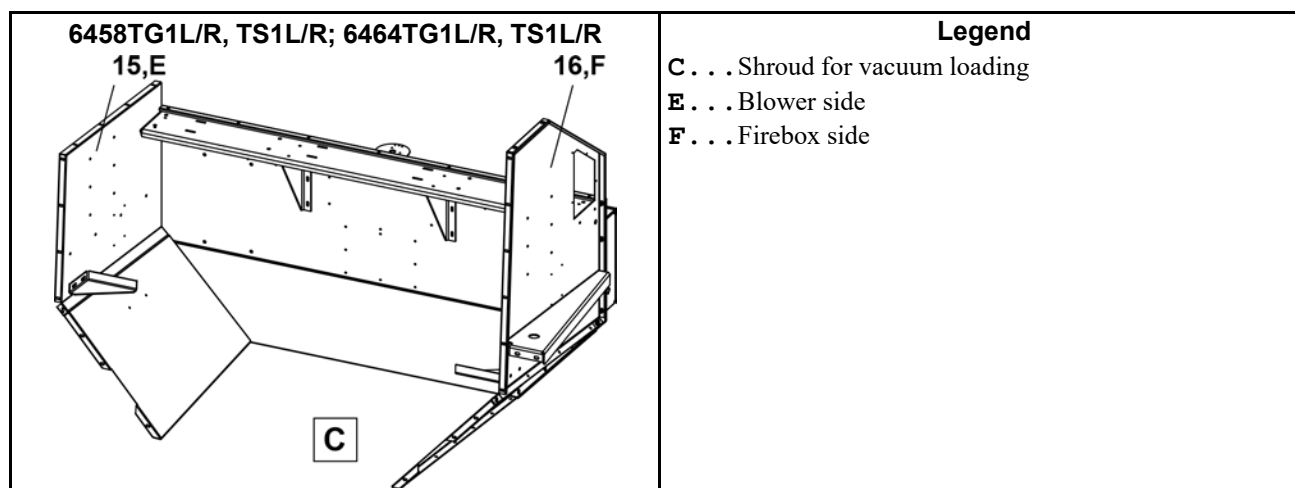


Table 29. Parts List—Unload Shrouds

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			6458/6464 STANDARD SHROUD
	B			7676 STANDARD SHROUD
	C			6458/6464 SHORT SHROUD
	D			7676 SHORT SHROUD
	E			8282 STANDARD SHROUD
	F			8282 SHORT SHROUD
	G			6458/6464 VACUUM LOADING SHROUD
Components				
A	1	07 71150A	6458 UNLOAD SHROUD RIGHT	
B	1	07 71505C	64" DRYER SHROUD SHORT CHAMFER - RT	
C	1	07 85150	7676 UNLOAD SHROUD RIGHT	
D	1	07 81505	7272 UNLOAD SHROUD RT SHORT	
EF	1	07 88123	8282 SHROUD SHORT CHAMFER-RT	
A	2	07 71150B	6458 UNLOAD SHROUD LEFT	
B	2	07 71505D	64" DRYER SHROUD SHORT CHAMFER-LF	
C	2	07 85151	7676 UNLOAD SHROUD LEFT	
D	2	07 81505A	7272 UNLOAD SHROUD LF SHORT	

Unload Shrouds

3 Sheets

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

Table 29 Parts List—Unload Shrouds (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
EF	2	07 88123A	8282 SHROUD SHORT CHAMFER-LT	
A	3	07 71152	6458 UNLOAD SHROUD BACK PLT	
B	3	07 71506	6458 UNLOAD SHROUD BACK =SHT	
C	3	07 85152	7676 UNLOAD SHROUD BACK PLT	
D	3	07 85152A	7676 UNLD SHROUD BACK-SHORT	
EF	3	07 88121	8282 UNLOAD SHROUD EXTENSION BACK	
AB	4	07 71154	64"DRYER GAS PIPE SUPP PLT	
CD	4	07 85154	7676 SHROUD GAS PIPE SUPPORT PLATE	
EF	4	07 88122	8282 GAS PIPE SUPP PLT	
all	5	07 71156	6458 PIPE SUPP GUSSET BKT	
AB	E6	W7 71507	6458 SHORT SHROUD GUSSET LFT	
CD	6	W7 81507	7272 SHORT SHROUD GUSSET LF	
EF	6F	07 88126	8282 SHORT SHROUD GUSSET	
all	7	15K037	HEXCAPSCR 1/4-20UNC2AX5/8 GR5	
all	8	15U180	LOCKWASHER MEDIUM 1/4 ZINCPL	
all	9	15U185	FLATWASHER(USS STD) 1/4" ZNC P	
all	10	15G165	HXNUT 1/4-20UNC2BSAE ZC GR2	
all	11	09H026V37	BEACON ROTARY 90MM AMBER CE	
E	12	07 88120	8282 UNLOAD SHROUD EXTENSION RIGHT	
E	13	07 88120A	8282 UNLOAD SHROUD EXTENSION LEFT	
EF	14	07 88124	8282 UNLOAD SHROUD BACK PLT	
G	15	07 71505E	6458 RT VAC LOADING SHROUD BLOWER SIDE	
G	16	07 71505H	6458 RT VAC LOADING SHROUD FB SIDE	

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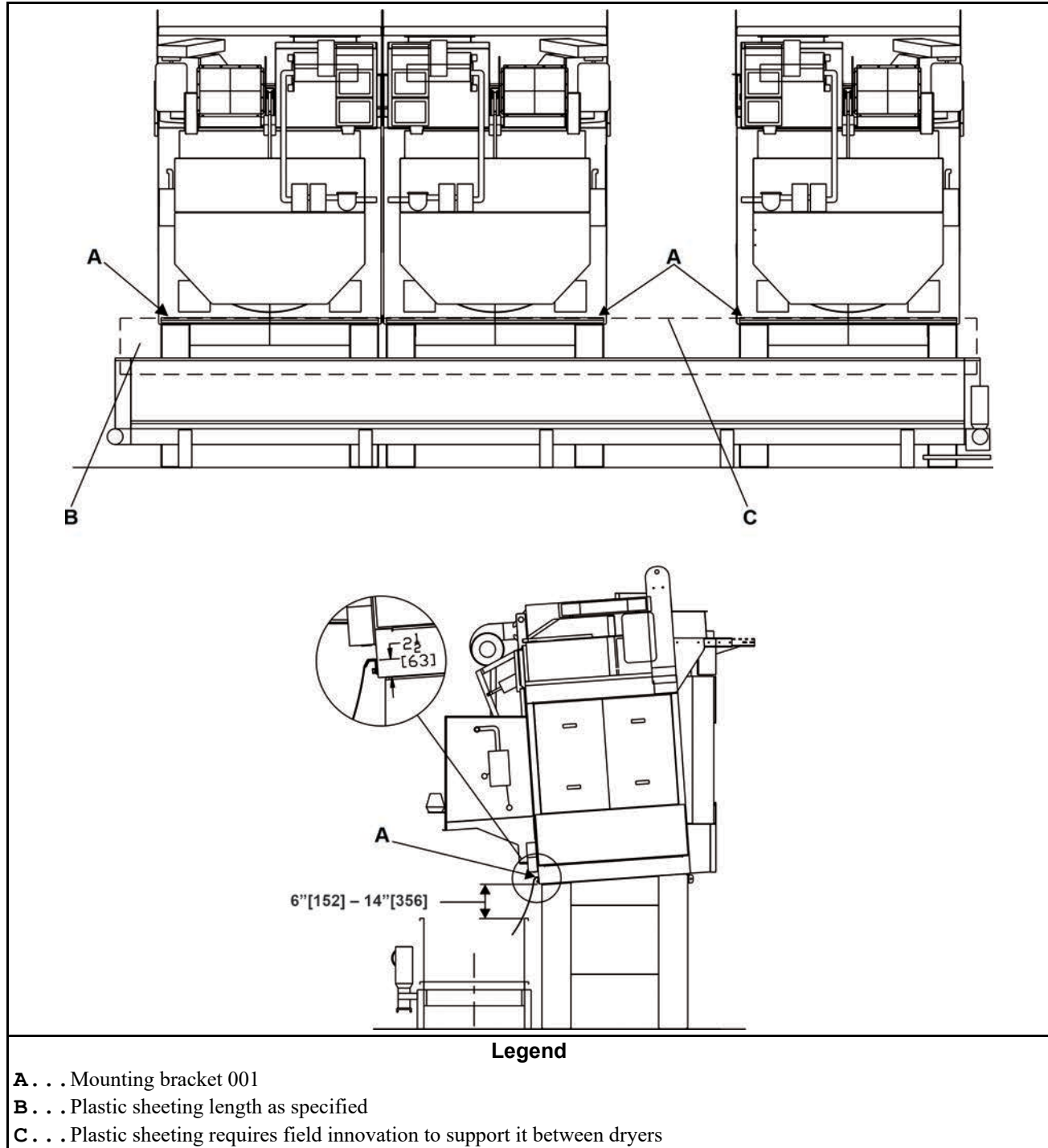
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Unload Bridge Installation

2 Sheets

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



Unload Bridge Installation

2 Sheets

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

Table 30. 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

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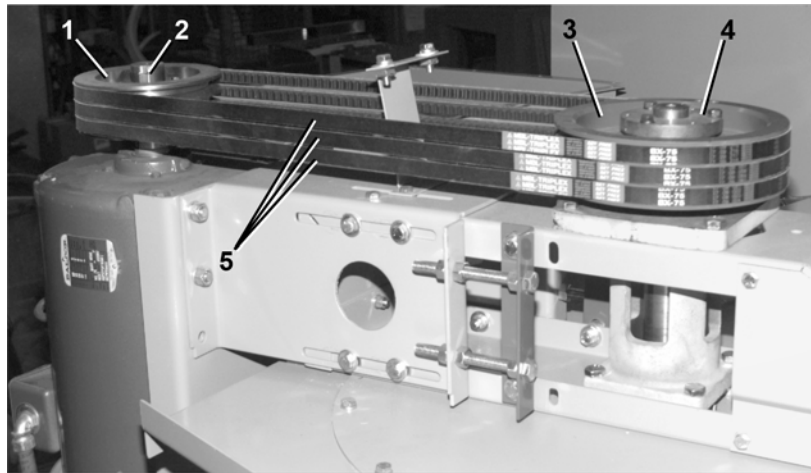
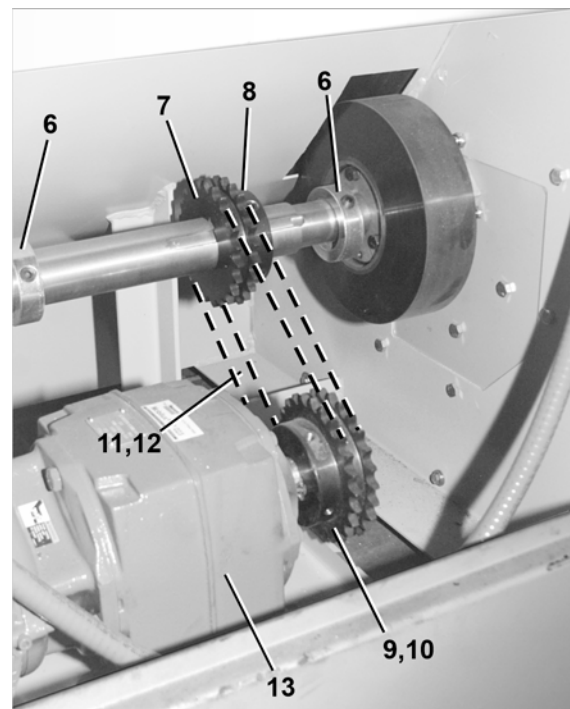
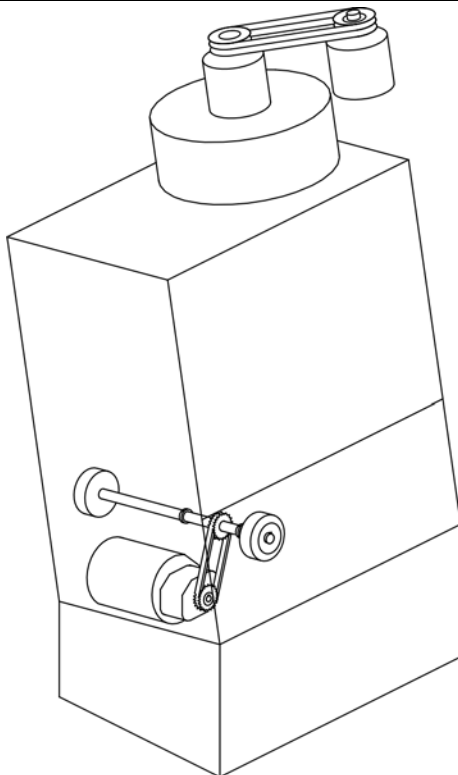
Drive Chart

3 Sheets

6450, 6458, 6464 Dryers



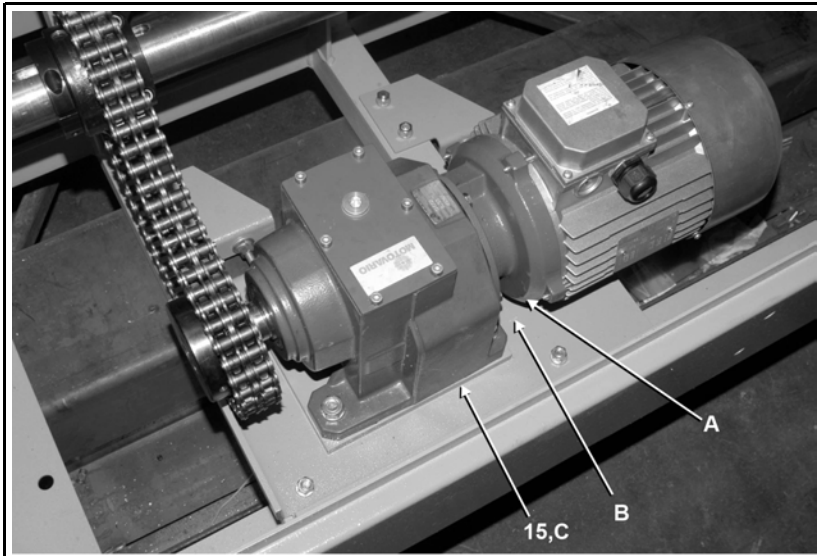
NOTE: Effective 1/10/08 the cylinder drive gear reducer and sprocket were changed on all 6458 Dryers as reflected on this drawing's parts list. The new gear reducer (item 13) is usable to repair all 6458 Dryers. For Dryers produced before 1/10/08, the new drive sprocket and bushing (items 9 & 10) must also be ordered.

Blower Drive**Cylinder Drive**

Drive Chart

6450, 6458, 6464 Dryers

3 Sheets



Legend

- A . . . Motor Mounting Flange
- B . . . Base
- C . . . Spacer (item 15) must be installed to provide sufficient clearance between the motor mounting flange and base.
- D . . . Use the Sprocket Alignment gage (item 14), shipped with the machine, to align the drive and driven sprockets.

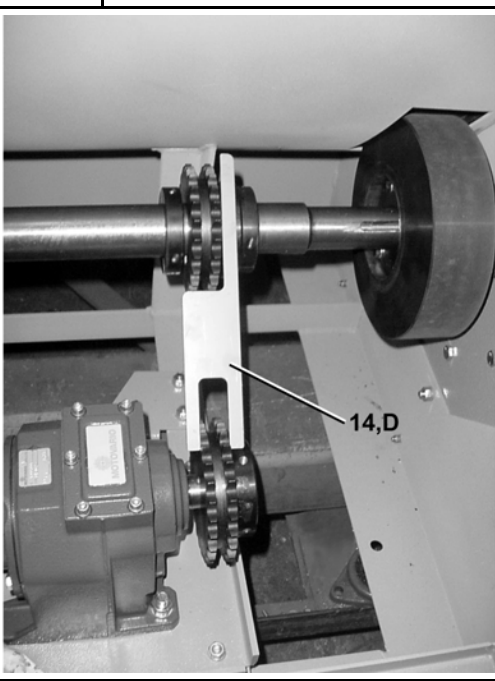
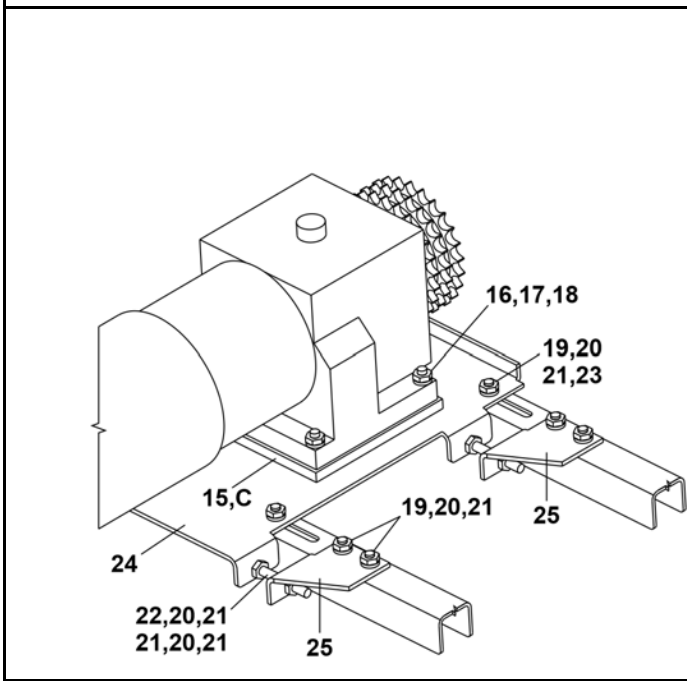


Table 31. Parts List—Drive Chart

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	D77 00350	DRIVE CHART 6450DRYER 50 CYC	6450 50 CYC
	B	D77 00360	DRIVE CHART 6450DRYER 60 CYC	6450 60 CYC

Drive Chart

6450, 6458, 6464 Dryers

3 Sheets

Table 31 Parts List—Drive Chart (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
	C	D77 00250	DRIVE CHART 6458DRYER 50 CYC	6458, 6464, 50 CYC
	D	D77 00260	DRIVE CHART 6458DRYER 60 CYC	6458, 6464, 60 CYC
Components				
A	1	56062B3SD	VPUL 3B6.2/A5.8 (SD) TYPE QD	3 REQUIRED
B	1	56048B3SD	VPUL 3B4.8 (SD) TYPE QD	
C	1	56080B3SK	VPUL 3B8.0/A7.6 (SK) TYPE QD	
D	1	56066B3SD	VPUL 3B6.6/A6.2 (SD) TYPE QD	3 REQUIRED
all	2	56Q1MSD	1+5/8" BUSH QD TYPE SD=MUST HAVE KEY	
all	3	56086B3SK	VPUL 3B8.6/A8.2 (SK) TYPE QD	
all	4	56Q1GSK	1+3/8" BUSH VPUL QD TYPE SK	3 REQUIRED
AC	5	56VB078X	VBELT BX78 RAWEDGE COG	
B	5	56VB073XM2	VBELT BX73 EA=1BELT	
D	5	56VB075XM3	VBELT BX75 EA=1BELT	3 REQUIRED
all	6	54JH22000C	SHFTCOLL 2"ID DBLSPLT CARSTL	
all	7	54N060B21A	SPRKT D60BTB21H 1+15/16TPRBORE (WT=4LBS)	
all	8	56Q1TB1	1+15/16 BUSH, MARTIN #2517 1+15/16	REPLACEMENT CHAIN FOR ALL 6450, 6458, 6464
all	9	54N060B25	SPRKT D60BTB25H-TPRLK (2517) (WT.=8 LBS)	
all	10	56Q1ETB	1+1/4" TAPRLOCKBUSH (2517)	
all	11	54G060SP3F	SOLID BUSH CHN 60-2DBL 39"LG 52 PITCHES	
all	12	20H011CG	GADUS S2 HIGH SPEED #550027655 EA=1 TUBE	
all	13	39F1923BN	3HP GEARMTR 230+3P60 CH052	
all	14	07 71752	SPROCKET ALIGNMENT GAGE-6458	
all	15	07 71464	6458 GEAR REDUCER SPACER	
all	16	15K191	HXCAPSCR 1/2-13UNC2AX2.5 GR5 Z	
all	17	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	18	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	19	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	20	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	21	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	22	15B110	HXTAPBOLT 3/8-16UNC2X5 FULTHD	
all	23	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	24	07 71165A	64" DRYER RT GEAR MTR SUPP PLATE	
all	25	07 71166A	50&64" DRYER RT MTR MNT ADJ BOLT BKT	

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Cylinder Installation

3 Sheets

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

	Legend A . . . Detail A: Drive and support roller adjustments B . . . Detail B: Guide roller adjustments C . . . Cylinder D . . . Felt flap seal E . . . Felt F . . . Guide roller assembly, see BPDUII01 G . . . House H . . . Shellfront J . . . Ring K . . . Adjustment bolts N1 . . Cylinder is aligned when it is symmetrical and square within the house cylinder cavity. N2 . . Use the adjustable bolts on the bearing mounting plates to adjust the position of the drive rollers. N3 . . Use the guide roller adjustment bolts to adjust the front/rear position of the cylinder.

Cylinder Installation

3 Sheets

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

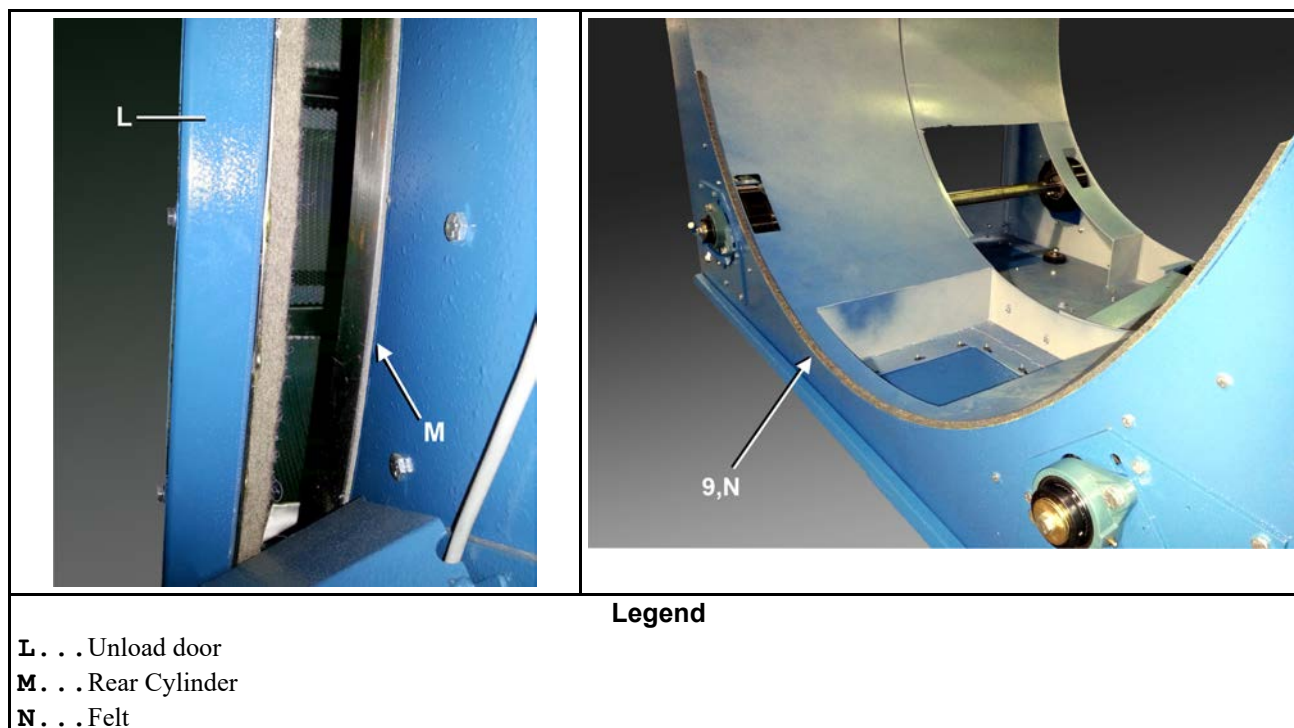


Table 32. Parts List—Cylinder Installation

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	A77FS001	6458 FRONT FLAP SEAL ASSY	6458, 6464 Dryers
	B	A79FS001	7272 FRONT FLAP SEAL ASSY	7272 Dryers
	C	G79FS020	7676 FRONT FLAP SEAL INSTALL	7676 Dryers
	D	G82FS001	8282 FRONT FLAP SEAL INSTALL	8282 Dryers
Components				
	1	A77CA031	6450 BASKET STANDARD	6450
	1	A77CA032	6450 BASKET TEFLON COAT	6450
	1	A77CA033	6450 BASKET HI-TEMP COAT	6450
	1	A77CA011	6458 BASKET STANDARD	6458
	1	A77CA012	6458 DRYER BASKET TEFLON COAT	6458
	1	A77CA014	6458 HITEMCO COATED BASKET	6458
	1	A77CA021	6464 DRYER BASKET STANDARD	6464
	1	A77CA022	6464 DRYER BASKET TEFLON COAT	6464
	1	A77CA023	6464 DRYER BASKET HITEMP COATING	6464

Cylinder Installation

3 Sheets

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

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

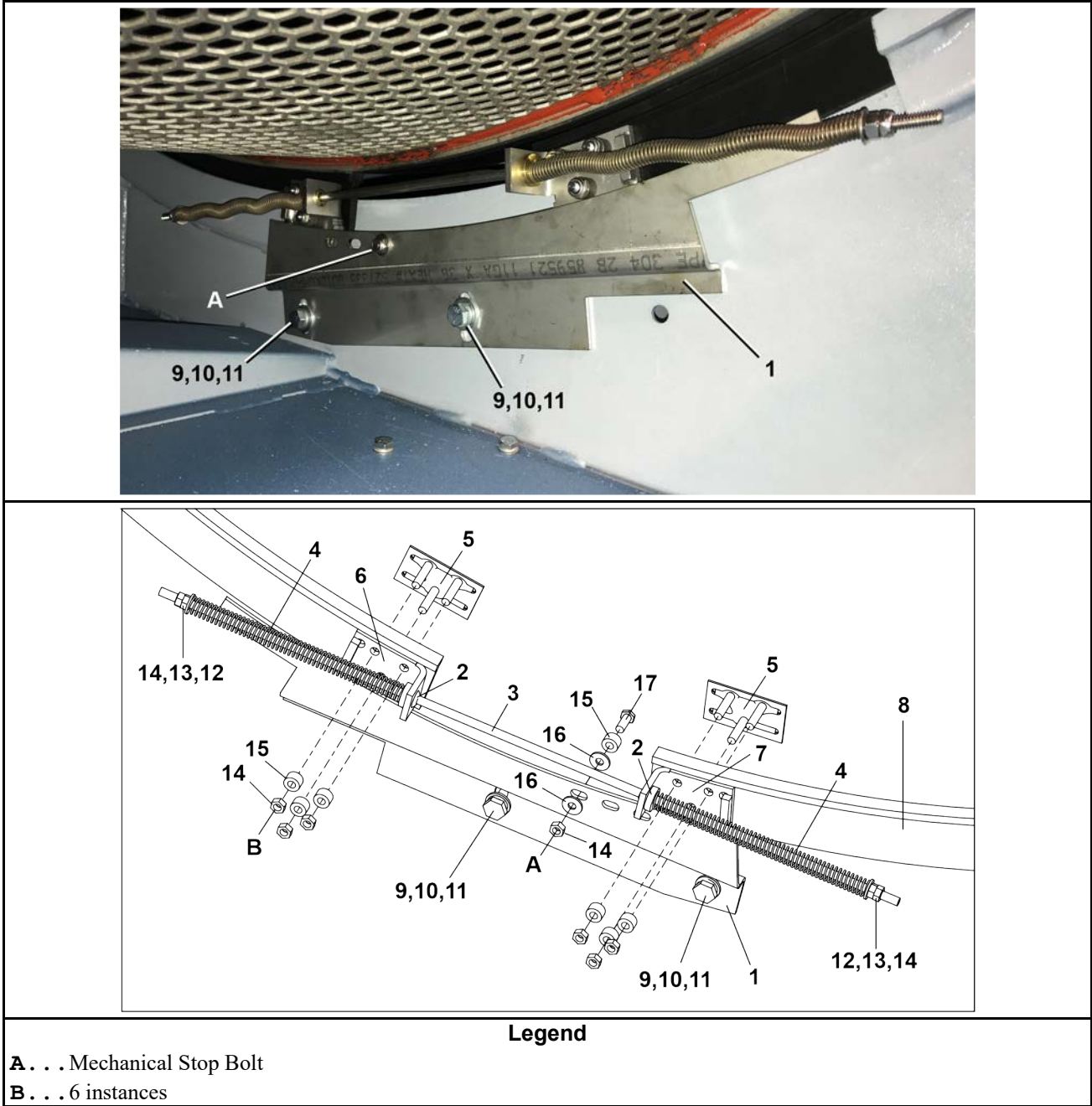
Find the assembly for your machine and the letter shown in the "Item" column. The components for your machine will show this letter or the word "all" in the "Used In" column. The numbers shown in the "Item" column are those shown in the illustrations.				
Used In	Item	Part Number	Description/Nomenclature	Comments
	1	A79CA002	7272TG1L+R=BASKET FINAL WELD/MACH	7272
	1	A79CA003	7272 DRYER BASKET TEFLON COAT	7272
	1	A79CA021	7676TG1L+R=BASKET FINAL MACH/WELD	7676
	1	A79CA023	7676TG1L+R=BASKET TEFLON COAT	7676
	1	A82CA001	8282 BASKET STANDARD	8282
AD	2	27A686	FELT 3/4"THKX1/2"W F7=0.67	
BC	2	27A686A	FELT 3/4"THKX3/4"W F7=0.67 EA=1'	
A	3	07 71212	FRONT SEAL COSMETIC HALF RING - SEE W7 71212 FOR FULL RING	
B	3	07 81212	7272 FRONT SEAL COSM RING	
C	3	W7 85212	7676 FRONT SEAL COSM RING WELD	
D	3	W7 88104	8282 FRONT SEAL COSMETIC RING WELD	
A	4	07 71226A	6458 FRONT SEAL/FELT/NOMEX	
B	4	07 81226A	7272 FRONT SEAL/FELT/NOMEX	
C	4	07 85226	7676 FRONT SEAL/FELT/NOMEX	
D	4	07 88071	8282 FRONT SEAL/FELT/NOMEX	
A	5	07 71117	6458 CYL SEAL RETAINER STRIP	
B	5	07 81117	7272 CYL SEAL RETAINER STRIP	
C	5	07 85117	7676 CYL SEAL RETAINER STRIP	
D	5	07 88070	8282 FRONT SEAL RETAINER STRIP	
all	6	15K033	BUTSOKCAPSCR 1/4-20X5/8 SS18-8	
all	7	15G164NE	HEXLOKNUT NYL 1/4-20 UNC2A SS.	
all	8	27A685	FELT 1/2"THK X 1+1/4"W SAE F-7	
all	9	27A679	FELT 1/4"THK X 1/2"W F7	

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T-Seal Assembly

2 Sheets

64050, 64058, 64064, 76076, 82082 Dryers



T-Seal Assembly

2 Sheets

64050, 64058, 64064, 76076, 82082 Dryers

Table 33. Parts List—T-Seal Assembly

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

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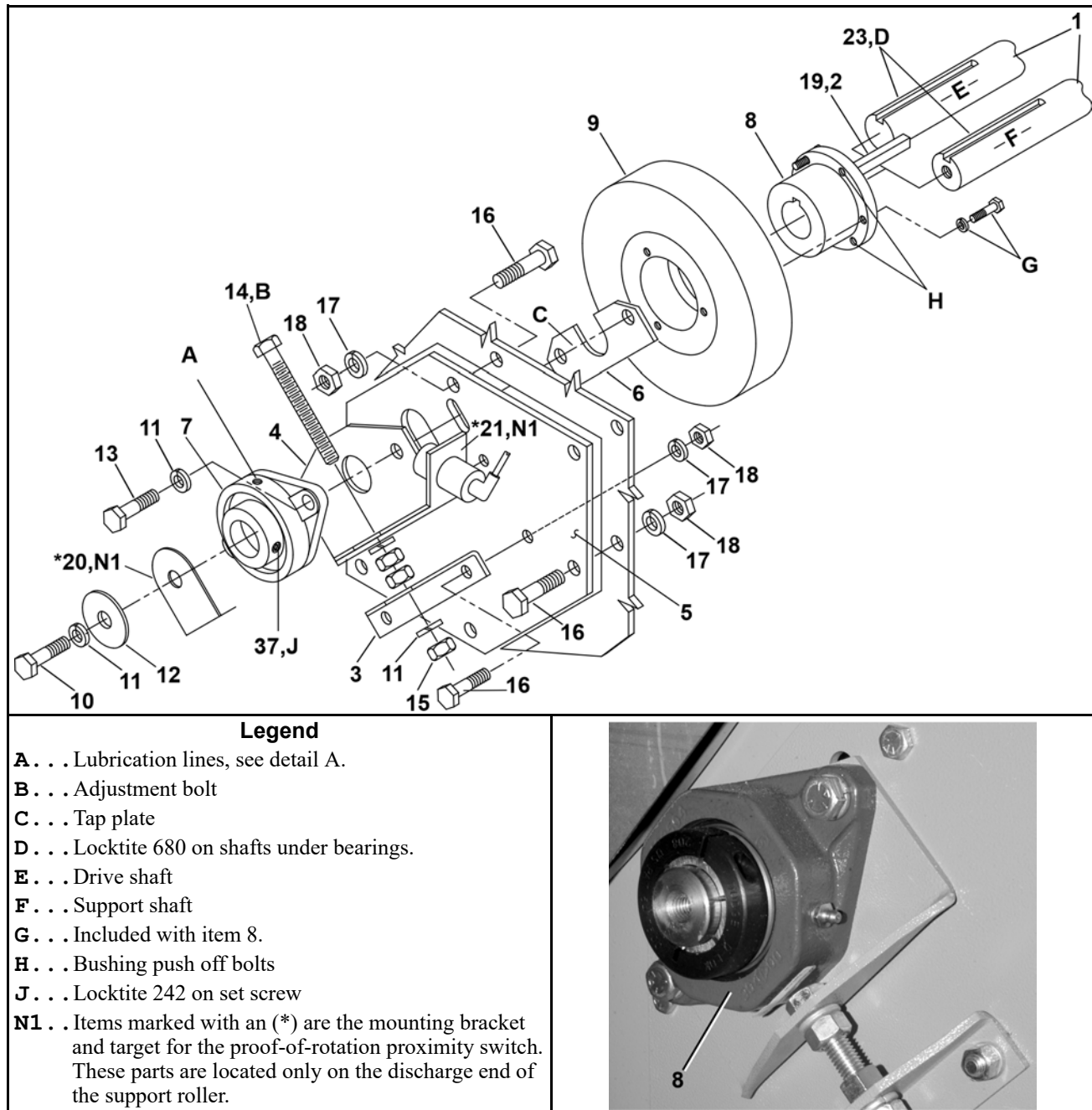
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Drive and Support Rollers

5 Sheets

6450, 6458, 6464 Dryers

Table 34. Bearing Support Plates and Bearings

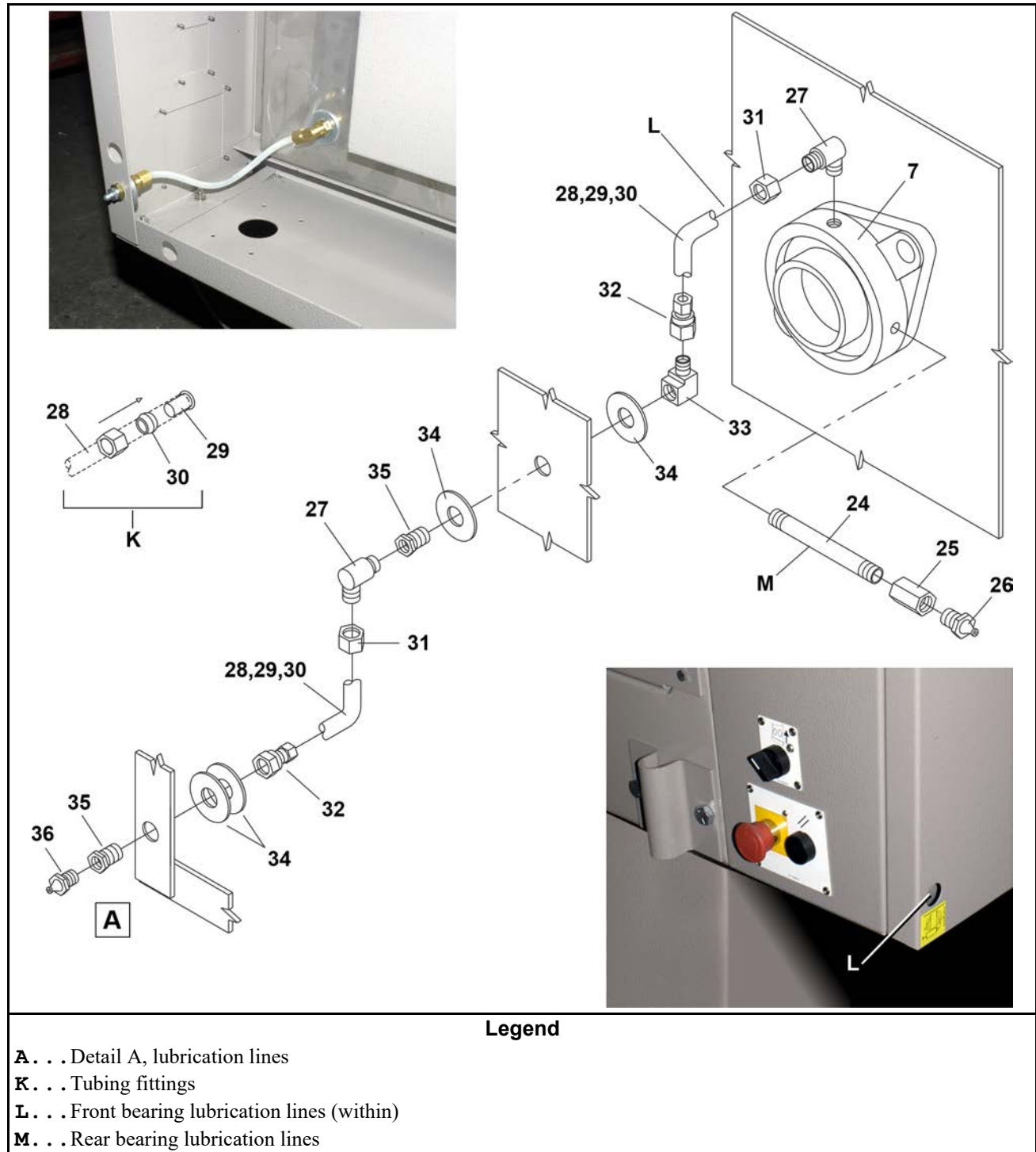


Drive and Support Rollers

5 Sheets

6450, 6458, 6464 Dryers

Table 35. Lubrication Lines

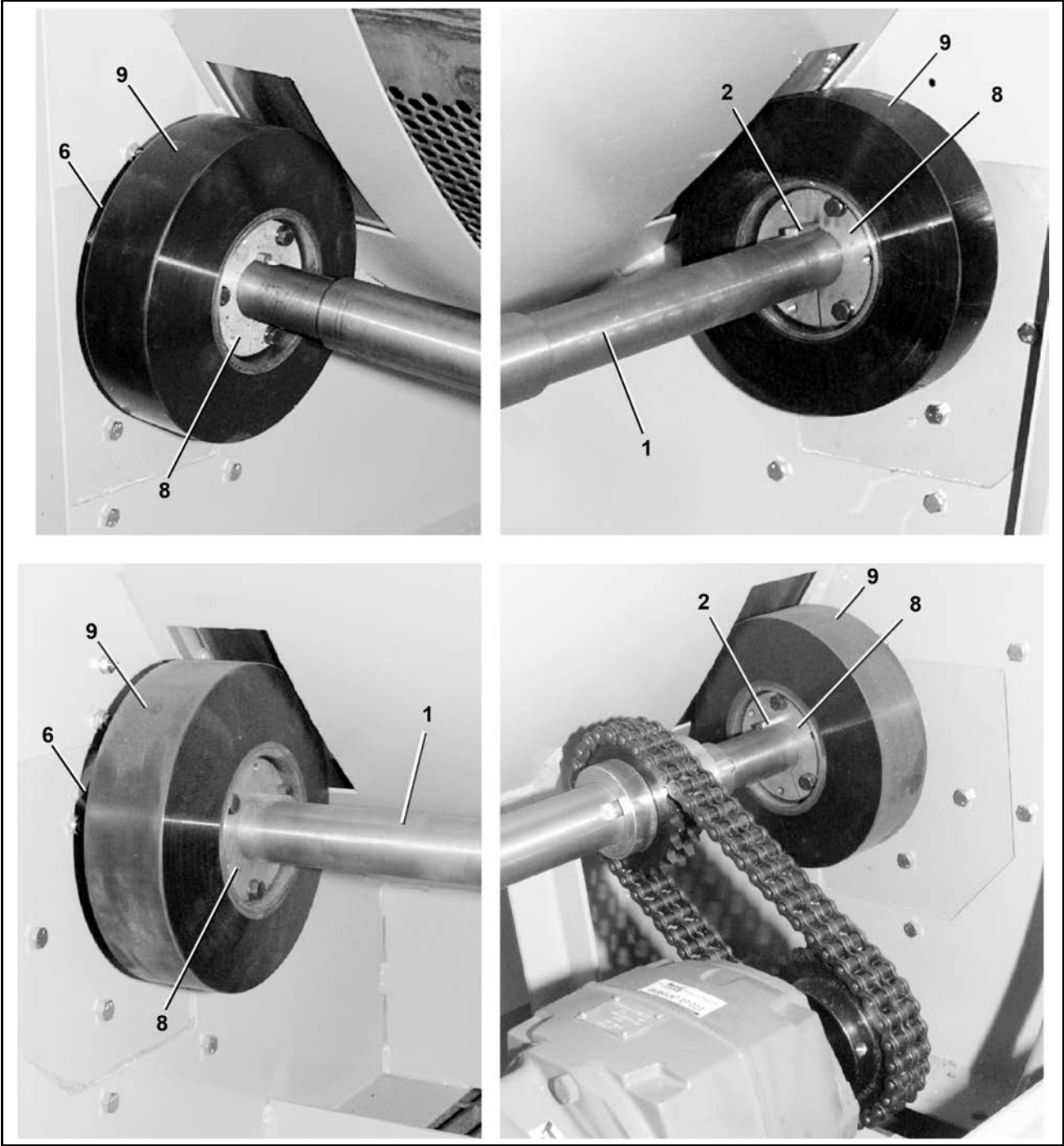


Drive and Support Rollers

5 Sheets

6450, 6458, 6464 Dryers

Table 36. Rollers, Shafts, Bushings



Drive and Support Rollers

5 Sheets

6450, 6458, 6464 Dryers

Table 37. 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	A77DB010	6458 CYLINDER DRIVE ASSY LF	FOR MODELS PRODUCED BEFORE 5/14/08
	B	A77DB012	6458 CYLINDER SUPP ASSY	FOR MODELS 6458TG1L/R.AAX AND LATER PRODUCED AFTER 5/14/08
	C	A77DB020A	6464 CYLINDER SUPP ASSY	6464 DRYERS
	D	G77DB030	6450 CYLINDER SHAFTS INSTALL	6450 DRYERS
Components				
A	1	X7 71168	6458 CYLINDER SHAFTS	
B	1	X7 71169	6458 CYLINDER SHAFT LG BEARING	
C	1	X7 72040A	6464 CYLINDER SHAFTS	
D	1	X7 72540	6450 CYLINDER SHAFTS	
all	2	07 50031A	DRYER SHAFT KEY=WHEEL	
all	3	07 50127	BRKT=BEARING AJUST	
A	4	07 50128	BRKT=BEARING MOUNTING	
BC	4	07 81228	7272 BRKT=SUPPORT BEARING MNT	
A	5	07 71280	6458 SUPP/DRIVE BEAR MTG PLT	
BC	5	07 81280	64-76" DRYER SUPPORT BEAR MTG PLT	
A	6	07 70049A	BEAR ADJUST TAP PLATE	
BC	6	07 81229	7272 BEARING ADJUST PLATE	
A	7	56F1H2CSWC	FLG BRG=1.438 B.D.+COLLAR	
BC	7	56F1H2CSA	FLANGE BRG 2-BOLT 1+7/16	
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	

Drive and Support Rollers

5 Sheets

6450, 6458, 6464 Dryers

Table 37 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	20	03 BL1X1A	TARGET FOR PHOTOEYE 6458 DRYER	
all	21	03 BL1X1B	6458/64 DRYER LF PHOTO EYE BRKT	DRIVE LEFT
all	21	03 BL1X1C	6458/64 DRYER RT PHOTO EYE BRKT	DRIVE RIGHT
all	22	20C008C	THDLKSEAL LCT24241 RMUBL250CC	
all	23	20C012DA	RETAINCMPD ADH LCT#68060 250ML	
all	24	5N0C03AG42	NPT NIP 1/8X3 TBE GALSTL SK40	
all	25	5SCC0CBE	NPT COUP 1/8 BRASS 125# 103A-A	
all	26	54M015	GREASEFIT 60X36/60X44 1610BL	
all	27	53A031B	BODY-EL90MALE.25X1/8 #269C-42B	
all	28	60E004TC	TUBING NYL(NAT)1/4"ODX.17ID	
all	29	53A501	TUBE INSERT .163"OD #63PT-4-40	
all	30	53A500	SLEEVE DELRIN 1/4"OD#60PT-4	
all	31	53A059A	NUT 1/4"BR.HOLYOKE AND #61A-4	
all	32	53A007B	BODYFEMCON.25X.25COMP#B66A-4B	
all	33	5SL0EBEC	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	

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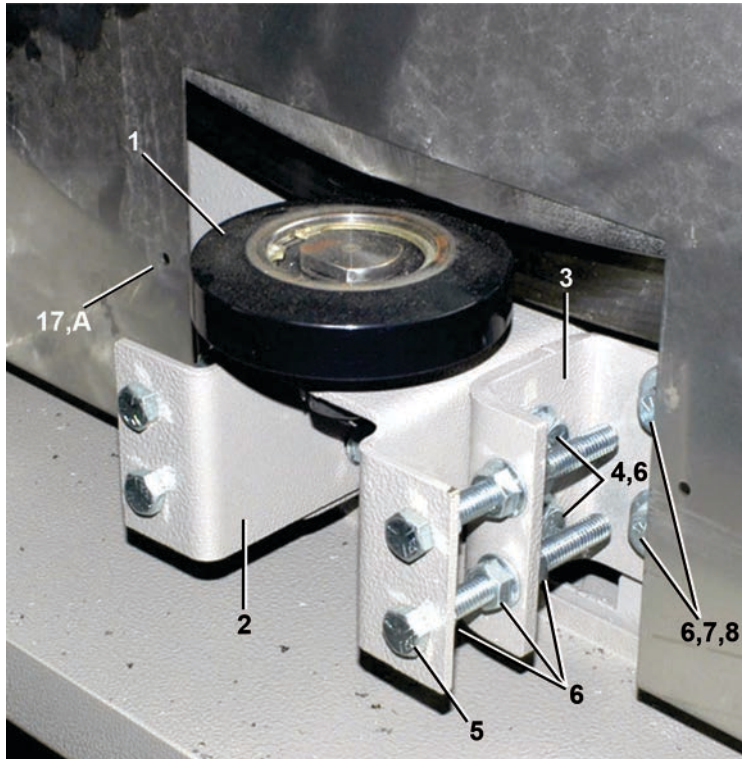
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Guide Roller Assembly

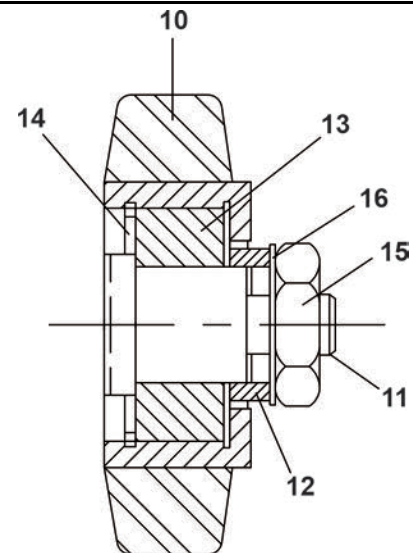
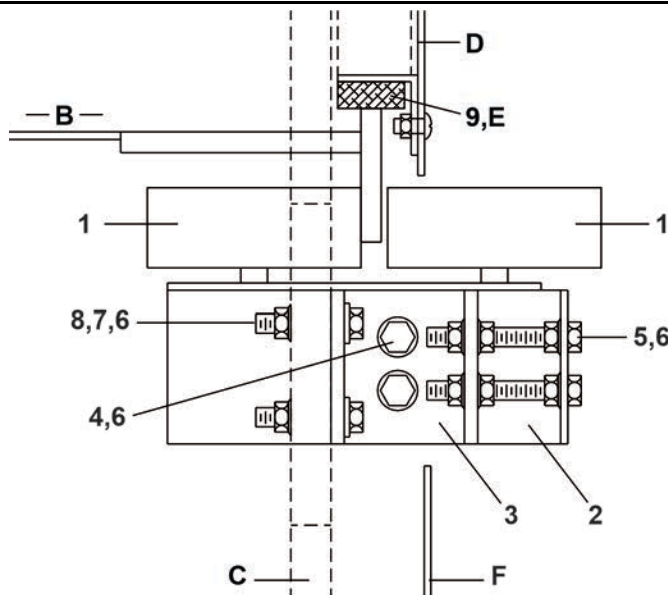
2 Sheets

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 38. 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	
A	2	07 50219	BRKT GUIDE ROLLER MOUNT	TWO REQUIRED CONTAINS 10–16
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	

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4.1 Main Air Blower Wheel Replacement

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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.

4.1.1 Resources Needed

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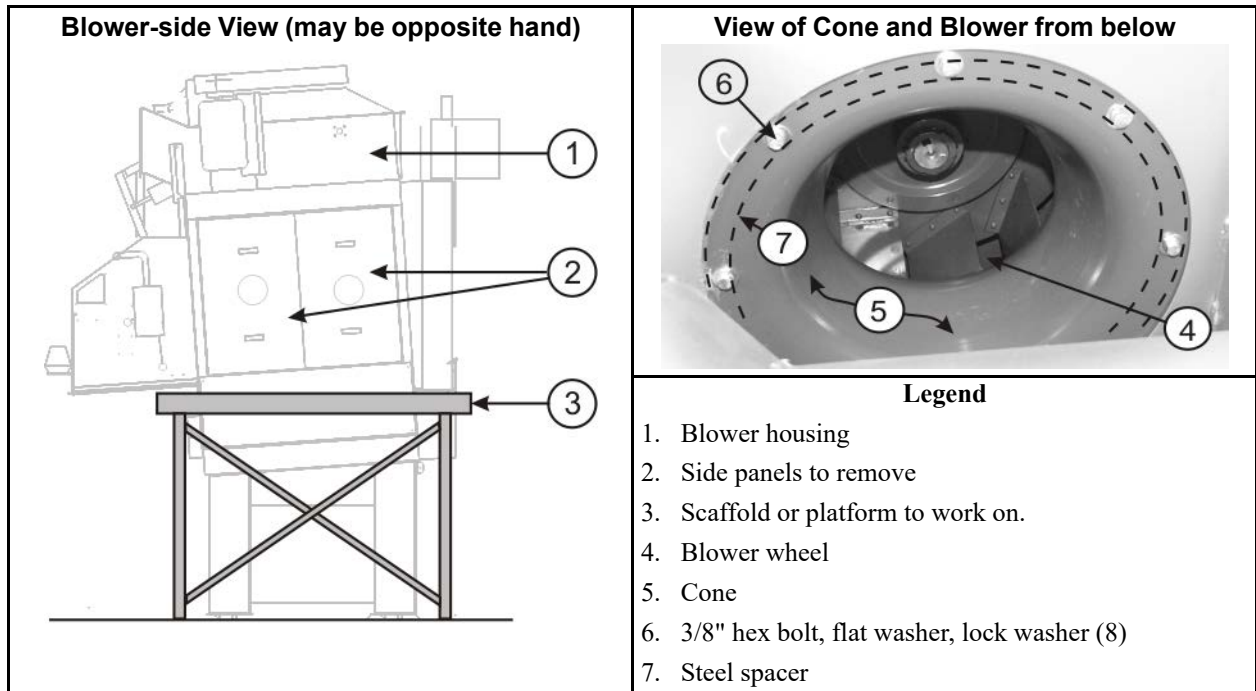
- Two maintenance personnel to handle the blower wheel overhead. Blower wheels range in weight from about 50 to 90 pounds (23 to 41 Kg).
- A sturdy scaffold or platform to work at the level of the dryer housing (see [Figure 31: Preparing for the Work, page 105](#))
- Dryer service manual (see the Blower 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

4.1.2 Preparations

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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 31, page 105](#).
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 31. Preparing for the Work



4.1.3 Remove the Old Blower Wheel

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1. Refer to [Figure 31, page 105](#). 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 32: Blower Wheel Attachment to Shaft, page 106](#). 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.

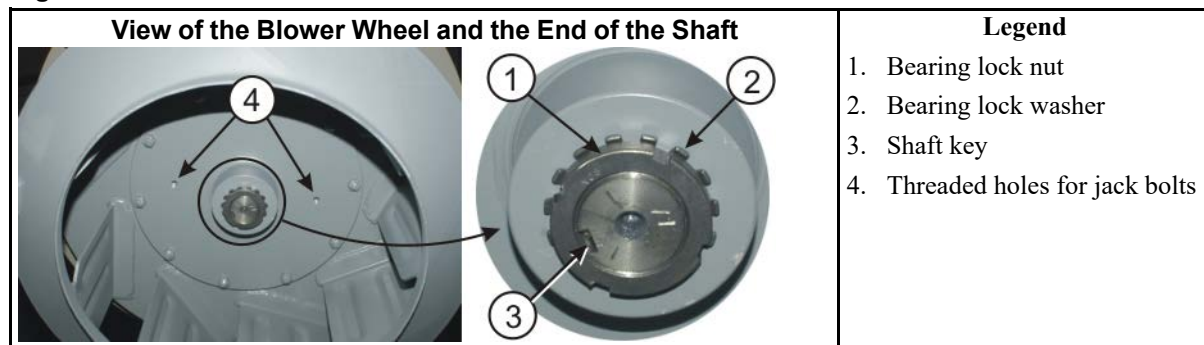
4. Refer to [Figure 32, page 106](#). Two threaded holes on the blower wheel hub (item 4) will accept the 3/8" jack bolts. Insert both bolts until they stop against the top of the blower housing. With the bearing lock nut still attached, alternately tighten the jack bolts to push the wheel off of the 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 32. Blower Wheel Attachment to Shaft



4.1.4 Install the New Blower Wheel

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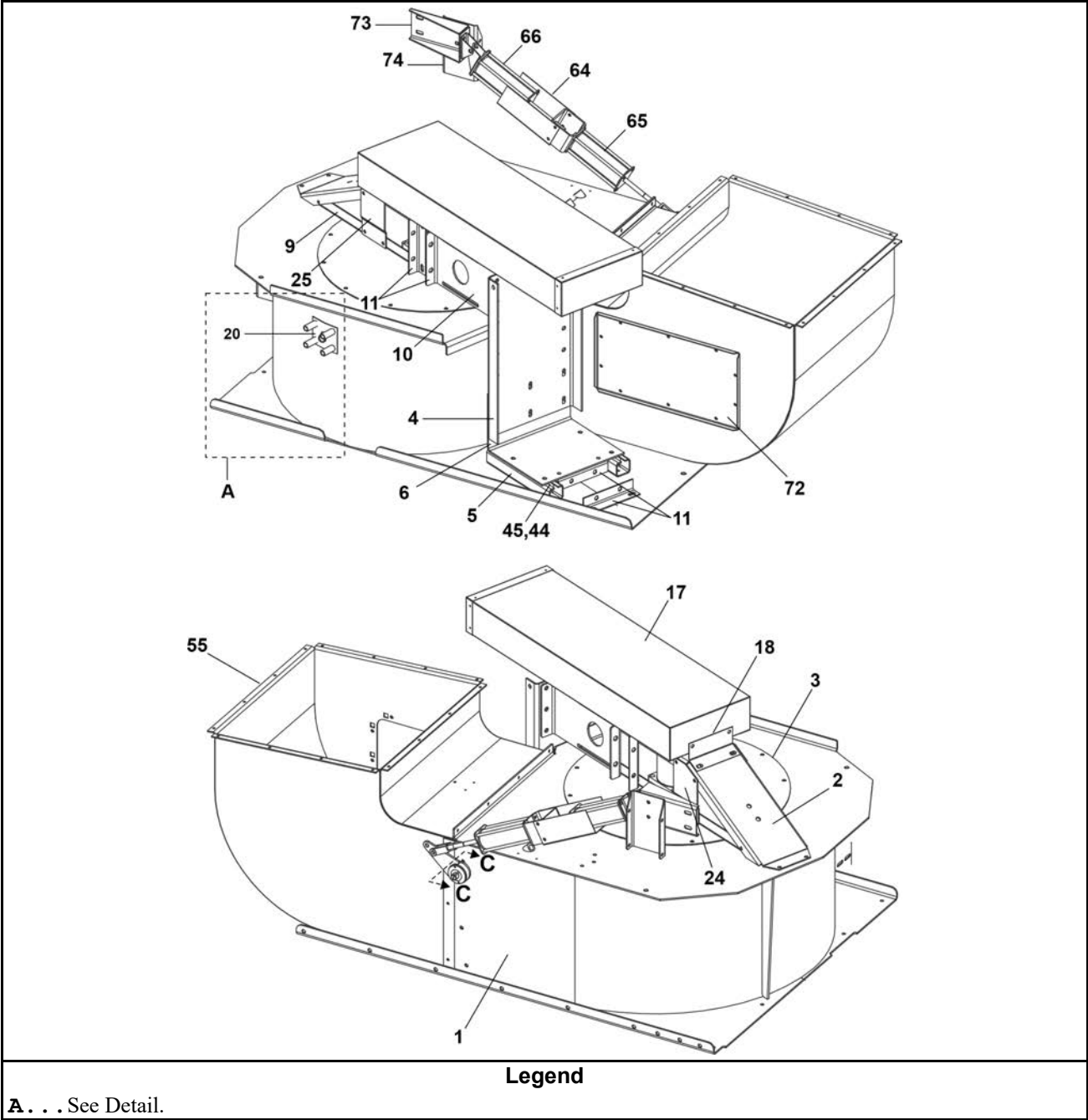
1. If the shaft key came off of the shaft, replace it. It should fit tightly in the groove on the shaft.
2. Put the 2x4 blocking within reach. Carefully maneuver the new blower wheel into position and onto the shaft. While supporting the weight of the blower wheel, wedge the 2x4 blocking under the blower 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 metallic rubbing sound. This is normally not serious and the noise should dissipate after the machine is in operation for a while and the cone wears down. If the noise is objectionable, remove electrical power from the machine (see Notice above) and adjust the cone position as explained above.

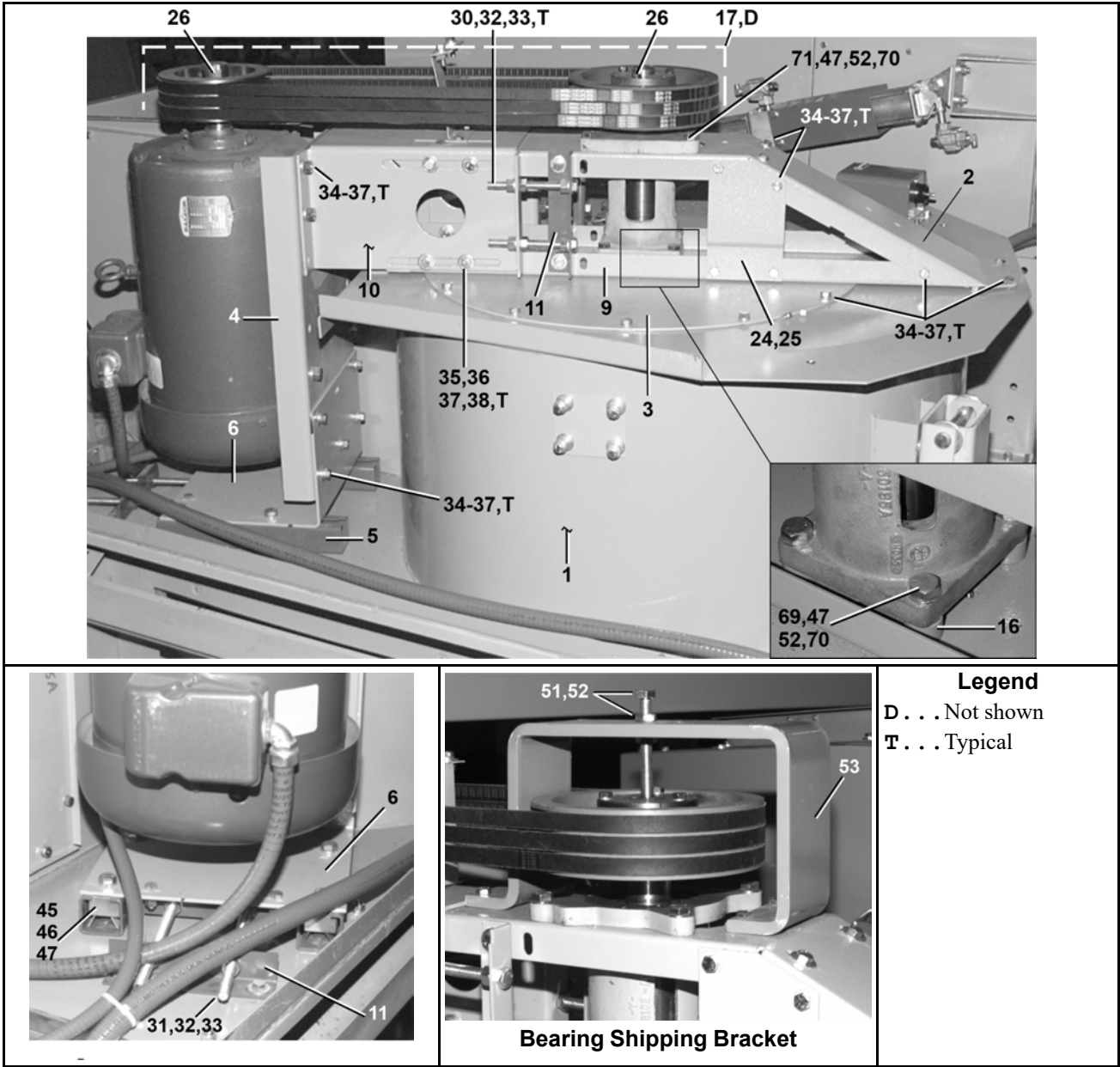
9. If any unusual noise or vibration persists, consult Milnor® Technical Support.
10. Replace the side panels and return the dryer to operation.



Blower with Front Vertical Exhaust

7 Sheets

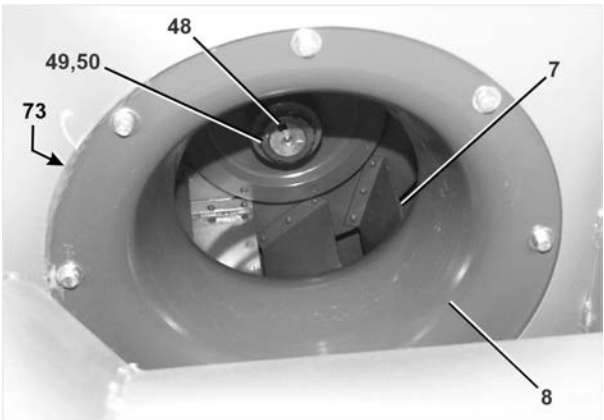
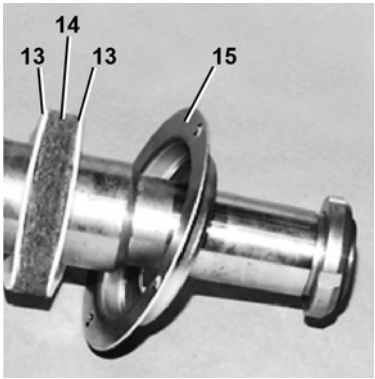
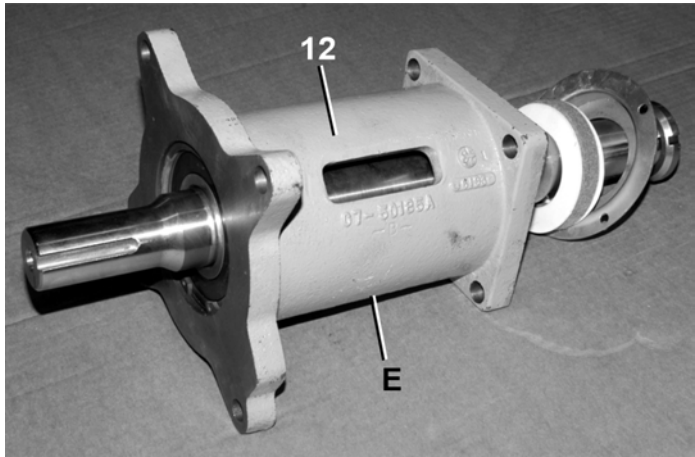
6458TG1L/R; 6464TG1L/R



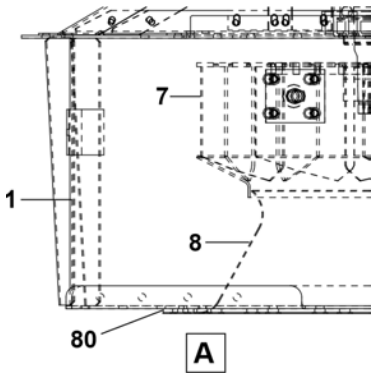
Blower with Front Vertical Exhaust

6458TG1L/R; 6464TG1L/R

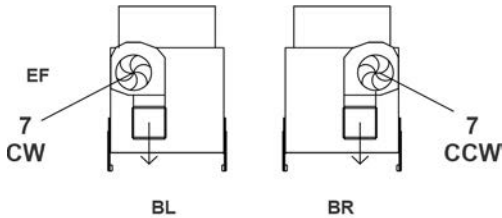
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Underside of Blower



A



B

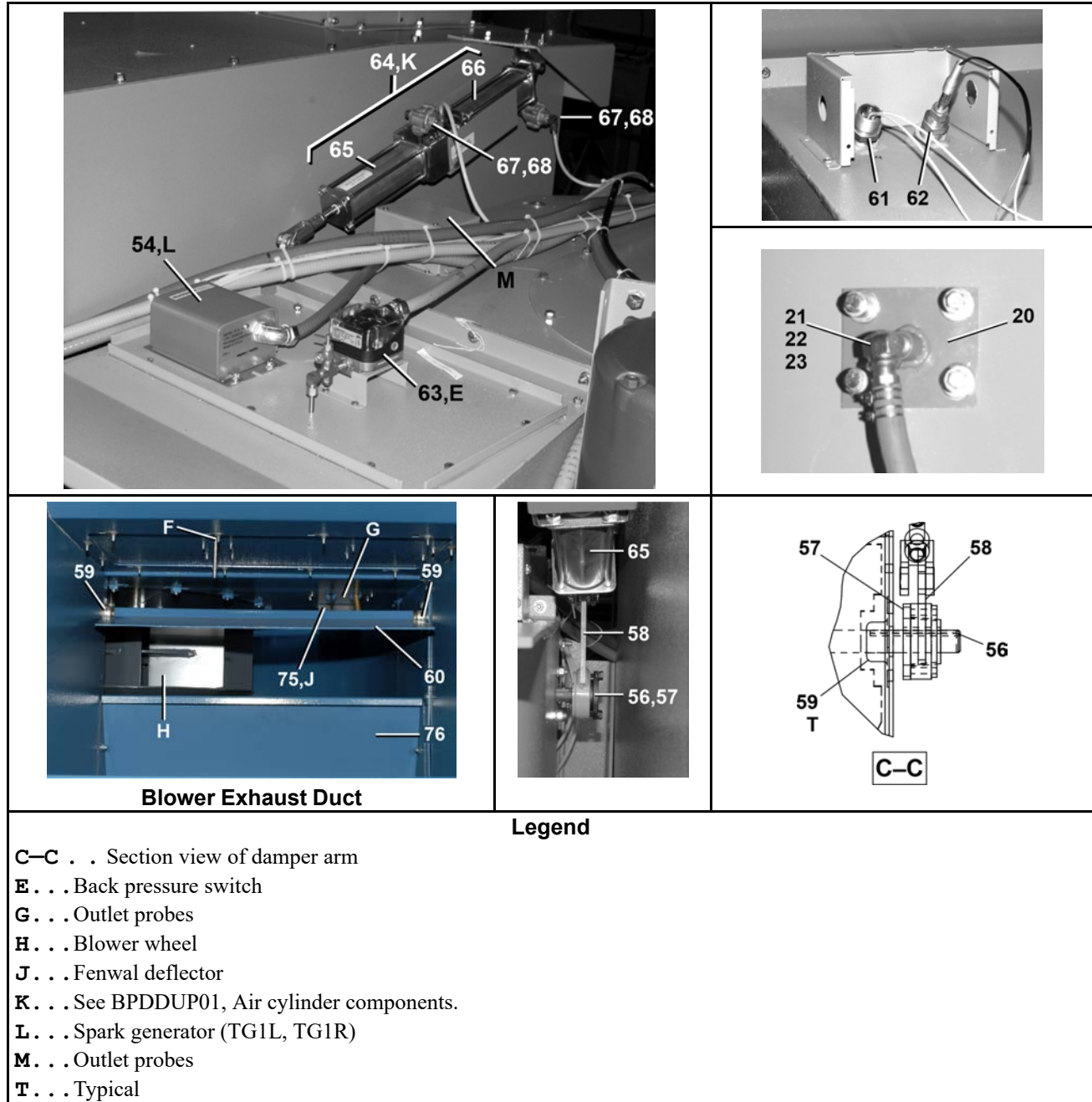
Legend

- A** . . . Inside view of Blower
- B** . . . Blower Wheel Direction
- BL** . . Blower left
- BR** . . Blower right
- CW** . . Clockwise
- CCW** . . Counter Clockwise
- E** . . . Blower Bearing, see BPDUUB01
- EF** . . Front vertical exhaust

Blower with Front Vertical Exhaust

7 Sheets

6458TG1L/R; 6464TG1L/R



Blower with Front Vertical Exhaust

7 Sheets

6458TG1L/R; 6464TG1L/R

Table 39. 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	A77BA008	6458/64 LF BLWR ASSY - FRNT VT EXHST	6458 & 6464TG1L
	B	A77BA008A	6458/64 RT BLWR ASSY - FRNT VT EXHST	6458 & 6464TG1R
Components				
A	1	W7 71075B	WLMT=BLOWR VOLUTE 22.25" 6464 LT	Blower Left
B	1	W7 71075C	WLMT=BLOWR VOLUTE 22.25" 6464 RT	Blower Right
all	2	07 50254	CHANNEL=BRG MT UPPER BLOWER	
all	3	07 71089	6458 BLOWER TOP PLATE	
all	4	07 71092	6458 BLOWER MTR UPPER BKT	
all	5	07 70140	+5880 BLOWER MOTOR RAIL	
all	6	07 71094	6458 BLOWER MTR LOWER BKT	
all	7	13E222CWA	BLOWER WHL 22+1/4"CL-3 CW	Clockwise
all	7	13E222CCWA	BLOWER WHL 22+1/4"CL-3 CCW	Counter Clockwise
all	8	13E222CONE-P	FUNNEL/INLET CONE #222 WHL.PAINTED	
all	9	07 50255	CHANN BRG MT LOWER BLOWER	
all	10	07 70137	64" DRYER MAIN BLOWER MTR SPT BKT	
all	11	07 50252	ANGLE=BELT ADJ BLOWER MOTOR	
all	12	A75BG004	BLW BRG HSE ASSY=2001354	
all	13	07 50288	BLOWER SHAFT TEFLON SEAL	
all	14	07 50287	BLOWER SHAFT FELT SEAL	
all	15	07 50286	BLOWER SHAFT SEAL CAP	
all	16	07 50184	BLWR BRG HSE SPACE SH=00143	
all	17	A77BA002	64" DRYER BLOWER BELT GUARD ASSY	
all	18	07 50267	BRACKET=64" DRYER MAIN BLW BELT GUARD	
all	19	07 50262	BRACKET=MAIN BLW BELT GUARD	
all	20	W7 60265	*LINT NOZZLE PLATE WLMT	
all	21	51E505	HOSESTEM BRASS 3/8H XMPT	
all	22	12P014SZ	TUBE CLAMP 1/2"ST/Z TIN#4886S	
all	24	07 50257	20" BLOWER BKT SUPPORT LEFT	
all	25	07 50257A	20" BLOWER BKT SUPPORT RT	
all	26	15E195	SQMACHKEY 3/16X1+1/2 NOTAPER	
all	30	15K202	HEXCAPSCR 1/2-13UNC2AX5 GR5 ZI	
all	31	15D122C	HEXTAPSCR 1/2-13UNC X 8.5 FLTHD	
all	32	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	

Blower with Front Vertical Exhaust

7 Sheets

6458TG1L/R; 6464TG1L/R

Table 39 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	33	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	34	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	35	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	36	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	37	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	38	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	39	15N140	RDMACSCR 10-24UNC2AX3/4 ZINC G	
all	40	15G125	HXMACHSCRNUT 10-24UNC2B ZINC G	
all	41	15U150	LOCKWASHER MEDIUM #10 ZINCPL	
all	42	15K039	HXCAPSCR 1/4-20UNC2AX3/4 GR5 Z	
all	43	15U180	LOCKWASHER MEDIUM 1/4 ZINCPL	
all	44	15G165	HXNUT 1/4-20UNC2BSAE ZC GR2	
all	45	02 19283	NUT=1/2-13UNCX1+1/2SQ SPEC	
all	46	15K151	HXCAPSCR 1/2-13UNC2AX1.25 GR5	
all	48	15E225	SQMACHKEY 3/8X1+1/2 NOTAPER-NO	
all	49	56AHN08	N08 BEARING LOCKNUT	
all	50	56AHW108	TW108 BEARING LOCKWASHER	
all	51	15D119	HXTAPSCR 1/2-13X4 GR5 ZNC FTL	
all	53	07 50187	DRYER SHIPPING BLWR BEARING HOLDER	
all	54	09X175	IGNITION TRANSFRMER Q624A1014-U "UNITS"	
all	55	W7 71071	6458 BLOWER EXHAUST WELD	
all	57	56Q0PH	3/4" BROWNING H BUSHING TYPE 1	
all	58	W7 71098	6458 BLOWER DAMPER ARM WELD	
all	59	54E015	FLGMTBRG 3/4 BORE BRZ #FLB12	
all	60	W7 71097	6458 22.75" BLWR DAMP WELD LF	
all	61	30R0225P	THERMOSW.FENWAL CLOSE @ 225F STAINLESS STEEL	
all	62	30R0055PP	* DRYER OUTLET T/C PROBE ASSY	
all	63	A77BP001	6458 BACK PRESSURE SWIT ASSY	
all	64	A77AC003	6458 MAIN DAMP CYL ASSY	
all	65	A75 01300A	6458 AIR CYL. DAMP=2"STROKE	
all	66	A75 01200A	6458 AIR CYL. DAMP=3" STROKE	
all	67	96M055	QUICK EXHAUST VLV.1/4"	
all	68	5SP0GFFSSV	NPT PLUG 3/8 SQSOLIDVENTBLKSTL	

Blower with Front Vertical Exhaust

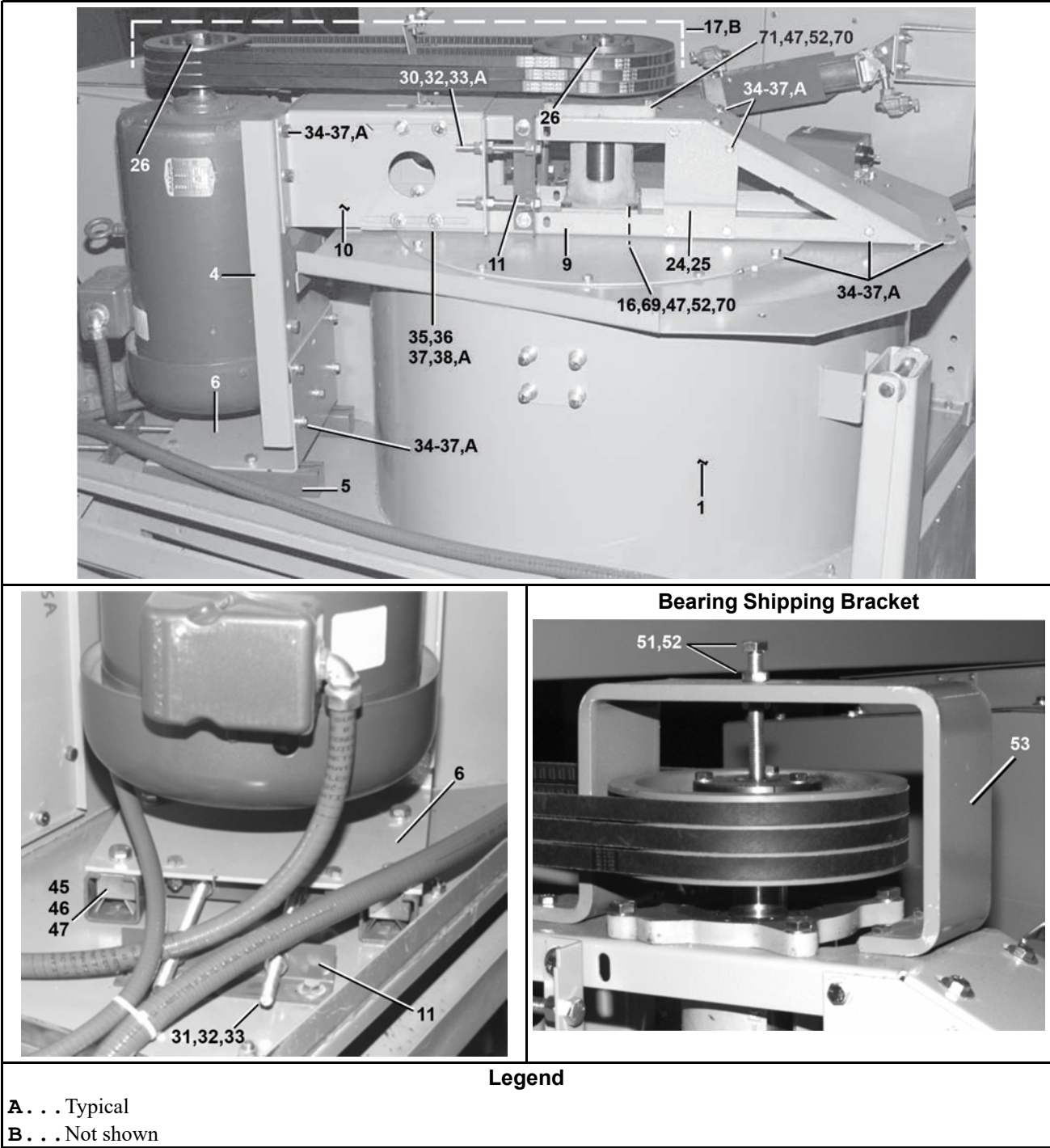
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6458TG1L/R; 6464TG1L/R

Table 39 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	69	15K191	HXCAPSCR 1/2-13UNC2AX2.5 GR5 Z	
all	70	15U243	FLTWASHER 7/8ODX33/64IDX16GA Z	
all	71	15K173A	HXCAPSCR 1/2-13UNC2AX1.75 GR5	
all	72	07 71095B	COVER=CLEAN OUT 6458	
all	73	07 85197B	6464 FB RETRO AIR DMPR ANGLE EXT BRKT	
all	74	07 85197	6464 FB RETRO AIR DMPR BRKT	
all	75	07 71040	FENWALL DEFLECTOR	
all	76	07 71090	6458 BLOWER CUTOFF PLATE	

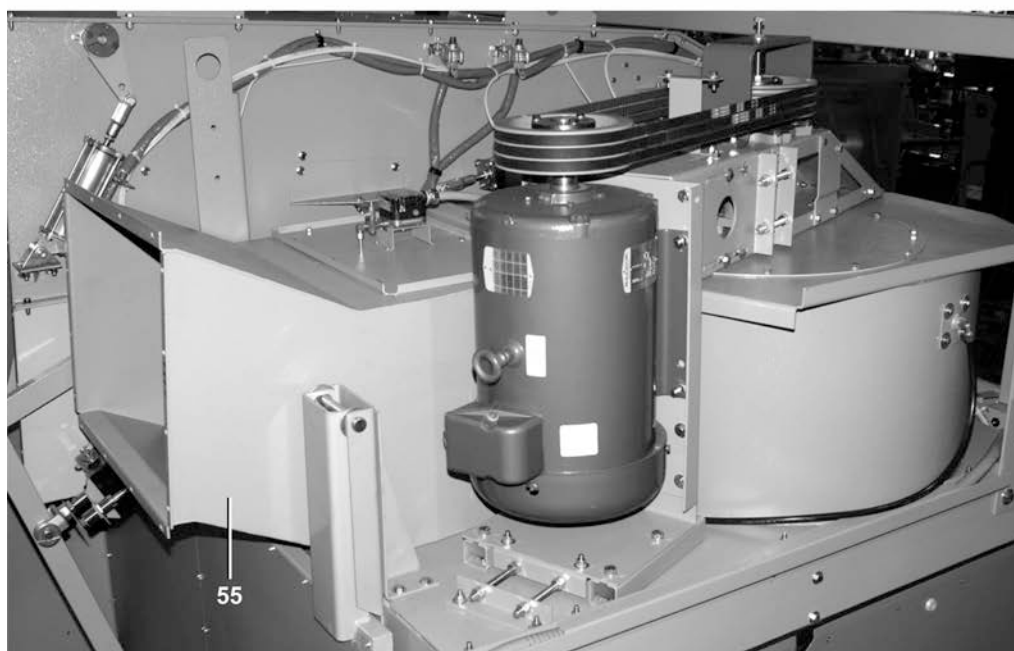
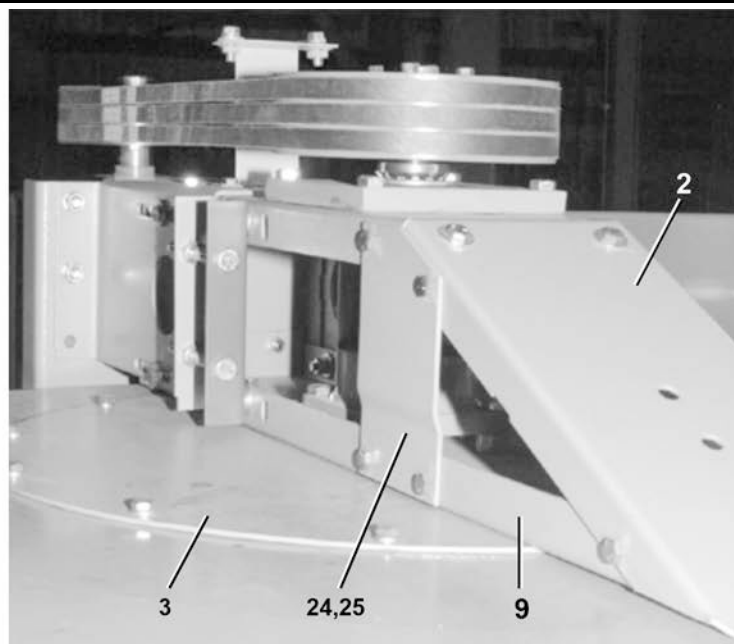
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Blower Installation and Exhaust Duct to Rear

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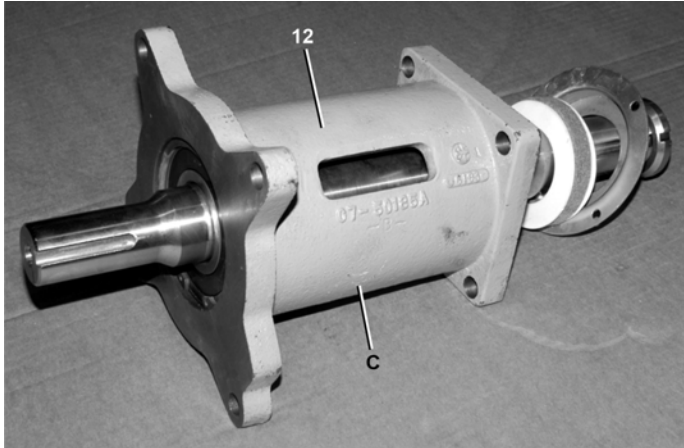
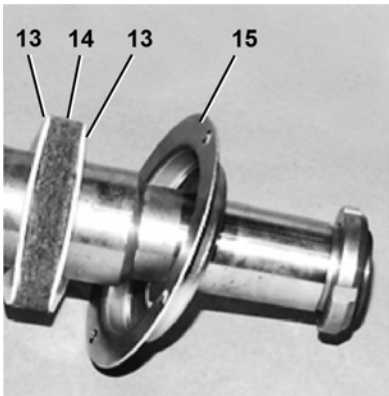
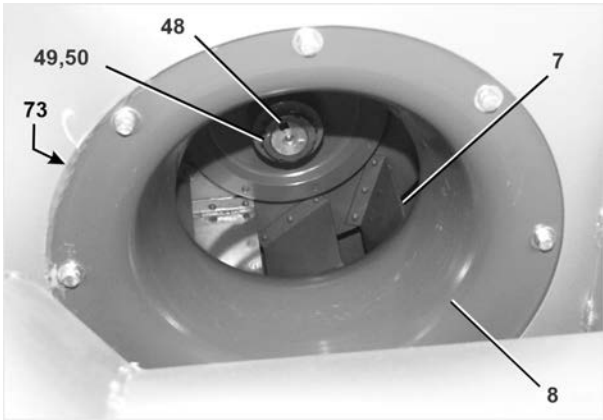
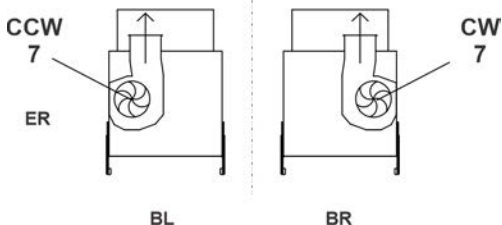
6458TG1L,TG1R,TS1L,TS1R; 6464TG1L,TG1R,TS1L,TS1R



Blower Installation and Exhaust Duct to Rear

8 Sheets

6458TG1L,TG1R,TS1L,TS1R; 6464TG1L,TG1R,TS1L,TS1R

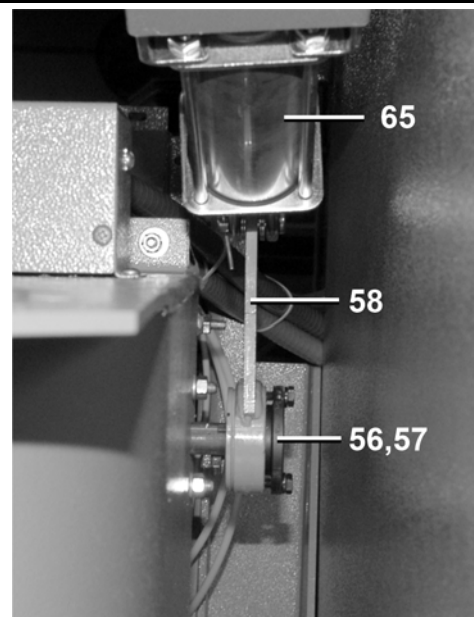
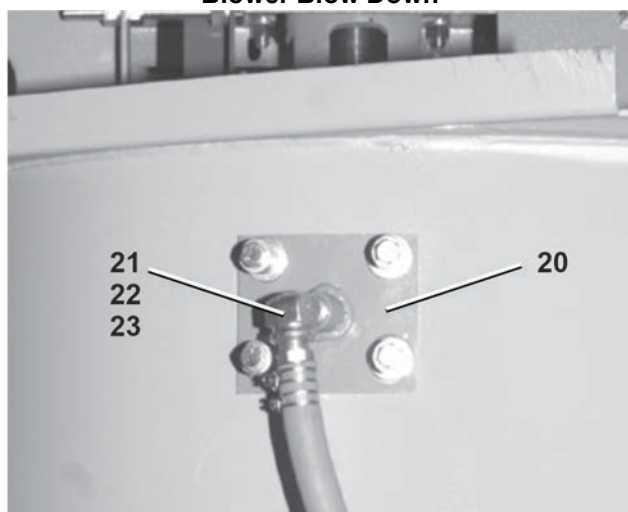
	
 Underside of Blower	 Legend BL . . Blower left BR . . Blower right C . . Bearing Assembly, see BPDDUB01. CW . . Clockwise CCW . . Counter clockwise ER . . Exhaust rear

Blower Installation and Exhaust Duct to Rear

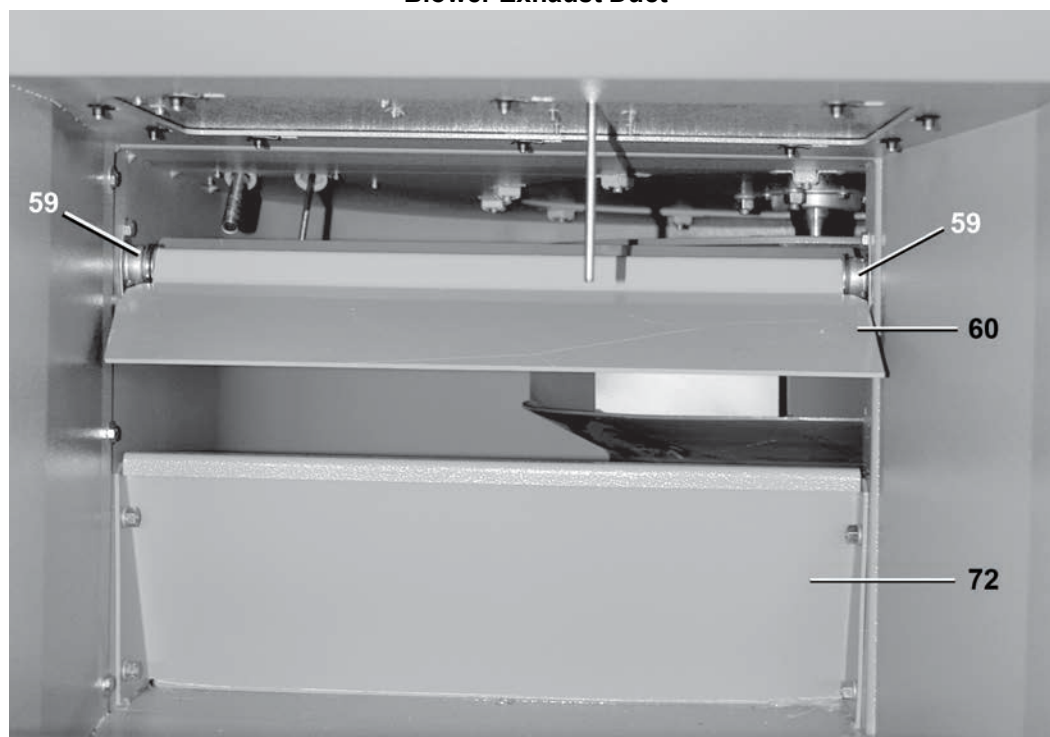
8 Sheets

6458TG1L,TG1R,TS1L,TS1R; 6464TG1L,TG1R,TS1L,TS1R

Blower Blow Down



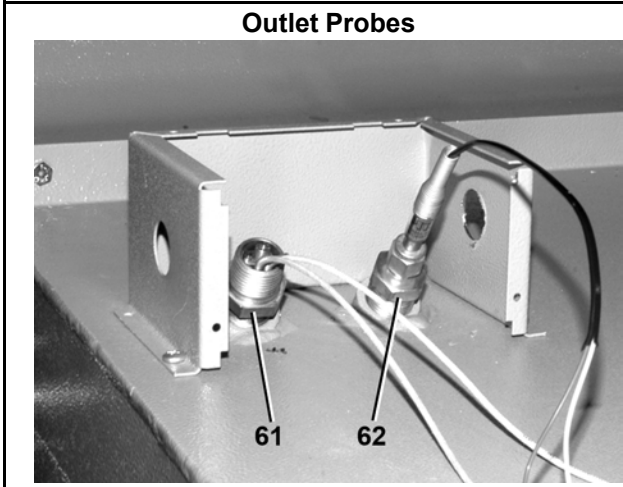
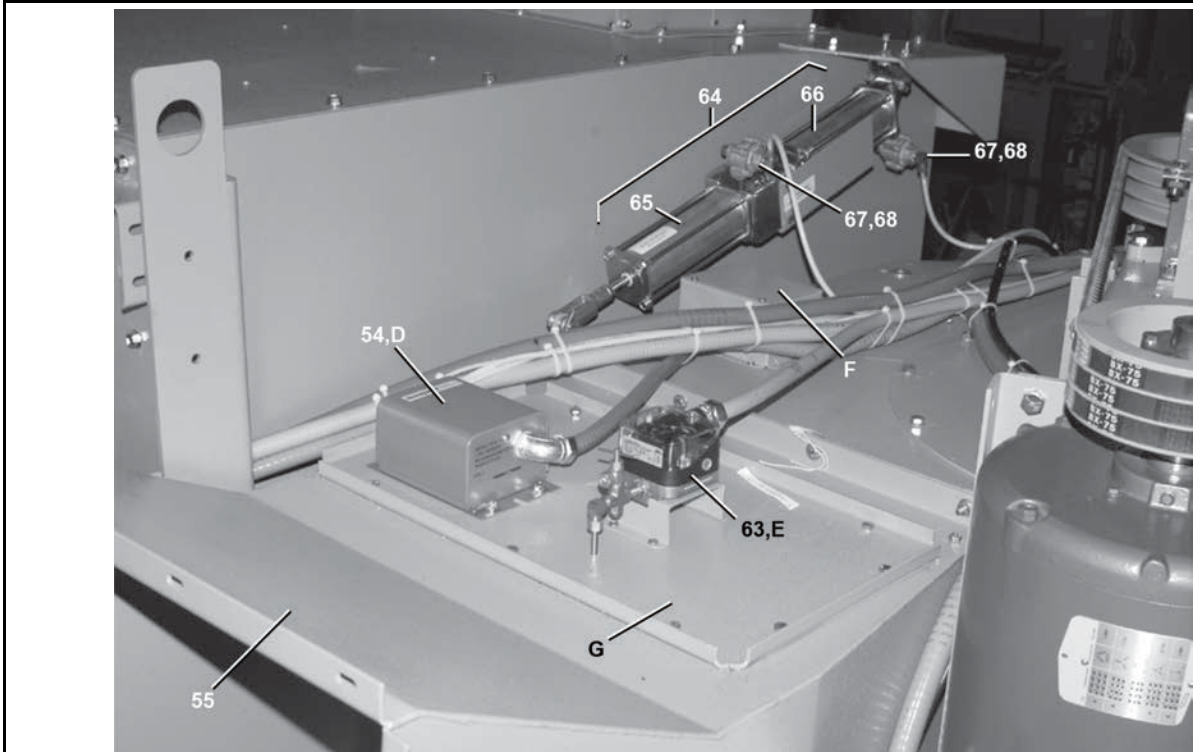
Blower Exhaust Duct



Blower Installation and Exhaust Duct to Rear

8 Sheets

6458TG1L,TG1R,TS1L,TS1R; 6464TG1L,TG1R,TS1L,TS1R



- Legend**
- D . . . Spark generator (TG1R,TG1L)
 - E . . . Back pressure switch
 - F . . . Outlet probes
 - G . . . Cover to access damper

Table 40. Parts List—Blower Installation and 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	A77BA006	6458/64 LF BLWR ASSY	Blower left

Blower Installation and Exhaust Duct to Rear

8 Sheets

6458TG1L,TG1R,TS1L,TS1R; 6464TG1L,TG1R,TS1L,TS1R

Table 40 Parts List—Blower Installation and 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
	B	A77BA006A	6458/64 RT BLWR ASSY	Blower right
	C	G77BA011	6458/64 LF BLWR INSTAL	Reference
Components				
all	1	W7 71136	6458 22.25 BLW WELD=LF=HORZ	Horizontal duct to rear
all	2	07 50254	CHANNEL=BRG MT UPPER BLOWER	
all	3	07 71089	6458 BLOWER TOP PLATE	
all	4	07 71092	6458 BLOWER MTR UPPER BKT	
all	5	07 70140	+5880 BLOWER MOTOR RAIL	
all	6	07 71094	6458 BLOWER MTR LOWER BKT	
all	7	13E222CWA	BLOWER WHL 22+1/4"CL-3 CW	See Detail.
all	7	13E222CCWA	BLOWER WHL 22+1/4"CL-3 CCW	See Detail.
all	8	13E222CONE-P	FUNNEL/INLET CONE #222 WHL.PAINTED	
all	9	07 50255	CHANN BRG MT LOWER BLOWER	
all	10	07 70137	64" DRYER MAIN BLOWER MTR SPT BKT	
all	11	07 50252	ANGLE=BELT ADJ BLOWER MOTOR	
all	12	A75BG004	BLW BRG HSE ASSY=2001354	
all	13	07 50288	BLOWER SHAFT TEFLON SEAL	
all	14	07 50287	BLOWER SHAFT FELT SEAL	
all	15	07 50286	BLOWER SHAFT SEAL CAP	
all	16	07 50184	BLWR BRG HSE SPACE SH=00143	
all	17	A77BA002	64" DRYER BLOWER BELT GUARD ASSY	
all	18	07 50267	BRACKET=64" DRYER MAIN BLW BELT GUARD	
all	19	07 50262	BRACKET=MAIN BLW BELT GUARD	
all	20	W7 60265	*LINT NOZZLE PLATE WLMT	
all	21	51E505	HOSESTEM BRASS 3/8H XMPT	
all	22	12P014SZ	TUBE CLAMP 1/2"ST/Z TIN#4886S	
all	23	90A025	COPPERTUBE 1/2"X.032X50' EA=1	
all	24	07 50257	20" BLOWER BKT SUPPORT LEFT	
all	25	07 50257A	20" BLOWER BKT SUPPORT RT	
all	26	15E195	SQMACHKEY 3/16X1+1/2 NOTAPER	
all	30	15K202	HEXCAPSCR 1/2-13UNC2AX5 GR5 ZI	
all	31	15D122C	HEXTAPSCR 1/2-13UNC X 8.5 FLTHD	
all	32	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	33	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	

Blower Installation and Exhaust Duct to Rear

8 Sheets

6458TG1L,TG1R,TS1L,TS1R; 6464TG1L,TG1R,TS1L,TS1R

Table 40 Parts List—Blower Installation and 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	34	15K095	HXCPSCR 3/8-16UNC2AX1 GR5 ZINC	
all	35	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	36	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	37	15U240	FLATWASHER(USS STD) 3/8" ZNC P	
all	38	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	39	15N140	RDMACSCR 10-24UNC2AX3/4 ZINC G	
all	40	15G125	HXMACHSCRNUT 10-24UNC2B ZINC G	
all	41	15U150	LOCKWASHER MEDIUM #10 ZINCPL	
all	42	15K039	HXCAPSCR 1/4-20UNC2AX3/4 GR5 Z	
all	43	15U180	LOCKWASHER MEDIUM 1/4 ZINCPL	
all	44	15G165	HXNUT 1/4-20UNC2BSAE ZC GR2	
all	45	02 19283	NUT=1/2-13UNCX1+1/2SQ SPEC	
all	46	15K151	HXCAPSCR 1/2-13UNC2AX1.25 GR5	
all	48	15E225	SQMACHKEY 3/8X1+1/2 NOTAPER-NO	
all	49	56AHN08	N08 BEARING LOCKNUT	
all	50	56AHW108	TW108 BEARING LOCKWASHER	
all	51	15D119	HXTAPSCR 1/2-13X4 GR5 ZNC FTL	
all	53	07 50187	DRYER SHIPPING BLWR BEARING HOLDER (COLOR=RED)	
all	54	09X175	IGNITION TRANSFRMER Q624A1014-U "UNITS"	
all	54	09X175A	IGNITION TRANSFRMER CE ECLIPSE 10012234	
all	54BB	09X175AB	MOUNTING KIT FOR 09X175A - ECLIPSE	
all	55	W7 71137	6458 BLW EXHST WELD=LF=HORZ	
all	55	W7 71137A	6458A BLW EXHST WELD=RT=HORZ	
all	57	56Q0PH	3/4" BROWNING H BUSHING TYPE 1	
all	58	W7 71098B	6458 BLWR DAMP ARM WELD HORZ	
all	59	54E015	FLGMTBRG 3/4 BORE BRZ #FLB12	
all	60	W7 71097	6458 22.75" BLWR DAMP WELD LF	
all	61	30R0225P	THERMOSW.FENWAL CLOSE @ 225F STAINLESS STEEL	
all	62	30R0055PP	* DRYER OUTLET T/C PROBE ASSY	
all	63	A77BP001	6458 BACK PRESSURE SWIT ASSY	
all	64	A77AC003	6458 MAIN DAMP CYL ASSY	
all	65	A75 01300A	6458 AIR CYL. DAMP=2"STROKE	
all	66	A75 01200A	6458 AIR CYL. DAMP=3" STROKE	

Blower Installation and Exhaust Duct to Rear

8 Sheets

6458TG1L,TG1R,TS1L,TS1R; 6464TG1L,TG1R,TS1L,TS1R

Table 40 Parts List—Blower Installation and Exhaust Duct to Rear (cont'd.)

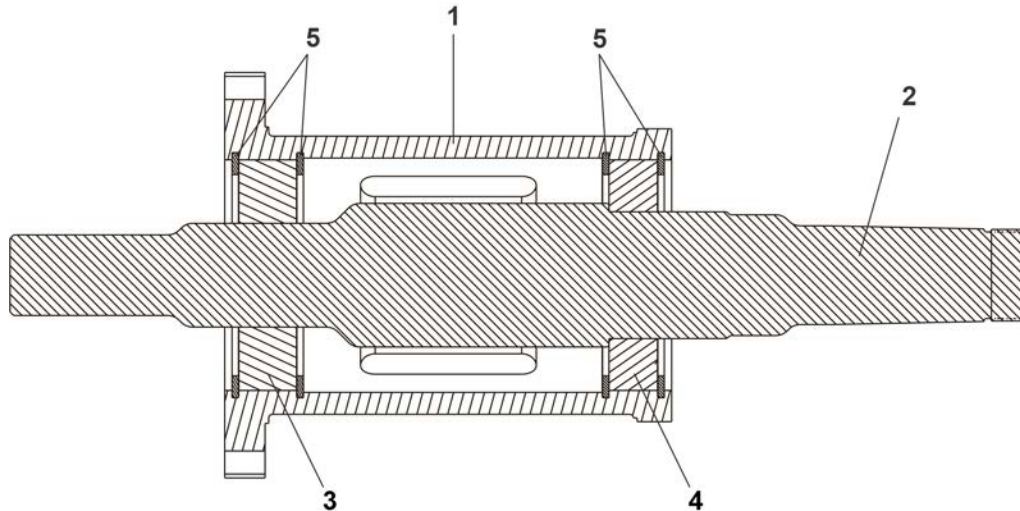
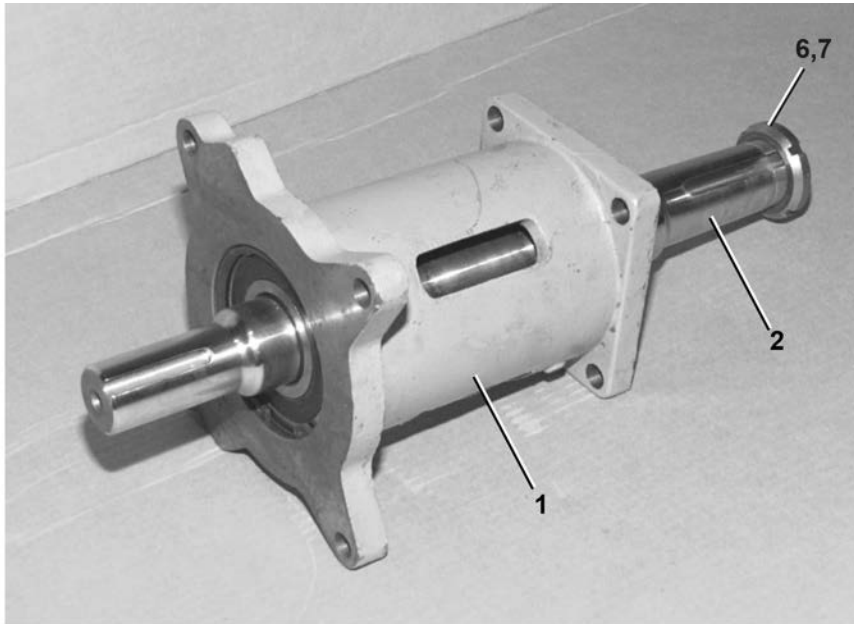
Find the assembly for your machine and the letter shown in the "Item" column. The components for your machine will show this letter or the word "all" in the "Used In" column. The numbers shown in the "Item" column are those shown in the illustrations.				
Used In	Item	Part Number	Description/Nomenclature	Comments
all	67	96M055	DELTROL QUICK EXHAUST VLV.1/4"	
all	68	5SP0GFFSSV	NPT PLUG 3/8 SQSOLIDVENTBLKSTL	
all	69	15K191	HXCAPSCR 1/2-13UNC2AX2.5 GR5 Z	
all	70	15U243	FLTWASHER 7/8ODX33/64IDX16GA Z	
all	71	15K182	HEXTAPSCR 1/2-13X2ZINC GR5 FUL	
all	72	07 71090	6458 BLOWER CUTOFF PLATE	
all	73	07 71026	SPACER=FUNNEL INLET CONE	

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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 41. 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	

5 Door Assemblies

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Load Door Installation

3 Sheets

6458TG1L/R, TS1L/R; 6464TG1L/R, TS1L/R; 7676TG1L/R, TS1L/R; 8282G1L/R

Figure 33. Door Installation

Legend

A . . . Top view
C . . . Lower cables and turnbuckles are shown to the inside, for visibility. They should be in-line with the upper cables.
D . . . From door lift brackets
E . . . Typical 7 places
F . . . For 7676 & 8282, see detail
G . . . Typical
H . . . Cable
J . . . Hose
K . . . Sleeve
L . . . Eyelet thimble
M . . . Door lift bracket

Removing Load Door

S1 . . 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.

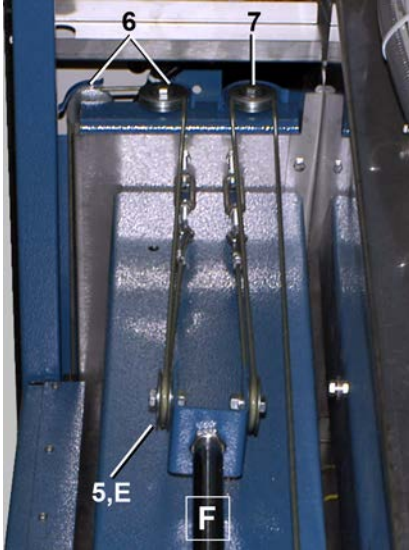
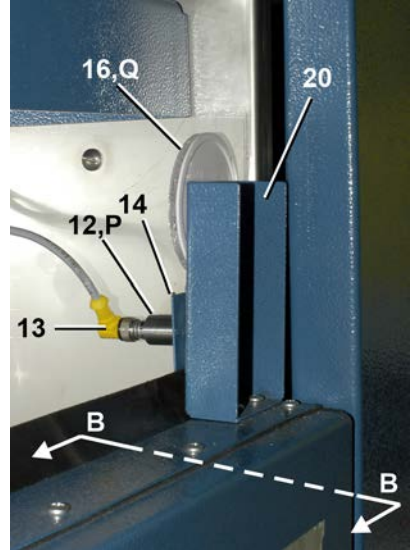
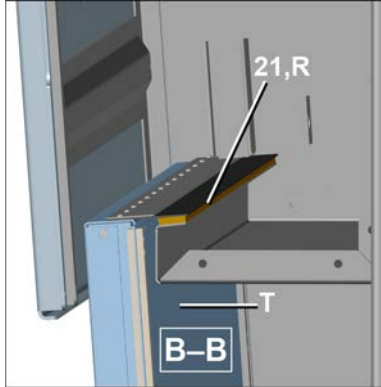
Reinstalling Load Door

S2 . . 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

3 Sheets

6458TG1L/R,TS1L/R; 6464TG1L/R,TS1L/R; 7676TG1L/R,TS1L/R; 8282G1L/R

6458 models built prior to 2014 	6458 models built 2014 & 6464, 7676, 8282 models 	Legend B-B . . Load door upper rest F . . Detail view for 7676 & 8282 N . . Full up photoeye P . . Full down proximity switch Q . . Target R . . Felt T . . Load door
		

Load Door Installation

3 Sheets

6458TG1L/R,TS1L/R; 6464TG1L/R,TS1L/R; 7676TG1L/R,TS1L/R; 8282G1L/R

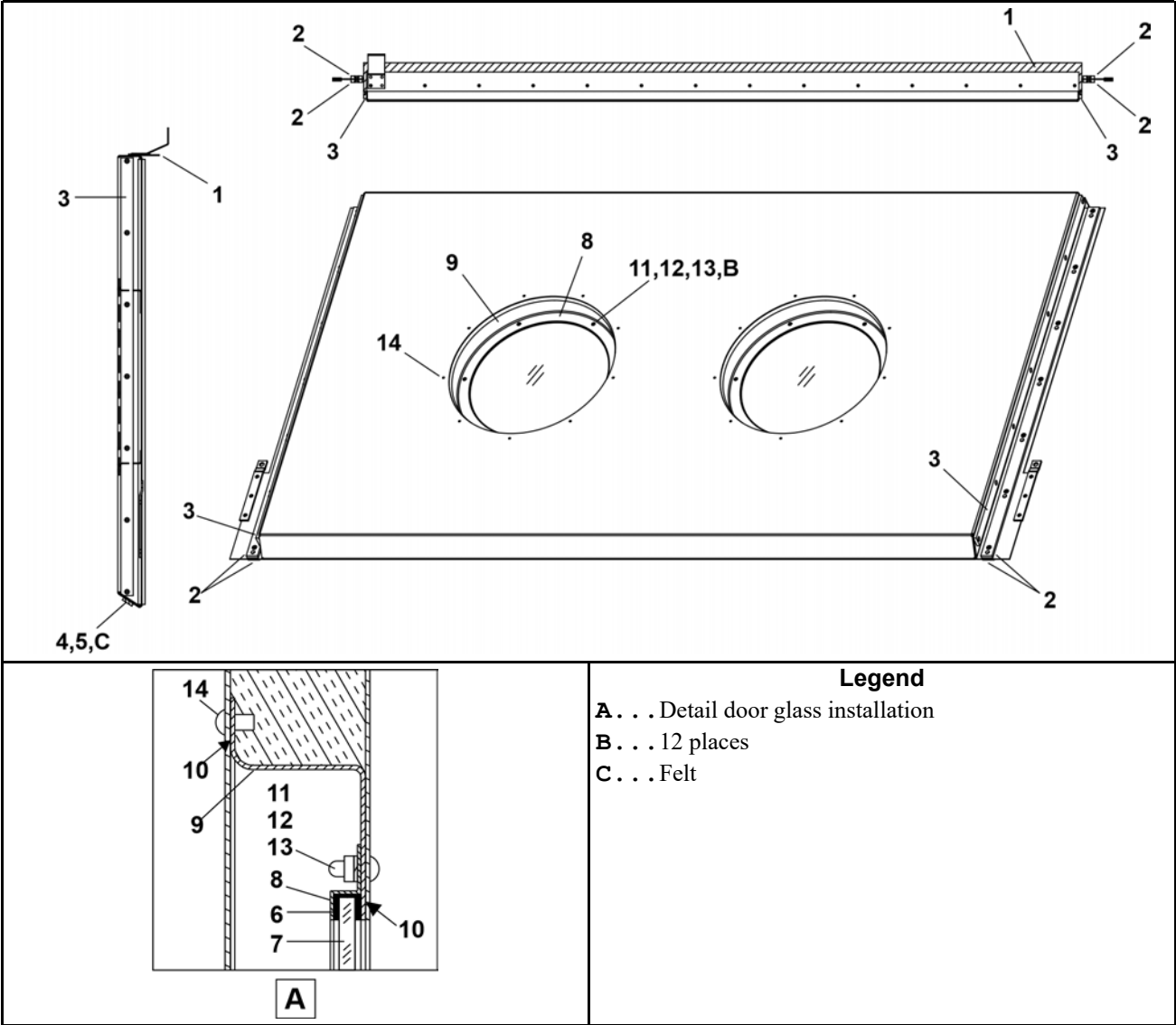
Table 42. Parts List—Load Door Installation

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	G77LD001D	6458 WIDE LOAD COSM INSTALL	6458 & 6464 DRYERS
	C	G79LD020	7676 LOAD COSM INSTALL	7676 DRYERS
	D	G82LD001	8282 LOAD COSMETIC INSTALL	8282 DRYERS
Components				
A	1	27C316	AIRCYL.3"BOREX16.5X.75PIVOT MT	
CD	1	27C416	AIR CYL 4"X16.5" STROKE	
all	2	96M055	DELTROL QUICK EXHAUST VLV.1/4"	
all	3	96H018	ANGLE NEEDLE VLV 1/4" T X 1/8MP	
A	4	07 40937	UHMW PULLEY GUIDE AIRCYL	
all	5	27A965	PULLEY ZINC PLATE #CPS6150	
all	6	W7 71197	6458 90 DEG PULLEY GRD WELD	
all	7	W7 71199	6458 180 DEG PULLEY GRD WELD	
A	8	27A964B	CABLE 3/32" 3095GN4 GALVANIZED	
CD	8	27A964	CABLE #3126-G-N-6	
A	9	27A963B	LOOP SLEEVE 3/32" 7092A	
CD	9	27A963	LOOP SLEEVE #7125-A	
A	10	27A962B	THIMBLE SS 3/32 AN100-4	
CD	10	27A962	THIMBLE #AN100-6	
all	11	17A074	TURNBCKLE 1/4X4 EYE+EYE ZINC	
A	12	09RPS30ADS	PROX SW QK CONN 30M NO-DC SHLD	
CD	12	09RPS18ADU	PRXSW QK CONN 18M NO-DC UNSHLD EUROFAST	
all	13	09RPSDC095	CON.90DEG FEMALE DC 3A300V 5M	
all	14	03 BL2X2A	BRACKET:PHOTOEYE 6458 DRYER	
all	15	07 80422	BRKT=LOAD DR PHOTO/PROX	
all	16	09RPE001A	REFLECTOR 3"DIA CLEAR	
all	17	09RPE011	PHOTOEYE VALU-BEAM 10-30DC	
all	18	03 E3X6A	ENCL:PHOTOEYE MOUNTING BOX	
all	19	03 E3X6B	PHOTOEYE COVER	
all	20	07 85422	BRKT=LOAD DR PHOTO/PROX TARGET TALL	
all	21	27A682	FELT 3/8"THK X 1"W SAE F-7	LOAD DOOR UPPER REST

Load Door

2 Sheets

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



Load Door

2 Sheets

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

Table 43. 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	A77LD001W	64" DRYER LOAD DOOR-WIDE	6458TG1L/R, TS1L/R 6464TG1L/R, TS1L/R
	B	A79LD002	7272 LOAD DOOR ASSY	7676TG1L/R 8282TG1L/R
Components				
A	1	07 71195A	64" DRYER WIDE LOAD DOOR TOP SEAL	
B	1	07 81195	7272 LOAD DOOR TOP SEAL	
A	2	07 81224A	7272 LD DR NYLON STRIP=SIDE	
B	2	07 81224	7272 LOAD DOOR NYLON STRIP	
all	3	07 81224A	7272 LD DR NYLON STRIP=SIDE	
all	4	27A682	FELT 3/8"THK X 1"W SAE F-7	
all	5	20C044	RUB/GASKET ADH 3M#EC1300 PINTS	
all	6	02 02366A	GASKET DOORGLASS = DRYER	
all	7	02 09215	DRGLASS 12 3/8DIA SS STAMPED	
all	8	07 50057	RING=SIGHGLASS LOAD DOOR	
all	9	07 71222	6458 LOAD DR SIGHT RING	
all	10	20C040B	SUPERFLEX CLR RTV SIL 10.1OZ	
all	11	15K031	BUTSOKCAPSCR 1/4-20X1/2 SS18-8	
all	12	15U181	LOCKWASHER MEDIUM 1/4 SS18-8	
all	13	15G140S	HEXCAPNUT(ACORN) 1/4-20 SS 18-	
all	14	15P050	TRDCUT-F PANHD 10-24X3/4 SS410	

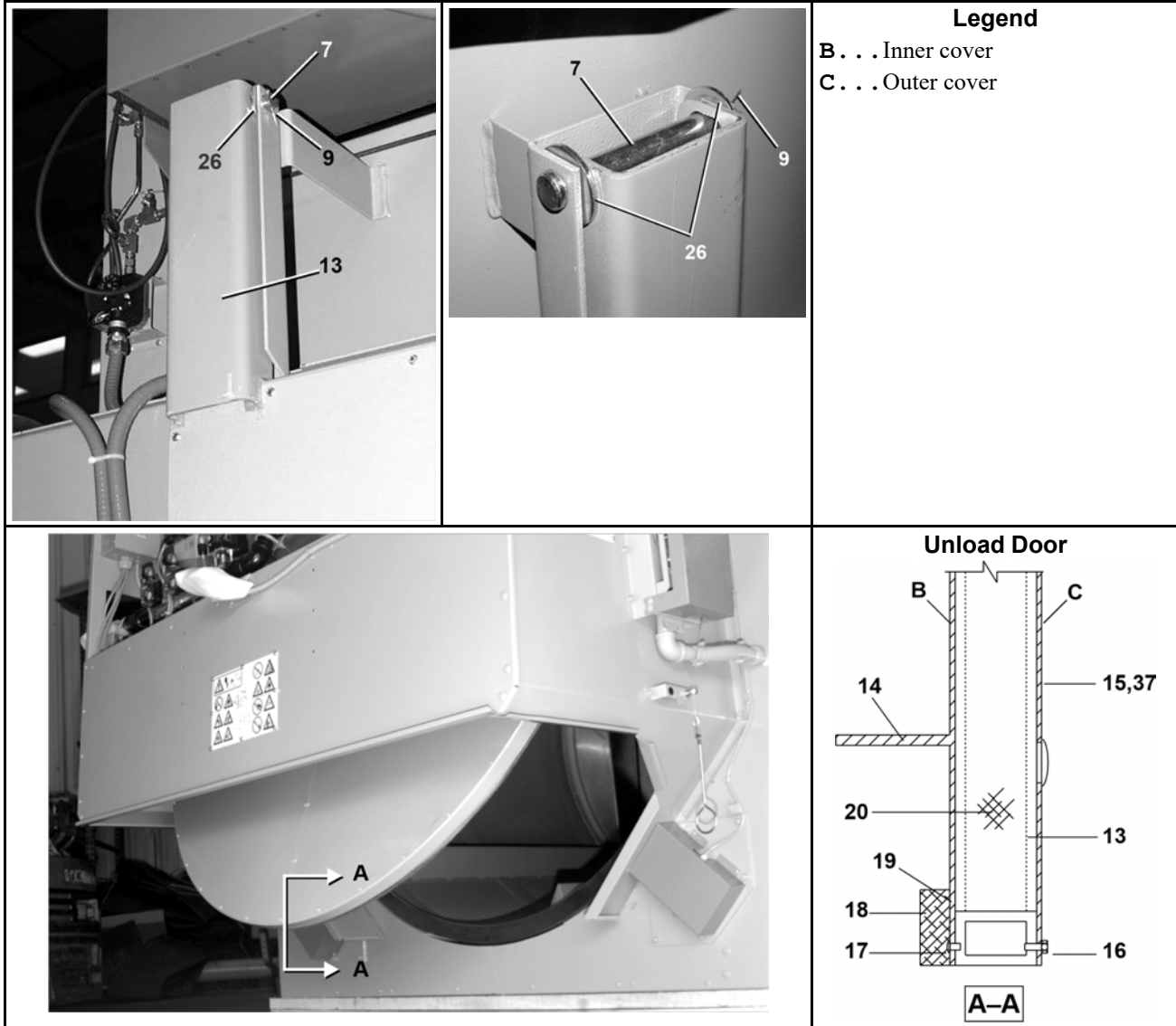
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Unload Door & Installation

4 Sheets

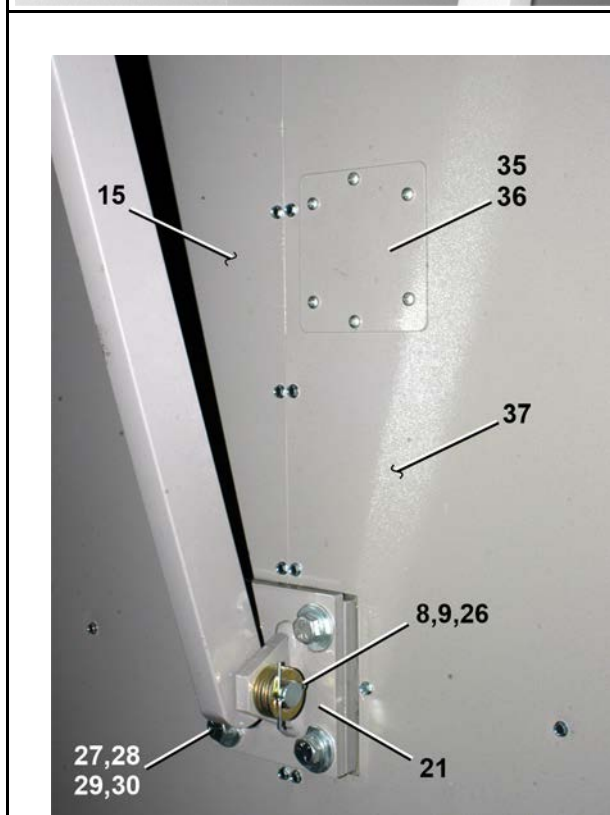
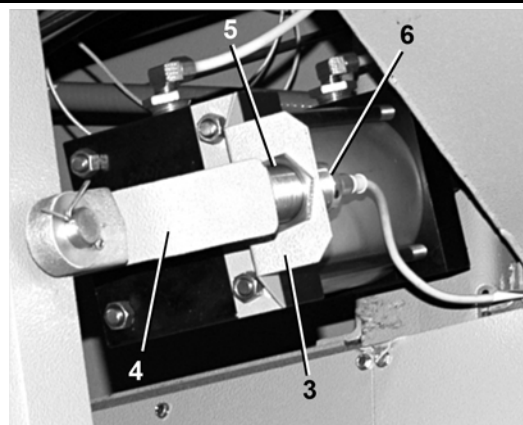
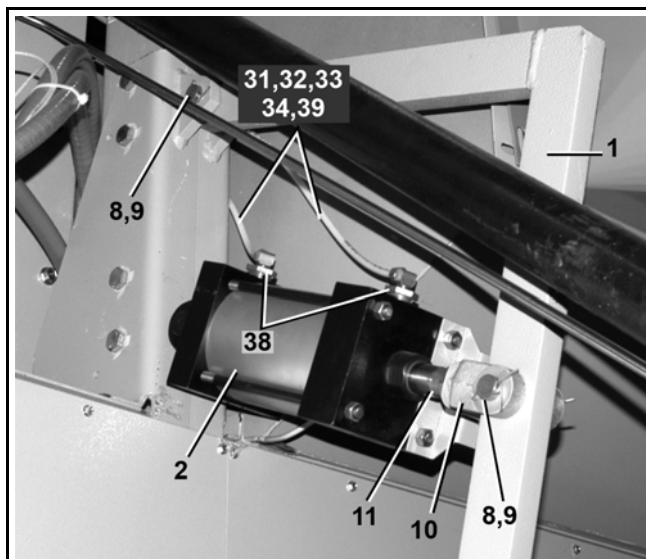
6458TG1L/R, TS1L/R; 6464TG1L/R, TS1L/R; 7676TG1L/R; 8282TG1L/R



Unload Door & Installation

4 Sheets

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



Optional IR Sensor

Unload Door & Installation

4 Sheets

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

Table 44. Parts List—Unload 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	A77SD010B	6458 UNLOAD DOOR ASSY	6458,6464
	D	A79UD020	7676 IR UNLOAD DOOR ASSY	7676
	E	A82UD001	8282 IR UNLOAD DOOR ASSY	8282
Components				
A	1	W7 71288	6458 UNLD DOOR HINGE ARM WELD	
D	1	W7 85288	7676 UNLD DOOR HINGE ARM WELD	
E	1	W7 88065	8282 UNLOAD DOOR HINGE ARM WELD	
AD	2	27C404	AIR CYL 4"X4.5"X1" CLEVIS MT.	
all	3	07 71132	6458 UNLOAD DOOR PROX BKT	
D	3	07 85132	7676 UNLOAD DOOR PROX BKT	
E	3	07 71132A	8282 UNLOAD DOOR PROX BKT	
all	4	07 71133	6458 UNLOAD DOOR PROX TARGET	
all	5	09RPS30CAS	PROXSW QK CONN 30M NO-AC SHLD	
all	6	09RPTAC005	CONN.ST.FEM 3-PIN AC 3A 5M	
all	7	17A044A	CLEVIS PIN 3/4X5+21/32 ZN SPEC	
all	8	17A045	CLEVIS PIN 3/4"X 3" DRILLED +	
all	9	15H051	STDCOTTERPIN 1/8X1+1/2ZINCPL	
all	10	17A049	YOKE END 3/4-16UNF HARD CHROME	
all	11	15G239S	HEXJAMNUT 3/4-16UNF2 SS18-8	
A	13	W7 71125A	6458 UNLOAD DR FRAME WELD	
D	13	W7 85125	7676 UNLOAD DOOR FRAME WELD	
E	13	W7 88055	8282 UNLOAD DOOR FRAME WLMT	
A	14	W7 71126B	6458 UNLD DOOR INNER SKIN WELD IR	
D	14	W7 85126B	7676 UNLD DR INNER SKIN WELD	
E	14	W7 88063	8282 UNLOAD DOOR INNER SKIN WELD	
A	15	07 71127	6458 INSL COVER UNLOAD DOOR	
D	15	07 85127	7676 INSL COVER UNLOAD DOOR	
E	15	07 88056	8282 UNLOAD DOOR INS COVER RIGHT	
all	16	15P059	SCRHXSELFDR:10-16X1/2 #2 ZINC	
A	17	15P052	10-16X3/4 T410 PH PAN TEK SC 3 PT S/S/ PRECOTE 80 PATCH	
D	17	15P053	8-18X3/4 PPHTKSSW/MICROSPHERE	
all	18	27A682	FELT 3/8"THK X 1"W SAE F-7	
all	19	20C044	RUB/GASKET ADH 3M#EC1300 PINTS	

Unload Door & Installation

4 Sheets

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

Table 44 Parts List—Unload 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	20	98P030	INSUL.FIBRGLS.24X48X1+1/2E=1SH	
all	21	W7 50047A	*LINKAGE ARM BASE BRKT WLMT	
all	22	15K105	HXCAPSCR 3/8-16UNC2A1.25 GR5 P	
all	23	15U255	LOCKWASHER MEDIUM 3/8 ZINCPL	
all	24	15G205	HXNUT 3/8-16UNC2B ZINC GR2	
all	25	15U343	FLATWASH 1X25/64X1/8 ZINC	
all	26	15U321H	FLTWASH 3/4 HARD ASTM F436	
all	27	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
all	28	15K173A	HXCAPSCR 1/2-13UNC2AX1.75 GR5	
all	29	15U300	LOKWASHER REGULAR 1/2 ZINC PLT	
all	30	15U280C	FLATWASH(US STD)1/2"CLIP+ZNC	
all	31	53A059A	NUT 1/4"BR.HOLYOKE AND #61A-4	
all	32	53A500	SLEEVE DELRIN 1/4"OD#60PT-4	
all	33	53A513	TUBE INSERT .120"ODX.539LG.	
all	34	60E004NTN	TUBING NYL(NAT)1/4"ODX.127ID	
all	35	07 44260	IR INNER UNLOAD DOOR COVER	
all	36	07 44261	IR OUTER UNLOAD DOOR COVER	
A	37	07 71127A	6458 INSL COVER UNLOAD DOOR IR	
D	37	07 85127A	7676 INSL COVER UNLOAD DOOR IR	
E	37	07 88056A	8282 UNLOAD DOOR INSUL COVER LEFT	
all	38	5SB0K0EBEO	NPTHEXBUSH 1/2X1/4 BRASS 125#	
all	39	53A031XB	BODY-EL90MALE.25X25 #269C-4-4B	

6 Vacuum Loading

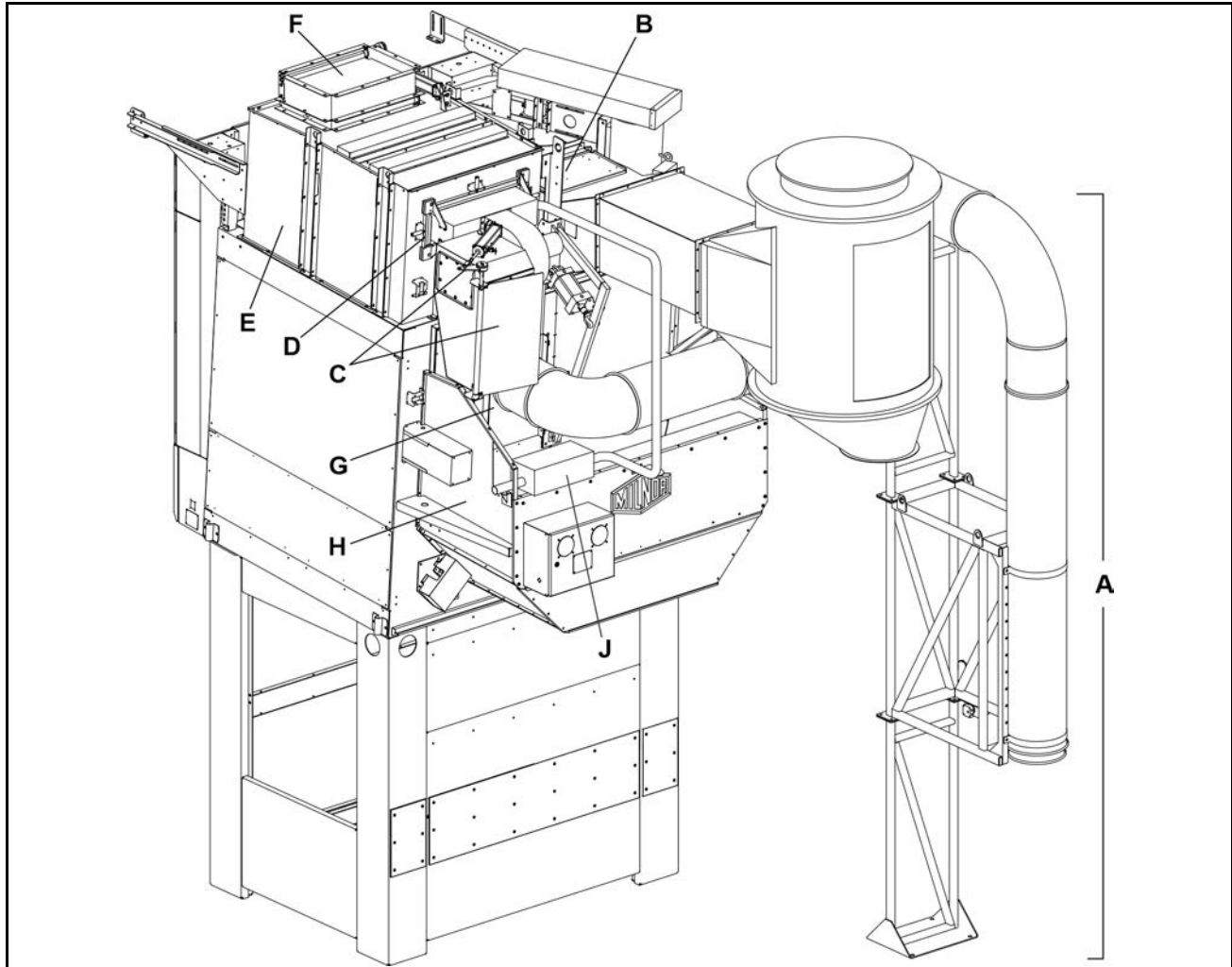
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Vacuum Loading Components

1 Sheet

6458TG1L, TG1R & 6464TG1L, TG1R AH Dryers



Legend

- A** . . . Vacuum loading frame, see BPDD6A02.
- B** . . . Blower exhaust duct damper, BMP000052.
- C** . . . Combustion box with damper, see BPDG6A02.
- D** . . . Burner seal dampers, see BPDG6A03.
- E** . . . Firebox burner, see BPDG6A06.
- F** . . . Firebox inlet damper, see BPDG6A04.
- G** . . . Unload door for vacuum loading, see BPDGA05.
- H** . . . Unload shroud for vacuum loading, BMP140052LO.
- J** . . . Gas piping for vacuum loading, BMP220025.

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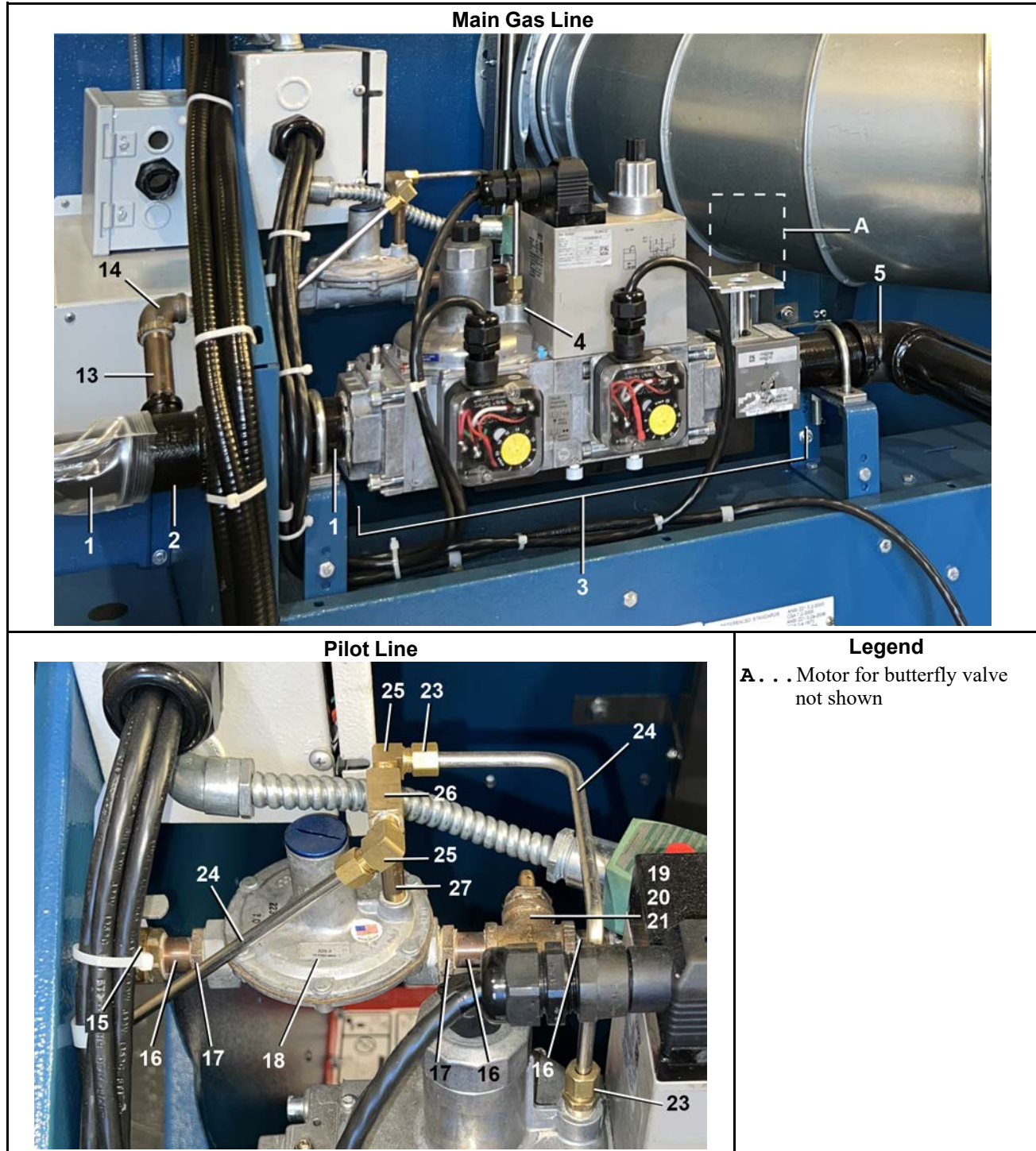
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CSA Gas Piping for Vacuum Loading

4 Sheets

6458TG1L,T1R; 6464TG1L,TG1R

Figure 34. Gas Train and Pilot Line



CSA Gas Piping for Vacuum Loading

4 Sheets

6458TG1L,T1R; 6464TG1L,TG1R

Figure 35. Gas Train and Pilot Line



CSA Gas Piping for Vacuum Loading

6458TG1L,T1R; 6464TG1L,TG1R

Table 45. Parts List—CSA Gas Piping for Vacuum Loading

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	A77VG011E	64" DRYER GAS TRAIN ENTRY SECTION VACUUM	
	B	A77VG014F	6458/64TG1L AH 2V-NOVENT=CSA SECTION VACUUM	
	C	A77VG015B	6458/64 AH GAS TRAIN VERT SECTION=CSA VACUUM	
	D	A77VG062C	6458/64 AH GAS TRAIN UPPER SECTION=CSA VACUUM	
	E	A77VG013	6458/64 PILOT GAS PIPE	
Components				
all	1	5N1K03AF42	NPT NIP 1.5X3" TBE BALMAL SCK40	
all	2	5S1KMFA0K	NPT TEE 1.5X1.5X1/2 BLKMAL150#	
all	3	A77VG020	1.5"VALTRAIN 2MILBTU LT TO RT UL795/CSA	
all	4	51T311	FLAMEARREST VNTSCREEN.375BRASS	
all	5	5SL1KMFA	NPT ELB 90DEG 1.5 BLKMAL 150#	
all	6	5N1K15EF42	NPT NIP 1.5X15.25" TBE BALSTL SCH40	
all	7	5N1K04AF42	NPT NIP 1.5X4 TBE BLKSTL SK40	
all	8	5SU1KMF	NPT UNION 1.5" BLKMAL 150#	
all	9	96G150C	1.5"GAS STOP VAL - RESUN #R	
all	10	5N1K33KF42	NPT NIP 1.5X33.5" TBE BALSTL SCH40	
all	11	5N1K42AF42	NPT NIP 1.5X42" TBE BLK SCH40	
all	12	5N1K02KF42	NPT NIP 1.5X2.5" TBE BALSTL SCH40	
all	13	5N0K03KB42	NPT NIP 1/2X3.5 TBE BRASS STD	
all	14	5SL0KBEA0G	NPT ELB 90DEG 1/2X3/8 BRASS 125	
all	15	96G030	3/8"GAS BALL VLV/ T- HANDLE	
all	16	5N0G01KBE2	3/8" X 1.5"BRASSNIPPLE TBE	
all	17	5SB0K0GBEO	NPTHEXBUSH 1/2X3/8 BRASS 125#	
all	18	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C-	
all	19	5S0GBEA	NPT TEE 3/8" BRASS 125#	
all	20	5SB0G0EBEO	NPTHEXBUSH 3/8X1/4 BRASS 125#	
all	21	96G0001	GAS TEST PORT	
all	23	53A008B	BODYMALECON.25X.25COMP#B68A-4B	
all	24	87Z00EX035	TUBE=1/4"ODX.035WL 316LSS*20RM	
all	25	53A031B	BODY-EL90MALE.25X1/8 #269C-42B	
all	26	51V010A	TEE 1/8"BRSEXTR BLOCTYP#2203P2	
all	27	5N0C02ABE2	NPT NIP 1/8X2 TBE BRASS STD	
all	28	96TCC2BA37	3/8" N/C 2WAY 120V50/60C VALVE	

CSA Gas Piping for Vacuum Loading

4 Sheets

6458TG1L,T1R; 6464TG1L,TG1R

Table 45 Parts List—CSA Gas Piping for Vacuum Loading (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	29	53A026	BODYMALECON3/8X3/8 #68C-6-6B	
all	30	87Z010	TUBE 3/8"ODX.035" SS304 *20RM	
all	31	53A023	MALECON3/8X.25COMP ANCHR#68-64	
all	32	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL # 55-302-01	
all	33	51V015	TEE 1/4 FGDBRASS 101T7-444	
all	34	53A044	EL90 3/8TXMP AND#69A-6C	
all	35	51P013	PLUG HXCNTRSUNK 1/4"BRASS	

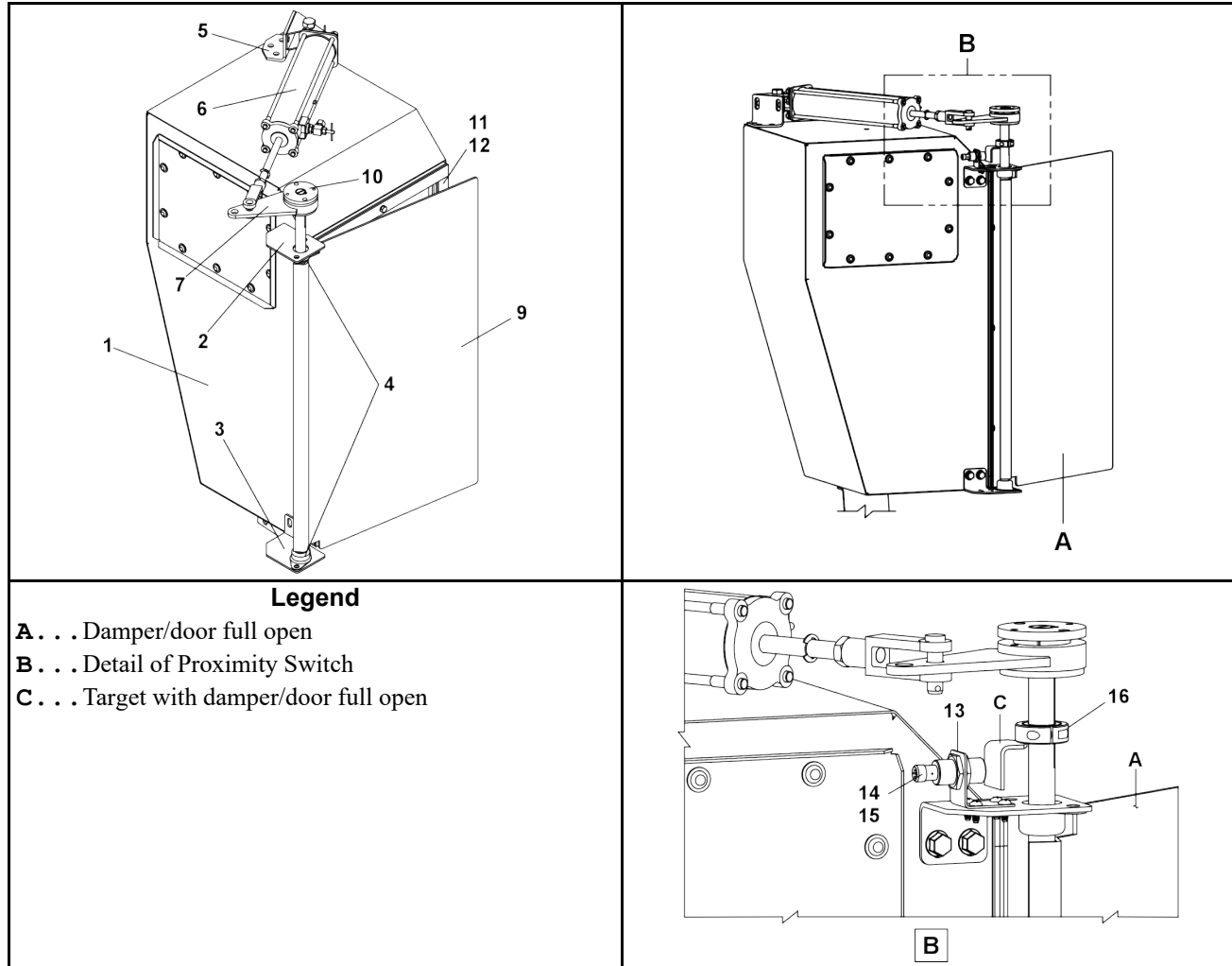
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Combustion Box with Damper Vacuum Loading

2 Sheet

6458TG1L, TG1R, 6464TG1L, TG1R

**Table 46. Parts List—Combustion Box with Damper Vacuum Dryer**

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	A77VC003	6458 LF VAC LOADING COMB BOX AMBLY	Reference
	B	KTN77PX003	6458/64 VAC PROX KIT — FILTEBOX AH	Contains items 13–15
Components				
all	1	A77FB003A	64" DRYER LF AIR HEAT BRNR FILTERBOX ASSEMBLY	
all	2	07 44367	DRYER VAC LOADING COMB BOX BUSH BRKT 1	
all	3	07 44367A	DRYER VAC LOADING COMB BOX BUSH BRKT 2	
all	4	54E015	FLGMTBRG 3/4 BORE BRZ #FLB12	

Combustion Box with Damper for Vacuum Loading

2 Sheet

6458TG1L, TG1R, 6464TG1L, TG1R

Table 46 Parts List—Combustion Box with Damper Vacuum Dryer (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	5	07 44368	DRYER VAC LOADING COMB BOX AIR CYL BRKT	
all	6	A40 01800	* AIRCYL, 2-WAY 7.13 STK	
all	7	W7 71098B	6458 BLWR DAMP ARM WELD HORZ	
all	9	W7 44369	6458 LF VAC LOADING COMB BOX DAMPER WLMT	
all	10	56Q0PH	3/4" BROWNING H BUSHING TYPE 1	
all	11	W7 71035	WLMT=6458 COMB AIR SCREEN	
all	12	60A006B	NEO RUBBER STRIP 1/4"X1"W/PSA	
all	13	07 443656	64" DRYER VAC AH FILTER BOX PROX MNT	
all	14	09RPS18ADW	PROX SW QK CONN 18M NO-DC UNSHLD EUROFAST PNP OUTPUT	
all	15	09RPSC010	CONN.STR FEMALE DC 3A 300V 10M RK4T-10 - EUROFAST	
all	16	W7 443655	64" DRYER VAC AH INLET PROX TARGET WLMT	

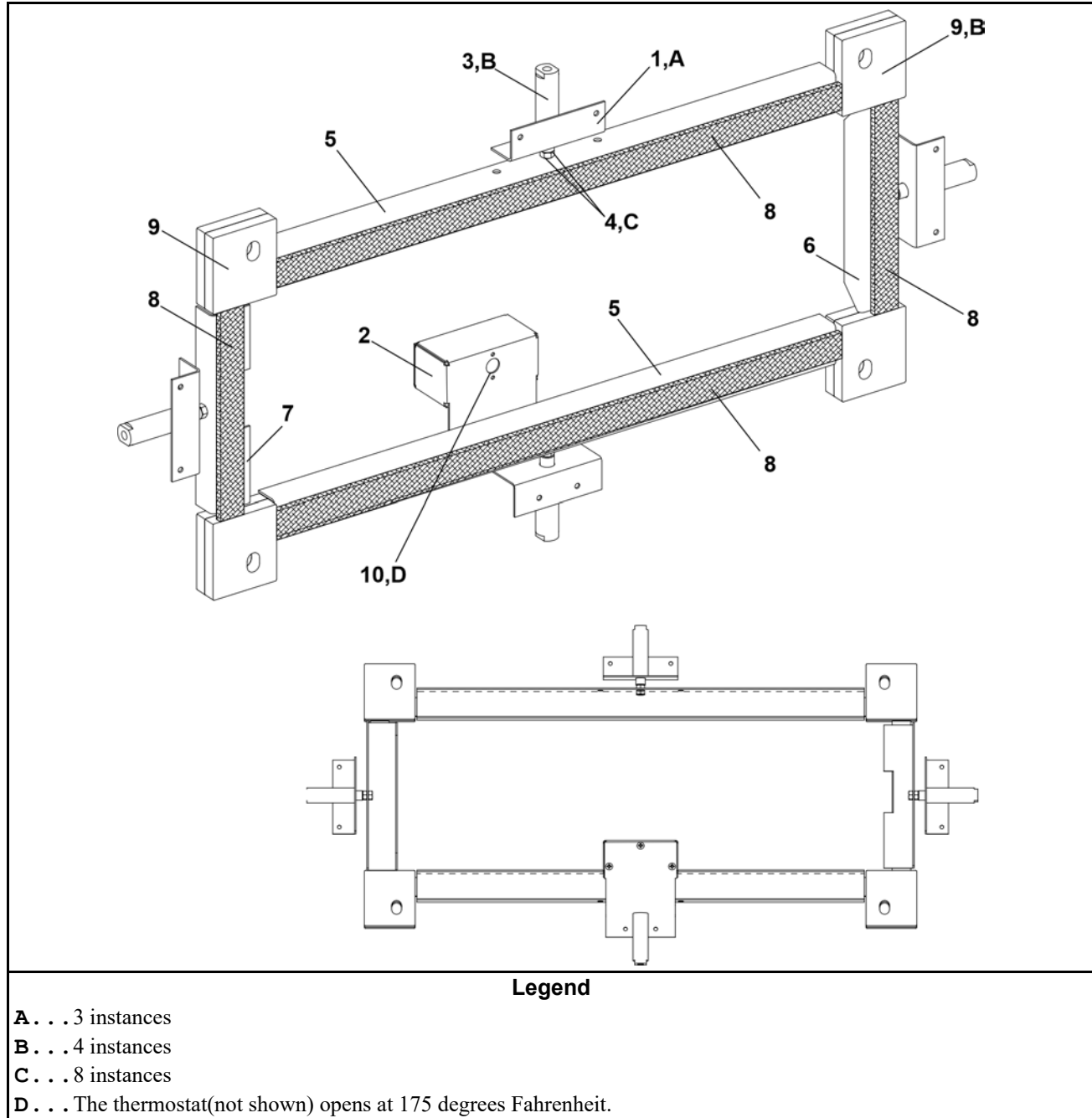
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Burner Seal Dampers for Vacuum Loading

2 Sheet

6458TG1L, TG1R, 6464TG1, TG1R



Burner Seal Dampers for Vacuum Loading

2 Sheet

6458TG1L, TG1R, 6464TG1, TG1R

Table 47. Parts List—Burner Seal Dampers

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	G77VC004	6458 VAC LOADING BRNR CVR INSTALL	
Components				
all	1	07 44 126	6458 VAC LOADING BRNR AIR CYL BRKT	
all	2	A77VC005	DRYER VAC LOADING THERMO BOX	
all	3	27C205	AIRCYL 3/4"BORE X 1"STROKE	
all	4	15G176	HEXNUT 1/4-28 UNF SS 18-8	
all	5	07 44 127C	6458 VAC LOADING BRNR CVR BRKT	
all	6	07 44 127	6458 VAC LOADING BRNR OUTR CVR BRKT	
all	7	07 44 127B	6458 VAC LOADING BRNR INNR CVR BRKT	
all	8	27A680	FELT 1/4"THK X 1"W SAE F-7	
all	9	W7 71067E	6458/64 VAC LOADING BRNR SUPP BKT SPACER WLMT	
all	10	30RA175T	THERMOSTAT OPENS AT 175F	

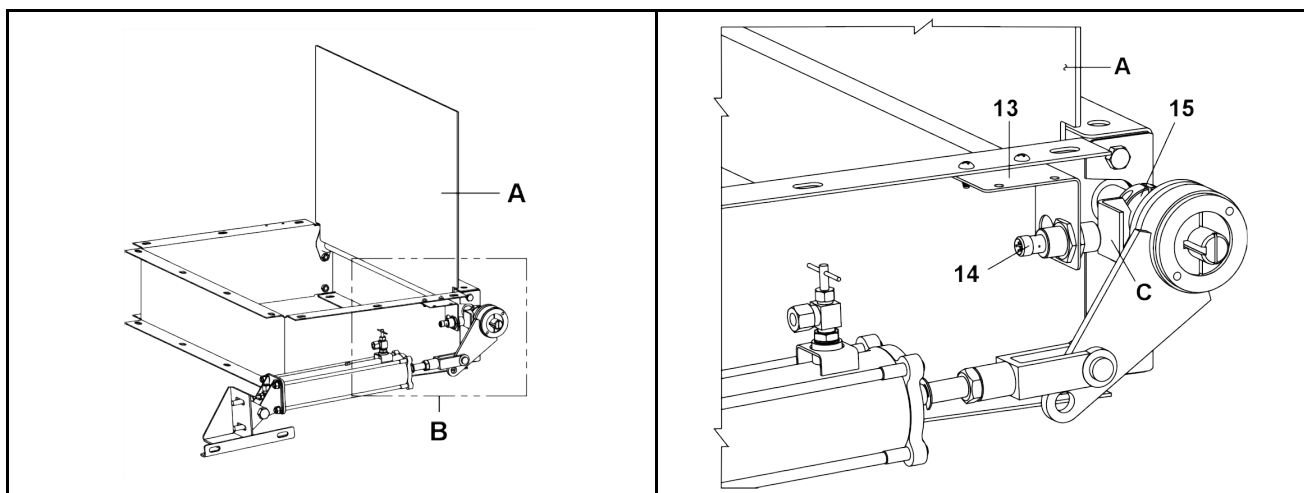
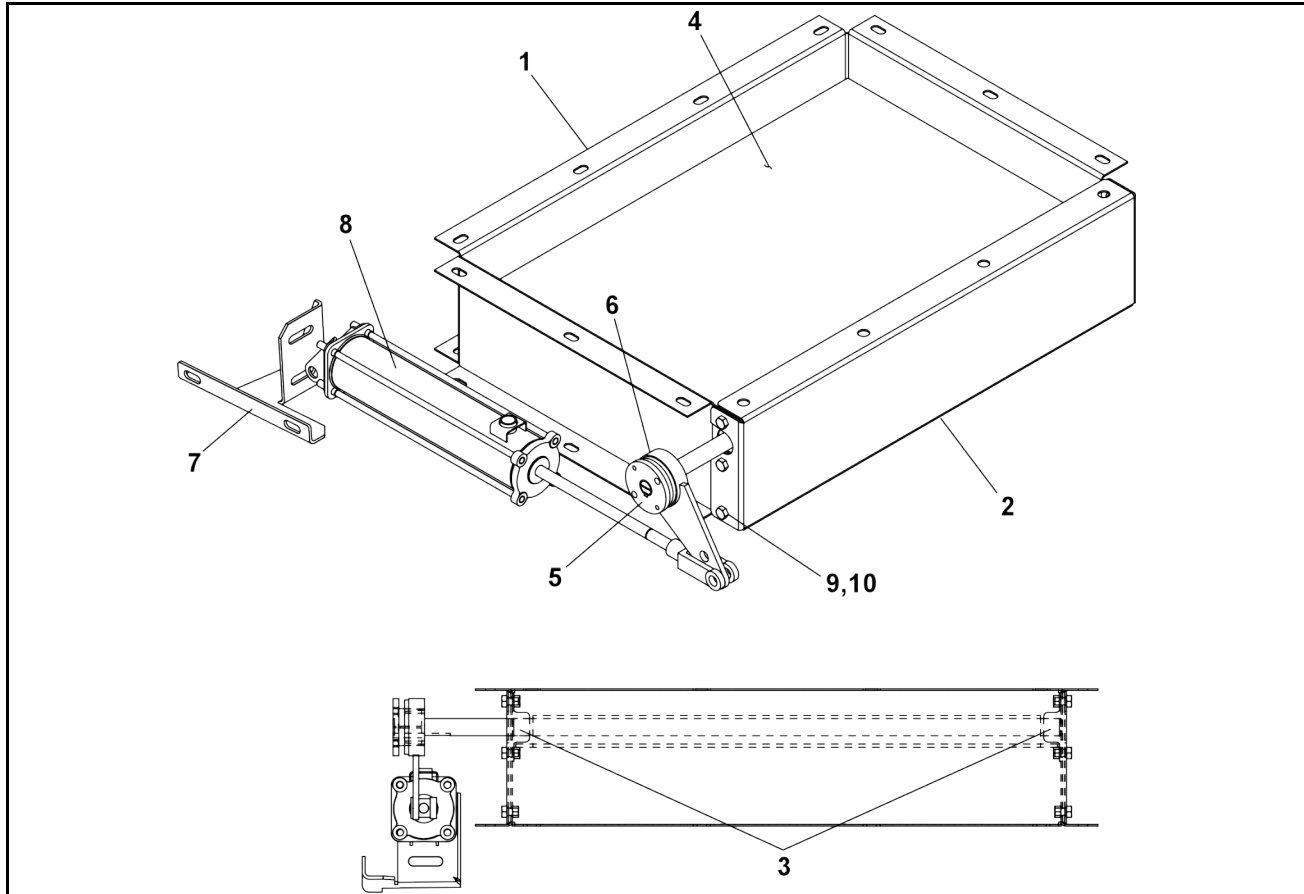
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Firebox Inlet Damper for Vacuum Loading

2 Sheet

6458TG1L, TG1R, 6464TG1L, TG1R



Firebox Inlet Damper for Vacuum Loading

2 Sheet

6458TG1L, TG1R, 6464TG1L, TG1R

Legend	
A . . . Damper full open	
B . . . Detail Proximity Switch	
C . . . Target when damper full open	

Table 48. Parts List—Firebox Inlet Damper for Vacuum Loading

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	A77VC001	6458 LF VAC LOADING FB INLT DAMPER ASMBLY	TG1L
	B	A77VC001A	6458 RT VAC LOADING FB INLT DAMPER ASMBLY	TG1R
	C	G77PX001	6458/64 VAC PROX INSTALL - FB INLET AH	Contains items 13–15
Components				
all	1	07 44360A	6458 VAC LOADING INLT FENWAL DUCT SIDE	
all	2	07 44361A	6458 VAC LOADING INLET FENWAL BACK	
all	3	54E015	FLGMTBRG 3/4 BORE BRZ #FLB12	
A	4	W7 44362D	6458 LF VAC LOADING INLET DAMPER WLMT	
B	4	W7 44362C	6458 RT VAC LOADING INLET DAMPER	
all	5	56Q0PH	3/4" BROWNING H BUSHING TYPE 1	
all	6	W7 71098B	6458 BLWR DAMP ARM WELD HORZ	
A	7	07 44366B	6458/64 VAC LOADING INLET AIR CYL BRKT	
B	7	07 44366C	6458/64 VAC LOADING INLET AIR CYL BRKT OPP	
all	8	A40 01800	* AIRCYL, 2-WAY 7.13 STK=52DRYELL	
all	9	15K050	HXCAPSCR 5/16-18UNC2AX1/2 GR5 ZN	
all	10	15G185	HXNUT 5/16-18UNC2B SAE ZINC GR	
all	11	15K085	HEXCAPSCR 3/8-16UNC2AX3/4 GR5	
all	12	15G198	HXFLGNUT 3/8-16 ZINC	
all	13	07 443654	64" DRYER VAC AH INLET PROX MNT	
all	14	09RPS18ADW	PROX SW QK CONN 18M NO-DC UNSHLD EUROFAST PNP OUTPUT	
all	15	W7 443655	64" DRYER VAC AH INLET PROX TARGET WLMT	

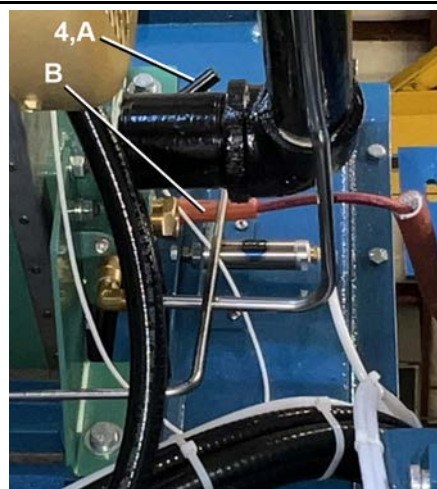
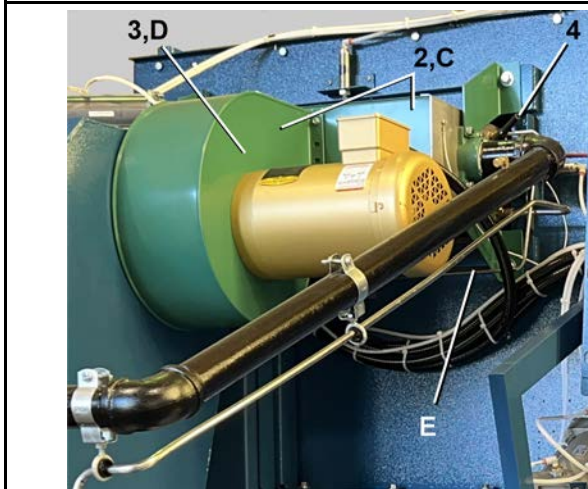
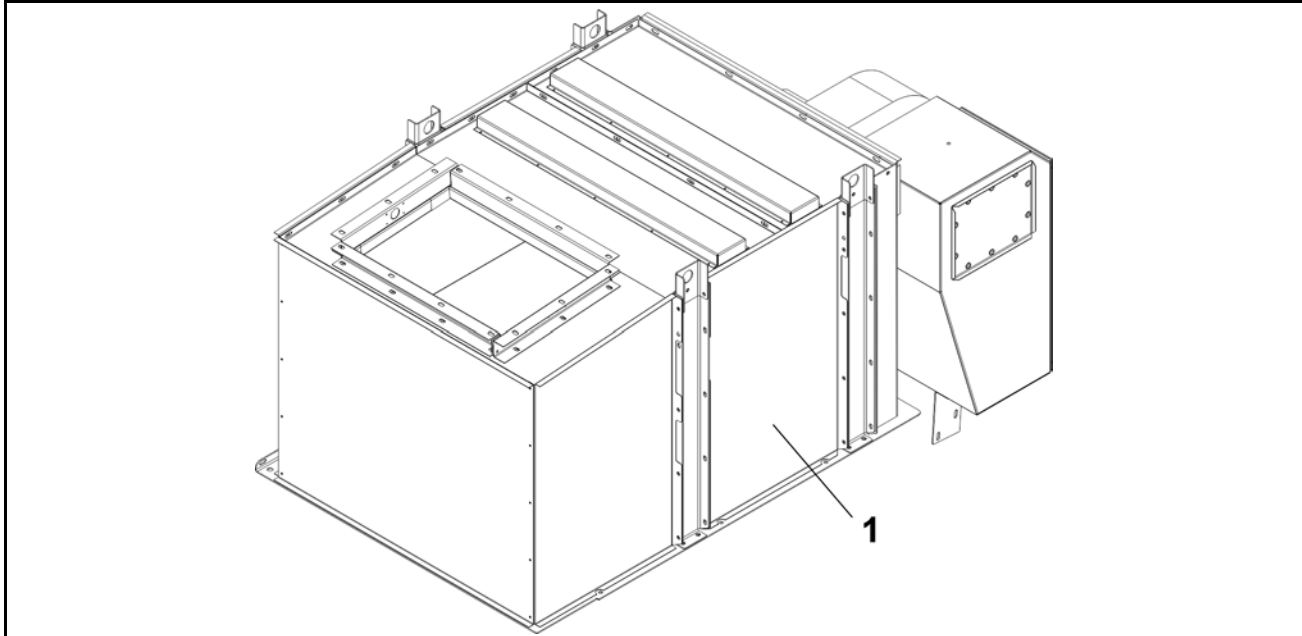
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Firebox and Burner for Vacuum Loading

3 Sheet

6458TG1L,TG1R, 6464TG1L,TG1R



Legend

- A . . . Spark plug
- B . . . Flame rod, comes with burner
- C . . . Burner, includes burner blower wheel
- D . . . Burner blower wheel
- E . . . To Combustion gas pressure switch

Firebox and Burner for Vacuum Loading

3 Sheet

6458TG1L,TG1R, 6464TG1L,TG1R



Legend

- E** . . . To combustion gas pressure switch
F . . . Combustion (burner) gas pressure switch
G . . . Firebox air pressure switch

Table 49. Parts List—Firebox and Burner

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	G77FB006	6458/64 AH FIREBOX INSTALL LF	TG1L
	B	G77FB006A	6458/64 AH FIREBOX INSTALL RT	TG1R
	C	A77FB003	64" DRYER AH BURNER ASSY	
Components				
all	1	A77FB006	6458/64 AH FIREBOX ASSY LF	TG1L
all	1	A77FB006A	6458/64 AH FIREBOX ASSY RT	TG1R
all	2	25AB242	64" AH DRYER: BURNER/BLW WHEEL 160AH 2MLW/201AH	
all	3	25AB242BW	BLOWER WHEEL FOR 160AH 240AH BNR	

Firebox and Burner for Vacuum Loading

3 Sheet

6458TG1L,TG1R, 6464TG1L,TG1R

Table 49 Parts List—Firebox and Burner (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	4	25AS004	ECLIPSE SPARK PLUG #13047	
all	5	09N19106B	GAS PRESS SW RANGE .2-2.4"WC	
all	6	09N19111	AIR PRESSW RANGE .08-.4	
all	7	W7 71558	WLMT=6458 DIFFUSER BLOW TUBE	

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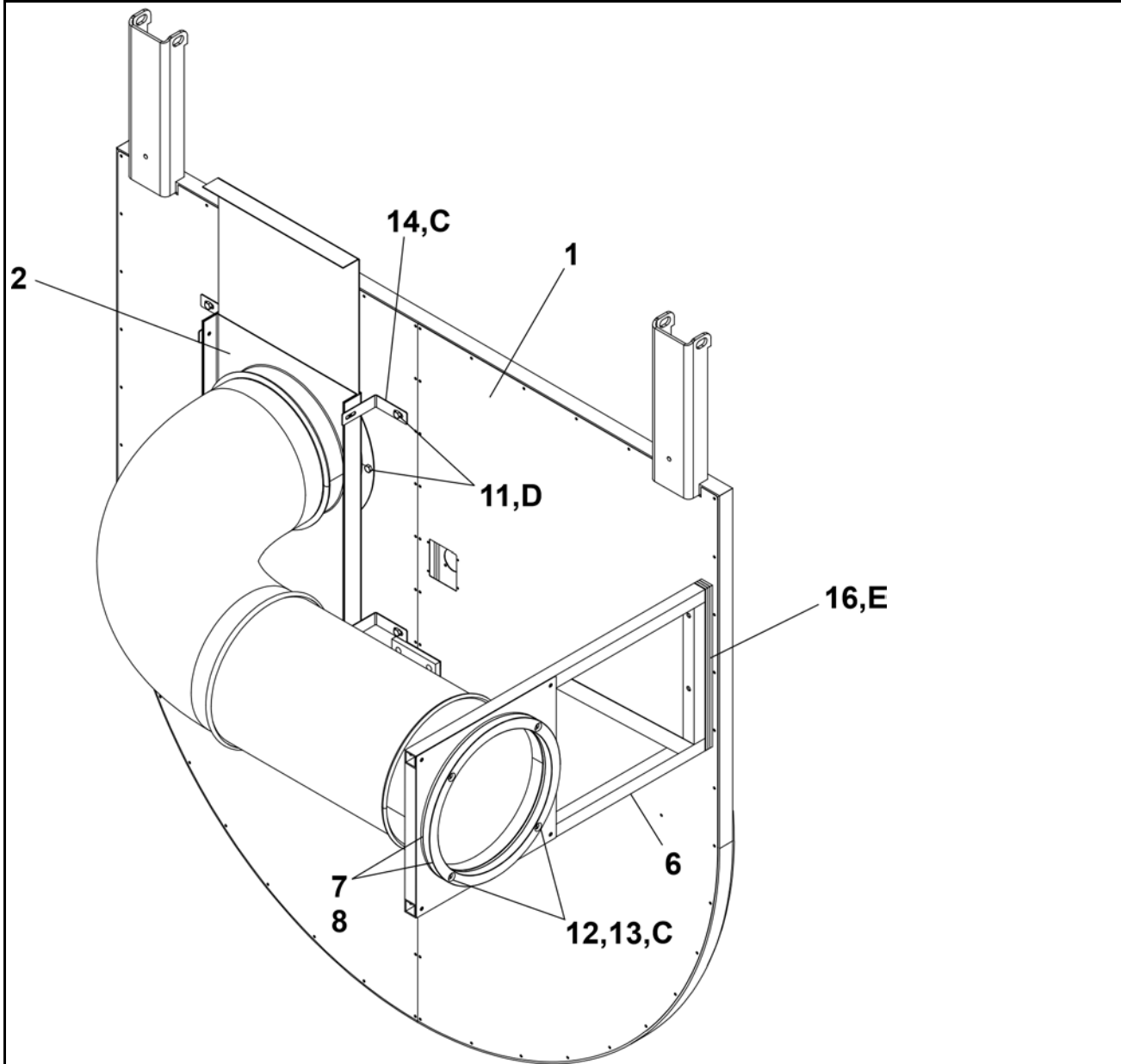
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Unload Door for Vacuum Loading

4 Sheet

6458TG1L,TG1R, 6464TG1L,TG1R



Legend

C . . . 4 instances

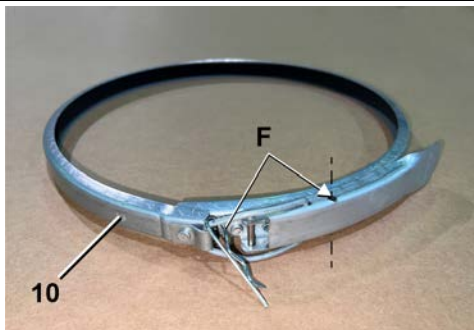
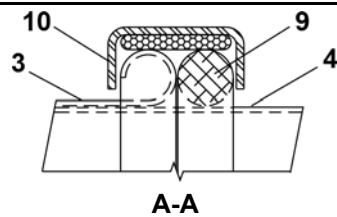
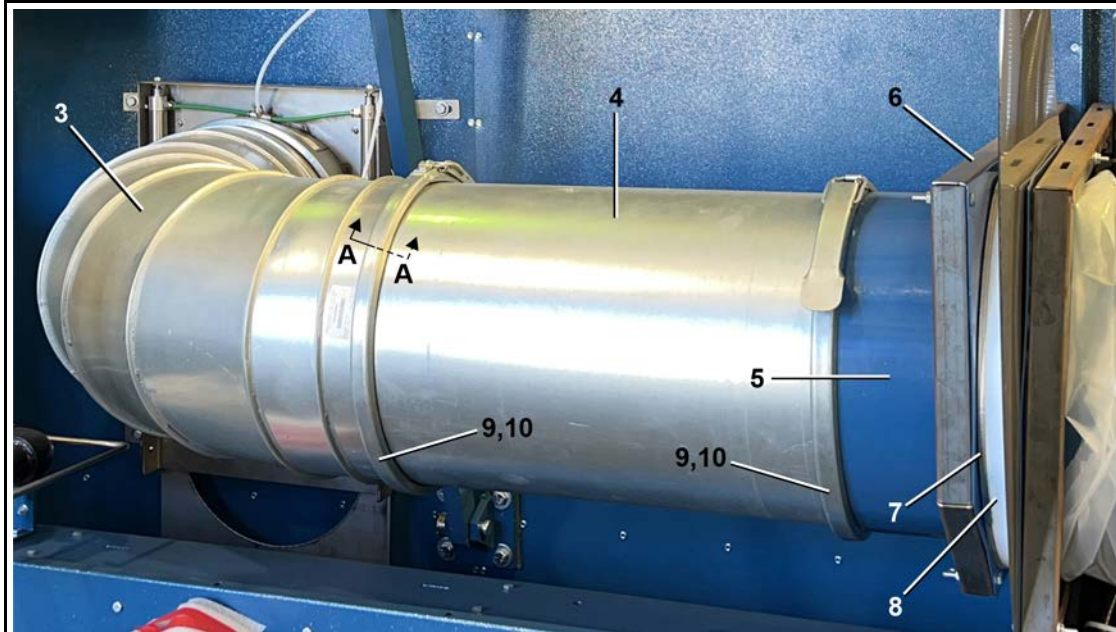
D . . . 12 instances

E . . . Shim until the duct aligns with the stationary frame.

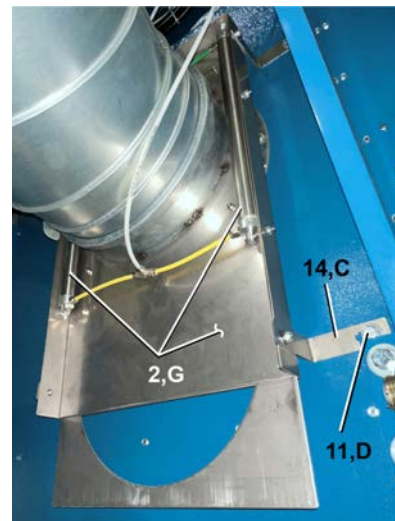
Unload Door For Vacuum Loading

4 Sheet

6458TG1L,TG1R, 6464TG1L,TG1R



Duct Clamp with Pin and Gasket



Blast Gate

Legend

A-A . . Example duct to duct connection

C . . . 4 instances

D . . . 12 instances

E . . . Shim until the duct aligns with the stationary frame.

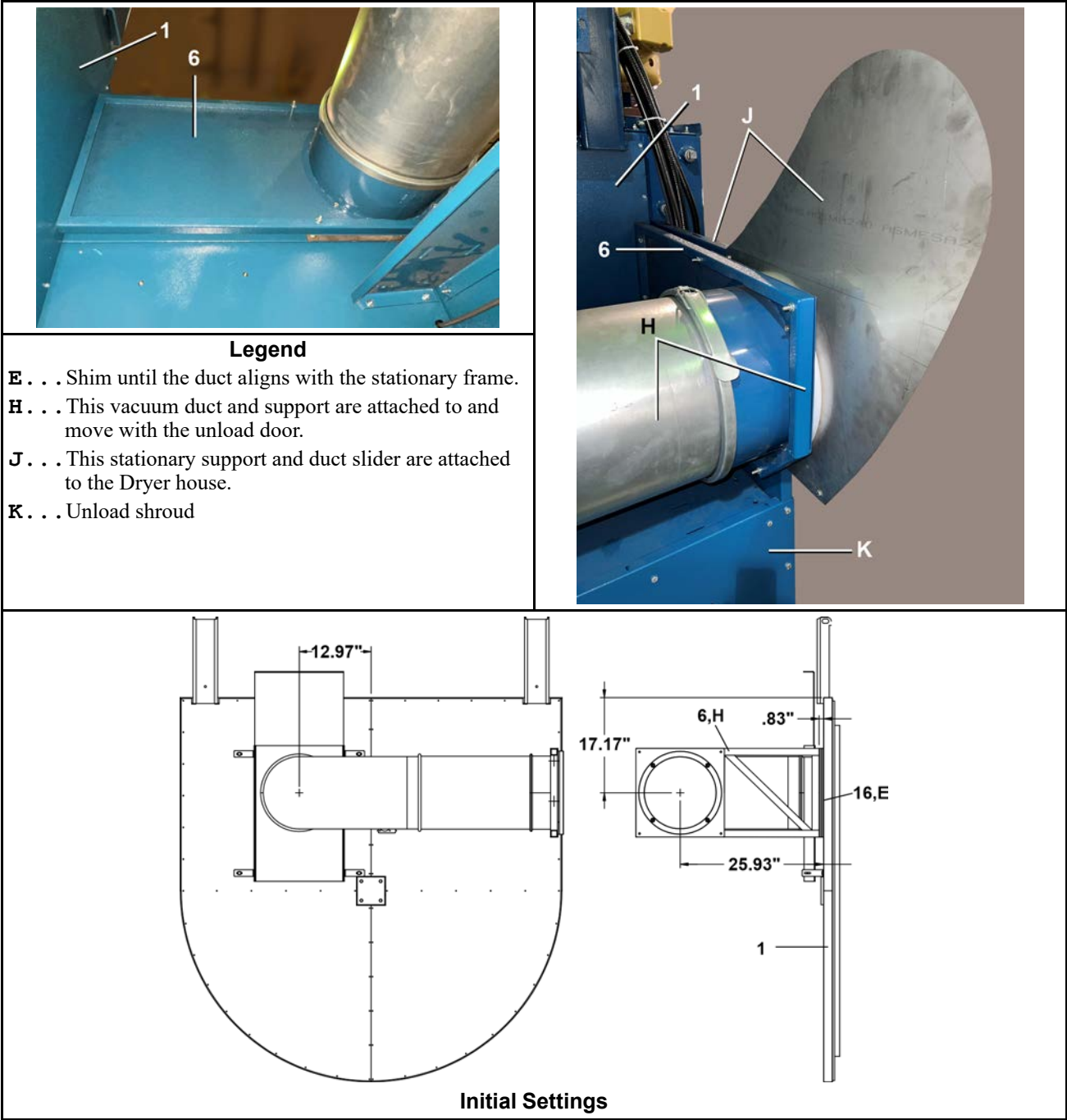
F . . . Insert the pin in the hole to lock. The locking pin and gasket come with the duct clamp.

G . . . The blast gate includes the pneumatic cylinders and tubing.

Unload Door For Vacuum Loading

4 Sheet

6458TG1L,TG1R, 6464TG1L,TG1R



Unload Door For Vacuum Loading

4 Sheet

6458TG1L,TG1R, 6464TG1L,TG1R

Table 50. Parts List—Unload Door Vacuum Loading

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	G77VC002	64" DRYER LF VAC LOADING UNLOAD DR W/ DUCTING	
Components				
all	1	A77SD010C	6458 LF VAC LOADING UNLOAD DOOR ASSY	
all	2	SKU000121	13" BLAST GATE	
all	3	6SL13G1A901K	13" GALV. QF ELBOW 90DEG 20GA 1.50 CLR 2.00TAN	
all	4	6N13G24AC	QF DUCT CUT 24" LG 20 GA	
all	5	W7 711251	DRYER VAC LOADING DUCT FLANGE WELD	
all	6	07 711251D	64" DRYER LF VAC LOADING FRAME DYN V2	
all	7	07 71125DRD	DRYER VAC LOADING DYNAMIC DUCT RING DOUBLER	
all	8	07 71125DR	DRYER VAC LOADING DYNAMIC DUCT RING	
all	9	60C188N	ORING 13.0ID BLACK NITRILE - QF DUCTING	
all	10	6A13G	13" GALV. QF CLAMP W/ PIN & NITRILE SEAL	
all	11	15K085	HEXCAPSCR 3/8-16UNC2AX3/4 GR5	
all	12	15N195A	FLATMACSCR 1/4-20NC2X1+1/4 SS1	
all	13	15G166A	HXLK NUT NYL 1/4-20 UNC2A STL/Z	
all	14	EXPJA0031AA	DRYER VAC LOADING GATE THIN BRKT	
all	15	96PVQC24T	QUICK CONNECT FITTING 1/4" TUBING TEE	
all	16	07 71125VBS	6458 VAC LOADING FRAME 1/4" SHIM	

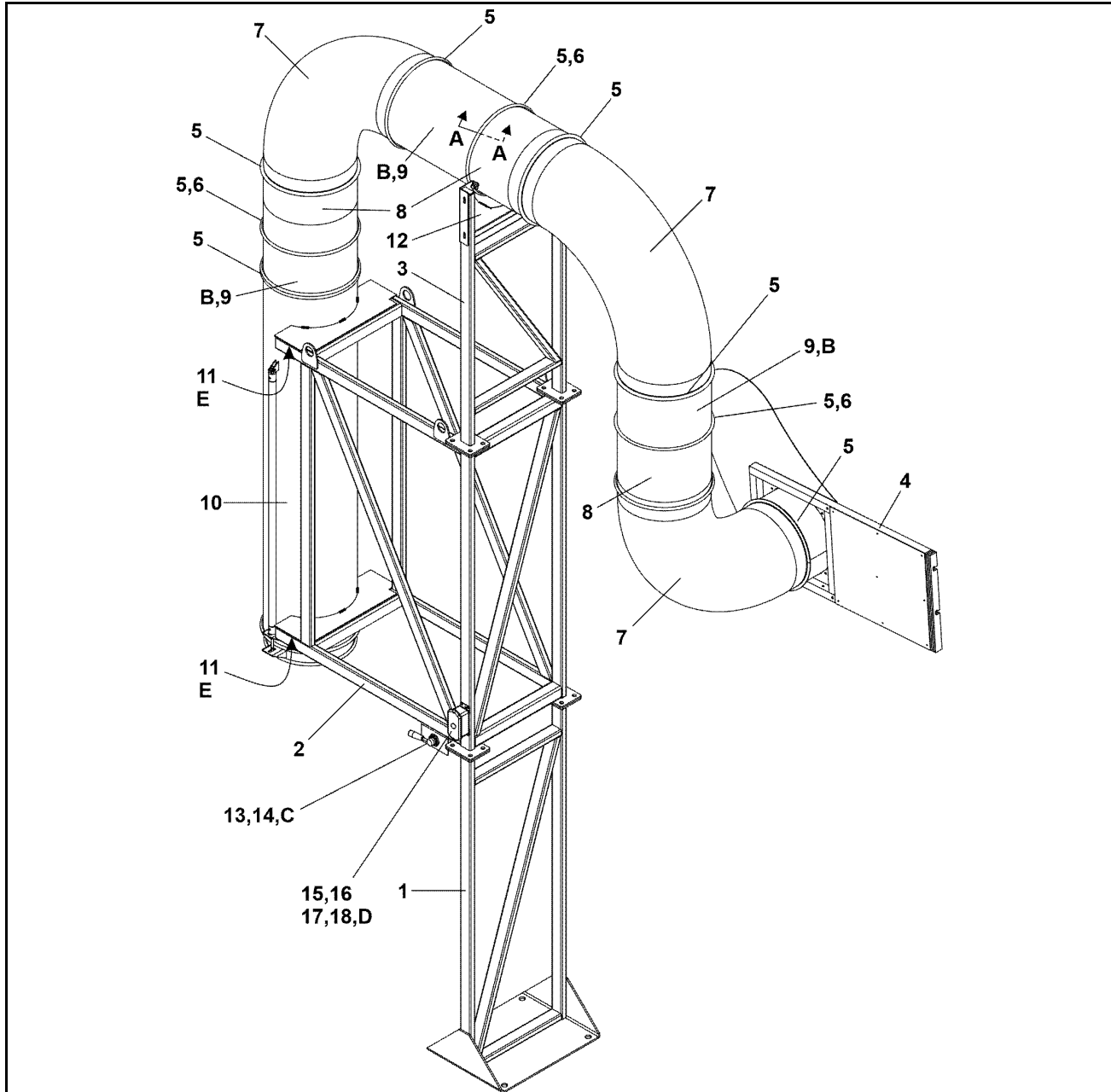
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Vacuum Loading Frame

3 Sheet

6458TG1L, TG1R, 6464TG1L, TG1R.



Legend

- B . . .** Duct lengths vary, consult Milnor factory.
- C . . .** Manual pneumatic switch to raise and lower the vacuum nozzle
- D . . .** Automatic/Manual switch for vacuum loading
- E . . .** Extension shims are used to adapt the nozzle mounting flanges to the frame.

Vacuum Loading Frame

3 Sheet

6458TG1L, TG1R, 6464TG1L, TG1R.

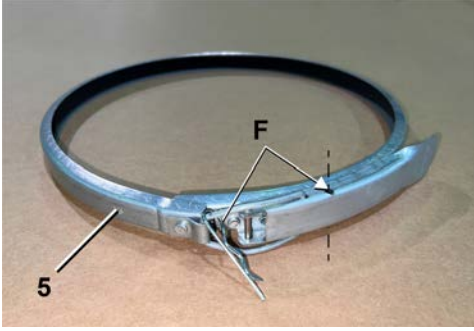
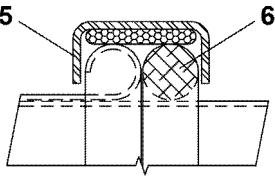
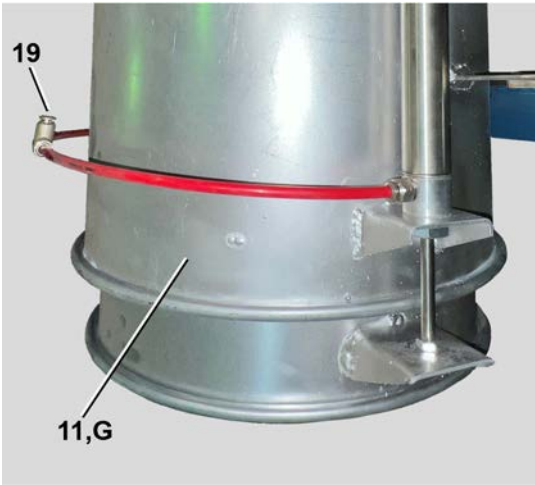
 Duct Clamp with Pin and Gasket	 A-A
	
Legend A-A . . . Duct to duct connection, typical F . . . Insert the pin in the hole to lock the latch. The pin and gasket come with the duct clamp. G . . . Vacuum nozzle includes the cylinders, tubing, and fittings.	

Table 51. Parts List—Vacuum Loading Frame

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	G77VC00528A	INSTALL=64" DRYER LF VAC LOADING FRAME 28.00"PED	Components shown below are for systems with (+)28" inch dryer pedestal. Lengths vary per installation, consult Milnor factory.
Components				
all	1	W7 711252	DRYER VAC LOADING BASE FRAME WELDMENT	
all	2	W7 711252A	DRYER VAC LOADING MID FRAME WELDMENT	
all	3	W7 71125328A	WELD=6464 DRYER VAC LOADING UPPER FRAME 28.00" PED	

Vacuum Loading Frame

6458TG1L, TG1R, 6464TG1L, TG1R.

Table 51 Parts List—Vacuum Loading Frame (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	4	G7 711251S3	64" DRYER LF STATIC FRAME INSTALL REAR CNTRL	
all	5	6A13G	13" GALV. QF CLAMP W/ PIN & NITRILE SEAL	
all	6	60C188N	ORING 13.0ID BLACK NITRILE - QF DUCTING	
all	7	6SL13G1A901K	13" GALV. QF ELBOW 90DEG 20GA 1.50 CLR 2.00TAN	
all	8	6SCC13CG10R	13" GALV. QF SLEEVE W/O-RING, 18GA 10-7/8 LG	
all	9	6N13G24AC	QF DUCT CUT 24" LG 20 GA	
all	10	SKU000120	VACUUM NOZZLE	
all	11	07 711253F	DRYER VAC EXTENSION SHIM	
all	12	07 711253E	DRYER VAC LOADING UPPER FRAME DUCT SUPPORT	
all	13	96N0015H	SHUTLVLV 1/4" 3POS/4WAY SPRING CNTR-OFF HAND LEVER	
all	14	07 96N0015H	MOUNTING PLATE FOR 96N0015H	
all	15	09N401S2W	SWITCH CTR-OFF 2-SPRING RETURN	
all	16	09N401BASE	MOUNT COLLAR ONLY	
all	17	09N401CBNO	CONT BLOCK 1-NO	
all	18	01 10782X	NPLT:DRYER VACUUM LOAD AUTO/MAN	
all	19	96PVQC24T	QUICK CONNECT FITTING 1/4" TUBING TEE	

7 Gas Assemblies

BPDG6G01 / 2022533

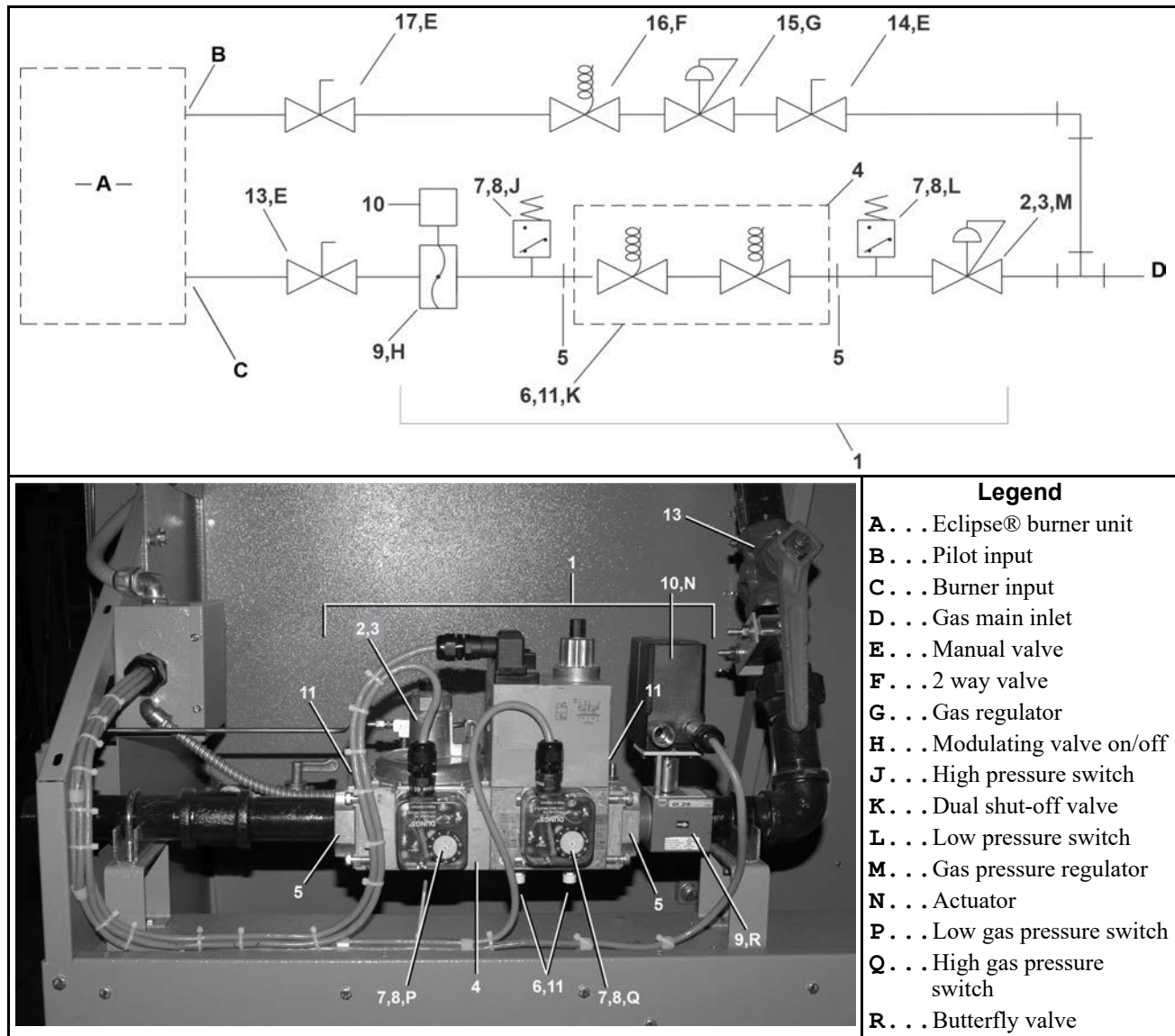
BPDG6G01.1 0000558379 A.3 A.6 12/28/22, 1:50 PM Released

Natural Gas Schematic, CSA

4 Sheets

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

Figure 36. Main Gas Inlet

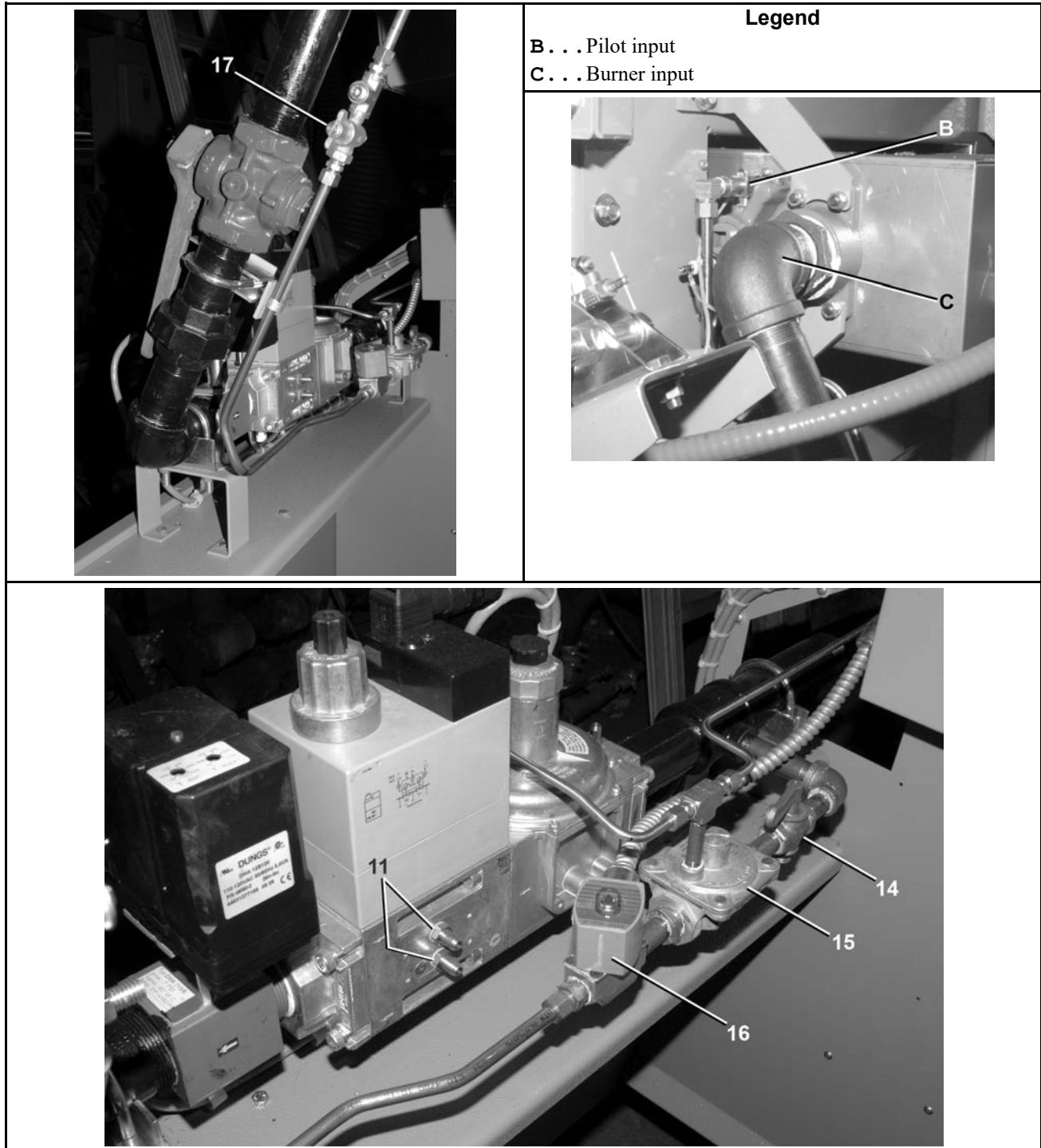


Natural Gas Schematic, CSA

4 Sheets

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

Figure 37. Pilot Line



Natural Gas Schematic, CSA

4 Sheets

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

Table 52. 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 52 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	

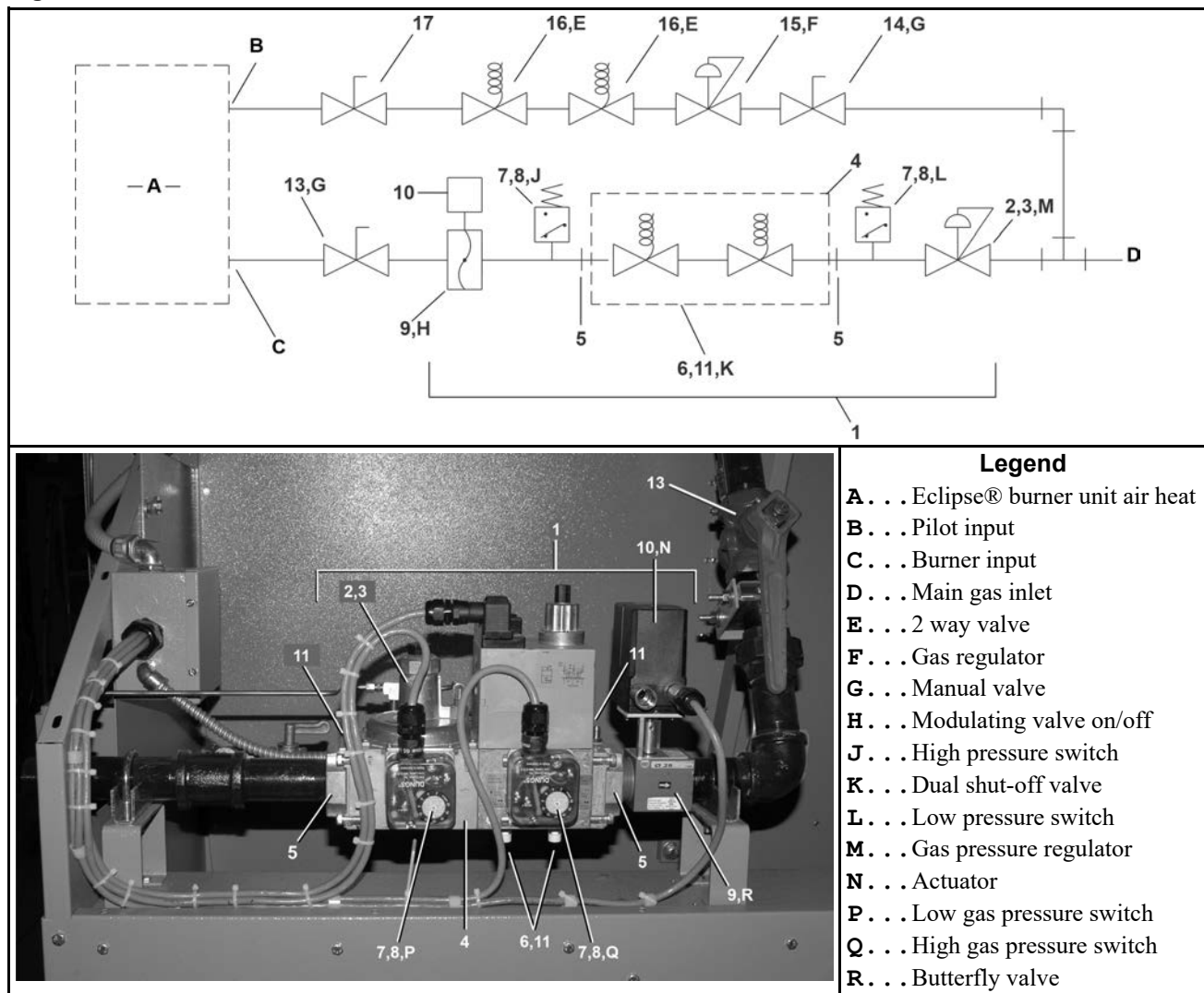
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Natural Gas Schematic, Europe and Australia

3 Sheets

6450TG1L,TG1R; 64058TG1L,TG1R; 6464TG1L,TG1R — Air Heat

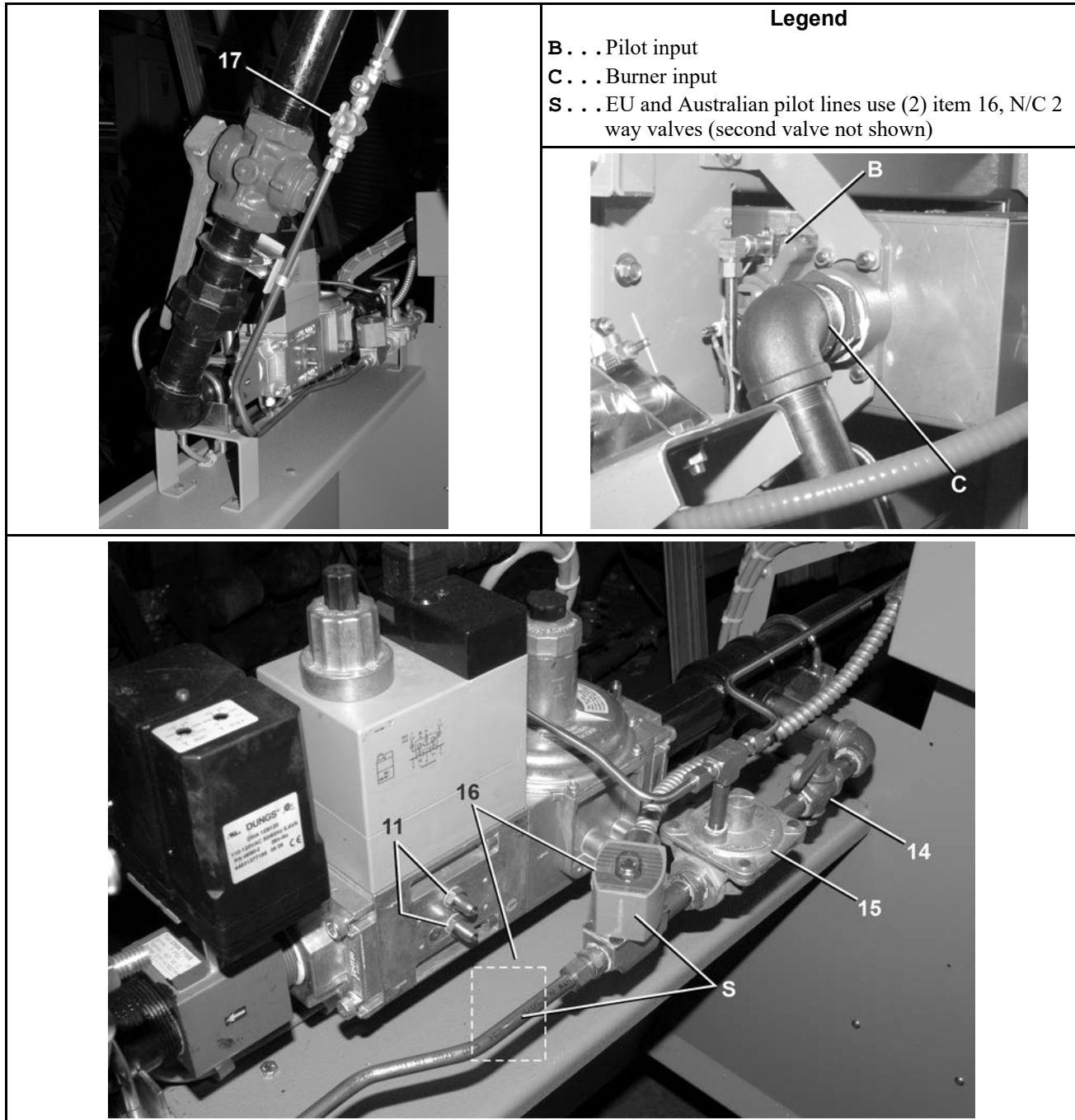
Figure 38. Main Gas Inlet

Natural Gas Schematic, Europe and Australia

3 Sheets

6450TG1L,TG1R; 64058TG1L,TG1R; 6464TG1L,TG1R — Air Heat

Figure 39. Pilot Line



Natural Gas Schematic, Europe and Australia

3 Sheets

6450TG1L,TG1R; 64058TG1L,TG1R; 6464TG1L,TG1R — Air Heat

Table 53. Parts List—Natural Gas Schematic, Europe and Australia

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	A77VG054	64" TG1L AH NAT. 2V=AUST	6450TG1L AUSTRALIA6458TG1L AUSTRALIA6464TG1L AUSTRALIA
	B	A77VG054A	64" TG1R AH NAT. 2V=AUST	6450TG1R AUSTRAL-IA6458TG1R AUSTRAL-IA6464TG1R AUSTRALIA
	C	A77VG057	6458/64TG1L AH 2V-NOVENT 10S=EU	6458TG1L EUROPE 6464TG1L EUROPE
	D	A77VG057A	6458/64TG1R AH 2V-NOVENT 10S=EU	6458TG1R EUROPE 6464TG1R EUROPE
Components				
A	1	A77VG021	1.5"VALTRAIN 2MLBTU LT TO RT AUST AGA	CONTAINS ITEMS 2–11
B	1	A77VG021A	1.5"VALTRAIN 2MLBTU RT TO LT AUST AGA	CONTAINS ITEMS 2–11
C	1	A77VG023	1.5" VALTRAIN 2MILBTU 10S=EU LT TO RT EN746-2	CONTAINS ITEMS 2–11
D	1	A77VG023A	1.5" VALTRAIN 2MILBTU 10S=EU RT TO LT EN746-2	CONTAINS ITEMS 2–11
all	2	96SD010	FRI712 GAS PRESS/REG #D230475	CE (EUROPE)
all	3	96SD011	FRI MOUNTING KIT #D219968	
AB	4	96SD024	DMV-DLE512 DUAL SHUT-OFF VALVE	
CD	4	96SD035	DUAL SHUTOFF VAL 110V 50HERTZ	
AB	5	96SD025	1-1/2 RP FLANGE ONLY #D221884	
CD	5	96SD013	1-1/2" FLNG ONLY #D222003	
all	6	96SD014	VISUALVAL POSINDIC #217-665	
all	7	96SD026	GW50A5W/2.5-50MBAR GASPRESWITC	
all	8	96SD016	MTGKIT FOR HI GAS PRESS SWITCH 273777	
AB	9	96SD027	DMK 515 MOTOR BUTTERFLY VALVE D = 24 MM	
CD	9	96SD017	DMK715/6 1-1/2"NPT BUTRFLY 28M 228783	
all	10	96SD018	DMA 12C120 ACTUATR 12 SEC TIME DMA 12C120	
all	11	96SD010	FRI712 GAS PRESS/REG #D230475	
AB	13	96G152AUST	1.5" BSP-T GAS BALL VALVE TURNFLO #B84	
CD	13	96G151A	1.5" GAS STOP VAL - NON-LUBE - CE	
all	14	96G038AUST	3/8" BSP-T GAS BALL VALVE TURNFLO #B84	
AB	15	96J508	1/2"INLET GASREG 4-12"- DUNGS AUSTRALIAN APPROVED	
CD	15	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C-MAXITRL	
all	16	96R3025A37	1/4"BSPP PILOT 2WN/C110V50/60	
all	17	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL # 55-302-01	

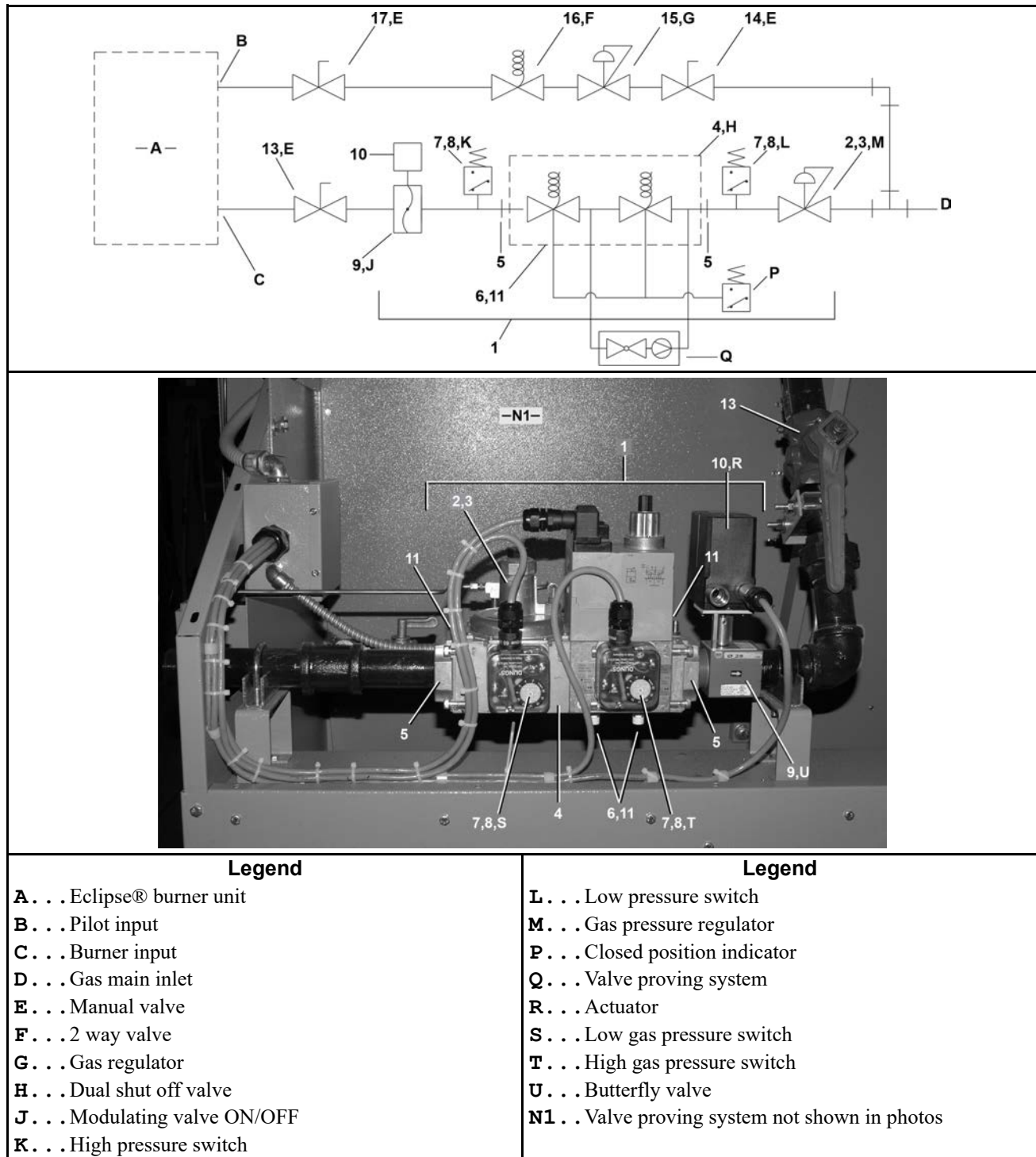
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Natural Gas Schematic, IRI

3 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

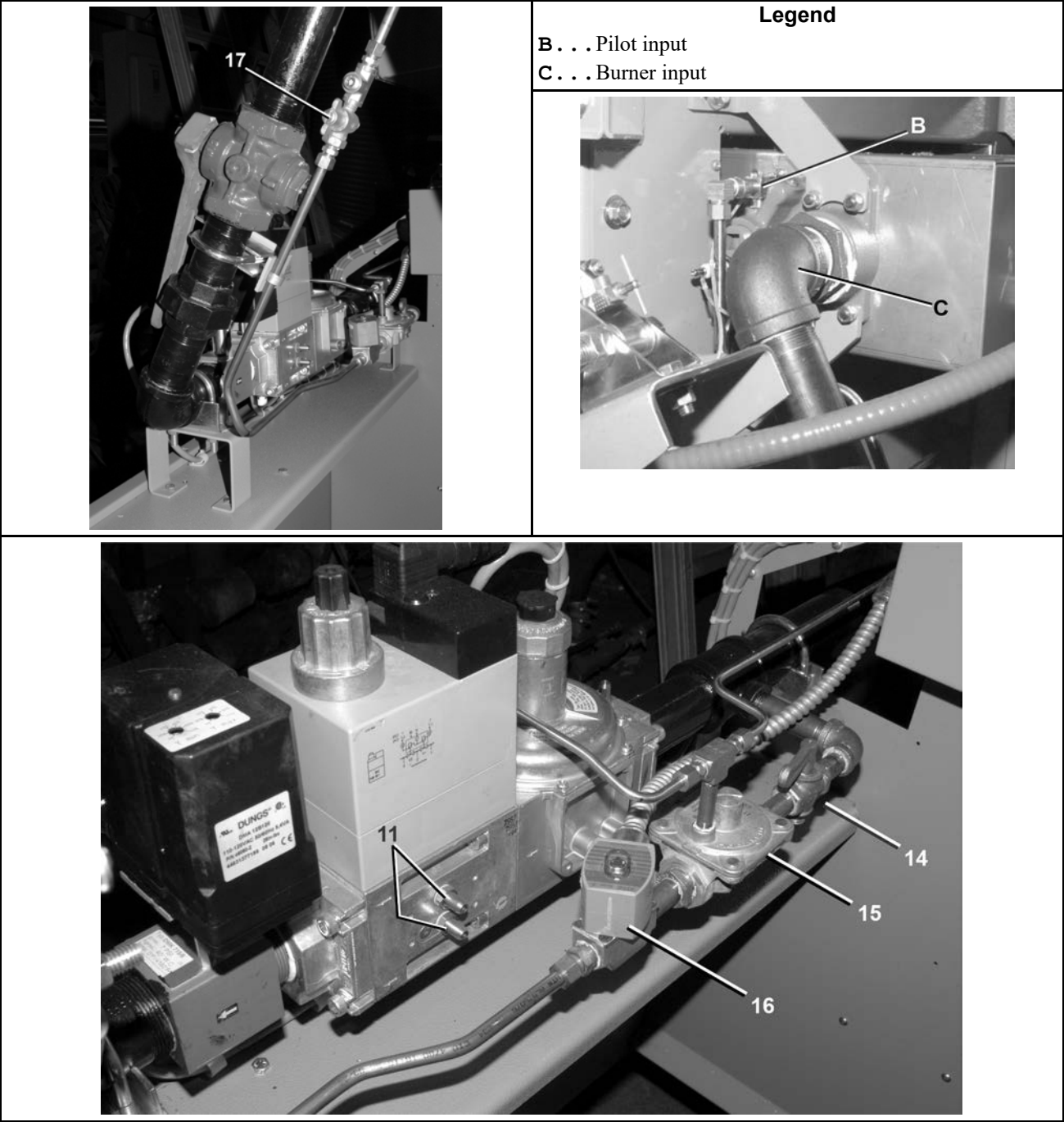
Figure 40. Main Gas Inlet

Natural Gas Schematic, IRI

3 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

Figure 41. Pilot Line



Natural Gas Schematic, IRI

3 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

Table 54. Parts List—Natural Gas Schematic, IRI

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	A77VG056	6458/64TG1L AH NAT. 2V+VPS=IRI	6458TG1L IRI,6464TGIL IRI
	B	A77VG056A	6458/64TG1R AH NAT. 2V+VPS=IRI	6458TG1R IRI,6464TGIR IRI
Components				
A	1	A77VG022	1.5" VALTRAIN 2MLBTU LT TO RT IRI	CONTAINS ITEMS 2–12
B	1	A77VG022A	1.5"VALTRAIN 2MLBTU RT TO LT IRI	CONTAINS ITEMS 2–12
all	2	96SD010	FRI712 GAS PRESS/REG #D230475	
all	3	96SD011	FRI MOUNTING KIT #D219968	
all	4	96SD012	DMV-DLE 703/602DUAL SHUTOFF VALVE	
all	5	96SD013	1-1/2" FLNG ONLY #D222003	
all	6	96SD014	VISUALVAL POSINDIC #217-665	
all	7	96SD015	GAO-A2-4-5 HI & LO GASPRESSWITCH	
all	8	96SD016	MTGKIT FOR HI GAS PRESS SWITCH	
all	9	96SD017	DMK715/6 1-1/2"NPT BUTRFLY 28M	
all	10	96SD018	DMA 12C120 ACTUATR 12 SEC TIME DMA	
all	11	96SD019	G 1/8" TEST NIPPLES(PRESSTEST	
all	12	96SD022	VALVE PROVING SYS #D221073	
all	13	96G151	1-1/2"NPTGASBALVAL W/UL,AGA & FM	
all	14	96G030	3/8"GAS BALL VLV/ T- HANDLE-CONBRACO#80-102-07	
all	15	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C-MAXITRL	
all	16	96TCC2BA37	3/8" N/C 2WAY 120V50/60C VALVE	
all	17	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL	

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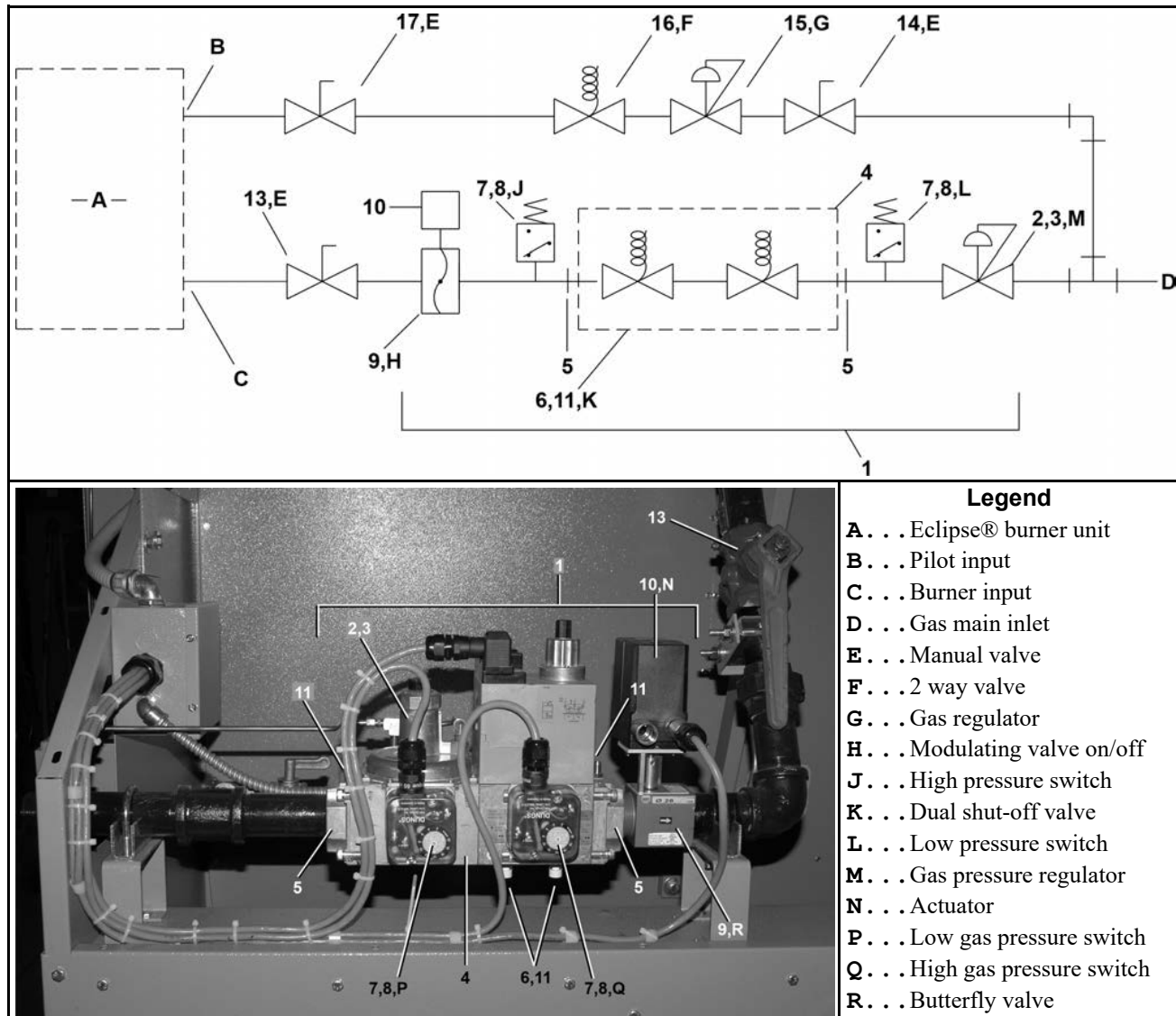
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Propane Schematic, CSA

3 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

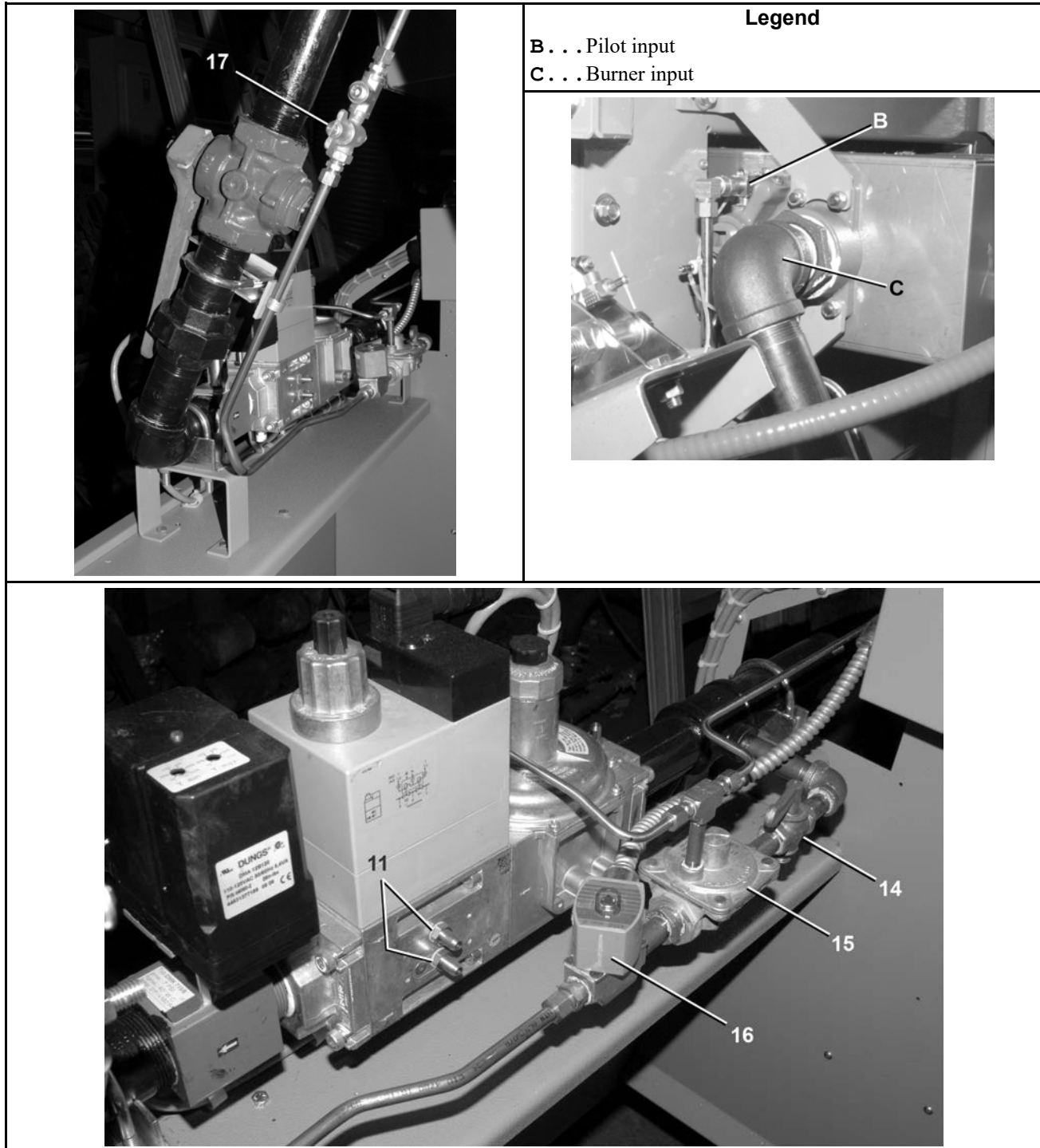
Figure 42. Main Gas Inlet



Propane Schematic, CSA

3 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

Figure 43. Pilot Line

Propane Schematic, CSA

3 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

Table 55. Parts List—Propane 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	A77VG053	6458/64TG1L AH PROP. 2V-NOVENT=CSA	6458TG1L PROPANE CSA
	B	A77VG053A	6458/64TG1R AH PROP. 2V-NOVENT=CSA	6464TG1L PROPANE CSA 6458TG1R PROPANE CSA 6464TG1R PROPANE CSA
Components				
A	1	A77VG020	1.5"VALTRAIN 2MILBTU LT TO RT	
B	1	A77VG020A	1.5"VALTRAIN 2MILBTU RT TO LT	
all	2	96SD010	FRI712 GAS PRESS/REG #D230475	
all	3	96SD011	FRI MOUNTING KIT #D219968	
all	4	96SD012	DMV-DLE 703/602DUAL SHUTOFF VALVE	
all	5	96SD013	1-1/2" FLNG ONLY #D222003	
all	6	96SD014	VISUALVAL POSINDIC #217-665	
all	7	96SD015	GAO-A2-4-5 HI&LO GASPRESSWITCH	
all	8	96SD016	MTGKIT FOR HI GAS PRESS SWITCH	
all	9	96SD017	DMK715/6 1-1/2"NPT BUTRFLY 28M	
all	10	96SD018	DMA 12C120 ACTUATR 12 SEC TIME DMA	
all	11	96SD019	G 1/8" TEST NIPPLES(PRESSTEST)	
all	13	96G150C	1.5"GAS STOP VAL WRENCH HANDLE	
all	14	96G030	3/8"GAS BALL VLV/ T- HANDLE	
all	15	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C-MAXITRL	
all	16	96TCC2BA37	3/8" N/C 2WAY 120V50/60C VALVE	
all	17	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL	

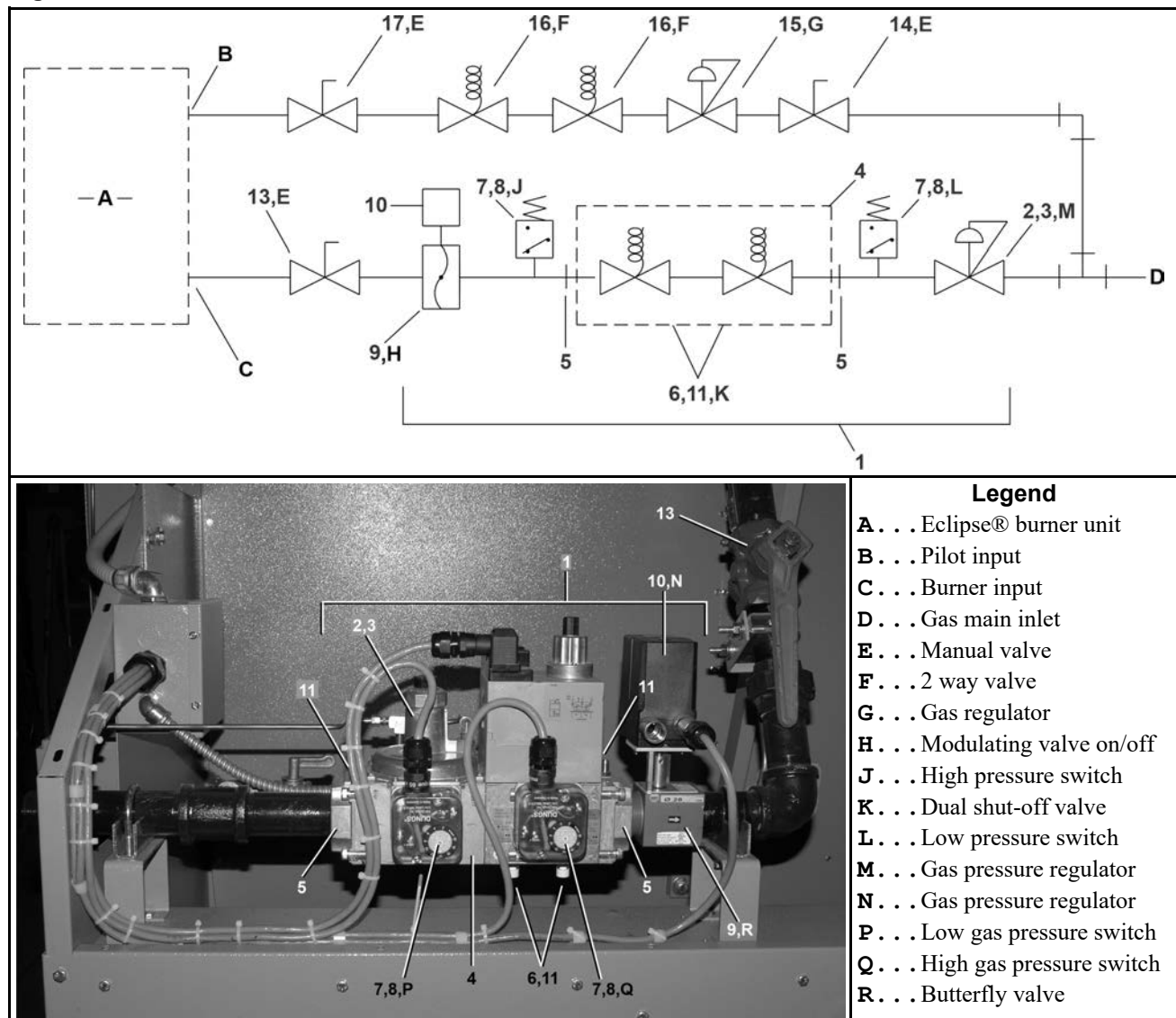
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Propane Schematic, Europe

3 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

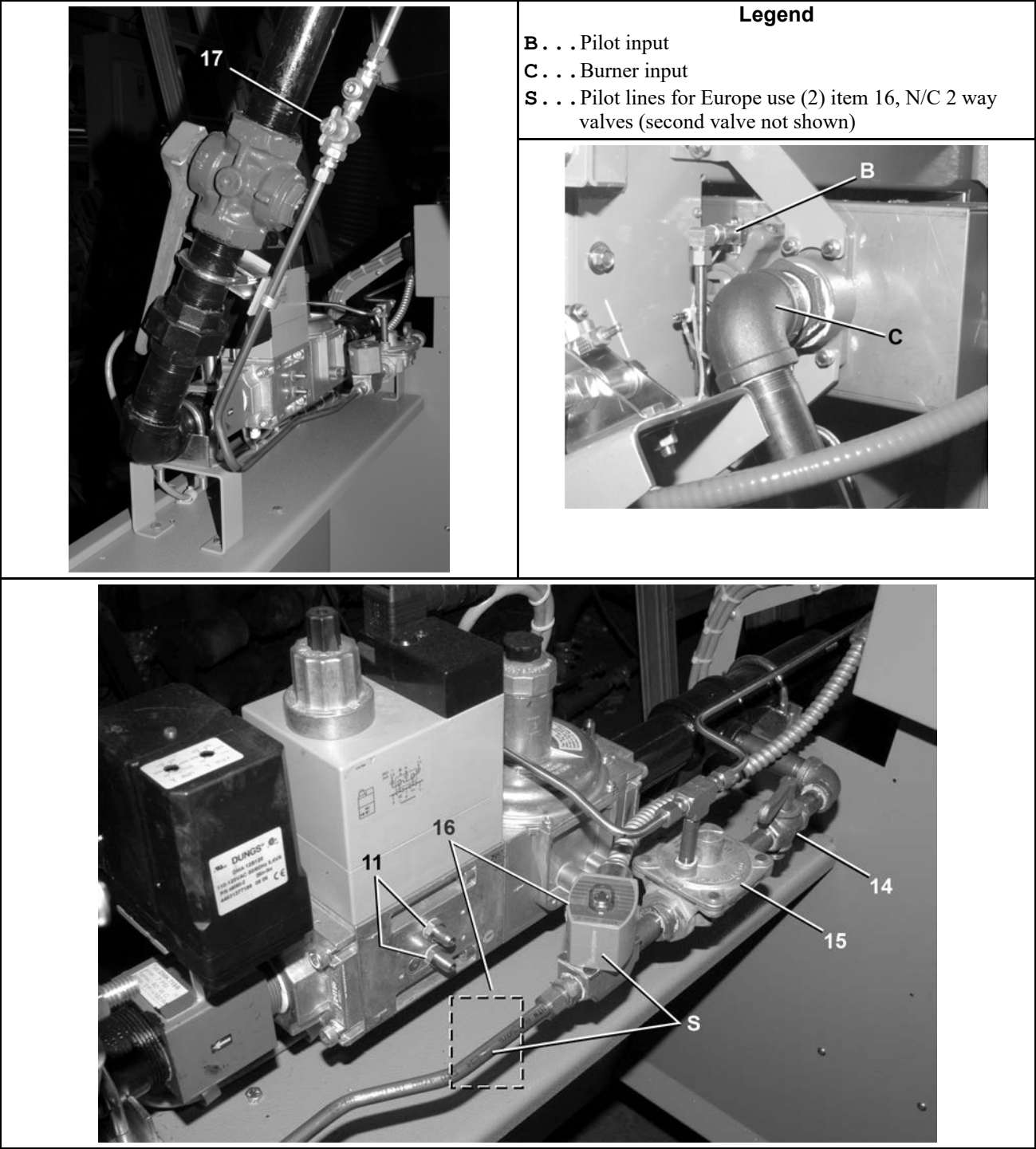
Figure 44. Main Gas Inlet

Propane Schematic, Europe

3 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

Figure 45. Pilot Line



Propane Schematic, Europe

3 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

Table 56. Parts List—Propane Schematic, Europe

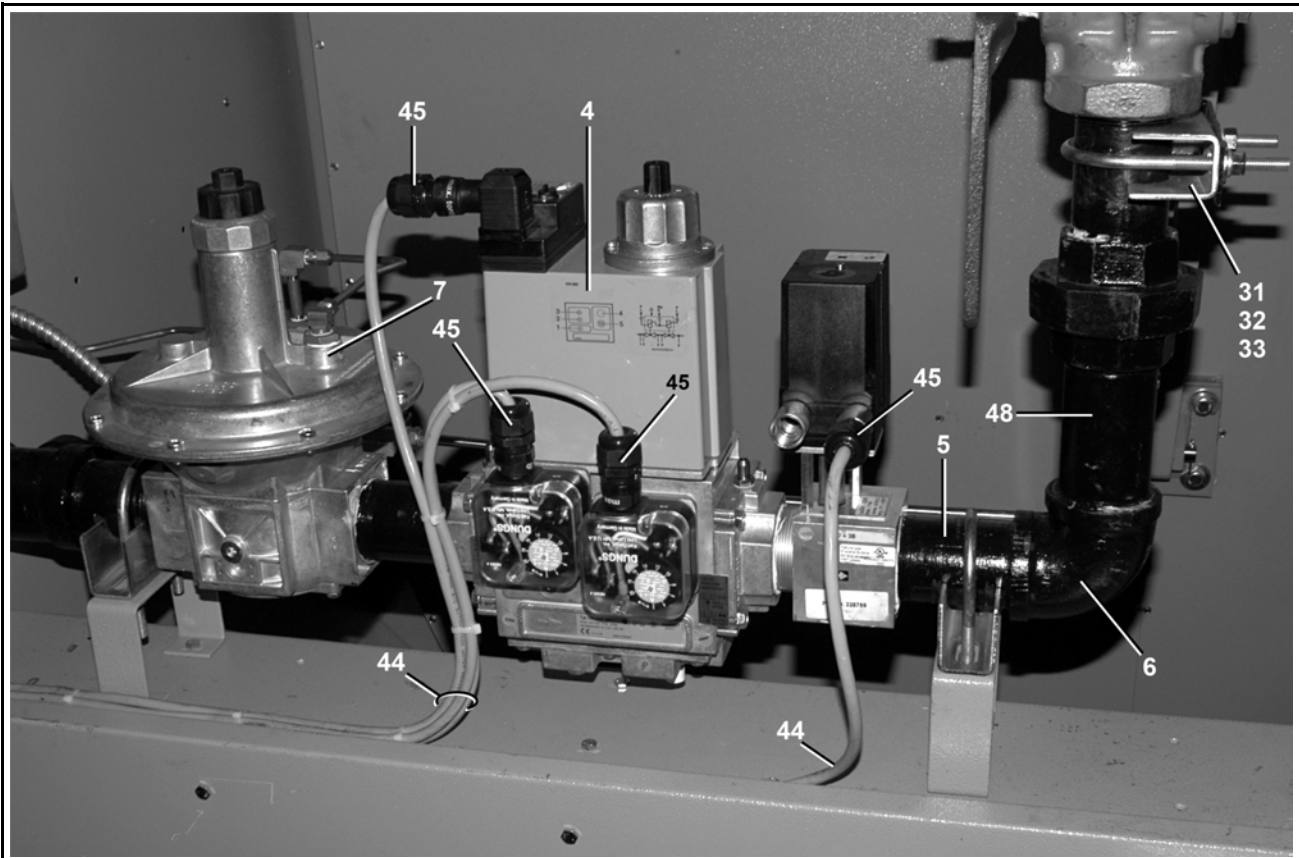
Find the assembly for your machine and the letter shown in the "Item" column. The components for your machine will show this letter or the word "all" in the "Used In" column. The numbers shown in the "Item" column are those shown in the illustrations.				
Used In	Item	Part Number	Description/Nomenclature	Comments
Reference Assemblies				
	A	A77VG057	6458/64TG1L AH 2V-NOVENT 10S=EU	6458TG1L,6464TG1L PROPANE, EUROPE
	B	A77VG057A	6458/64TG1R AH 2V-NOVENT 10S=EU	6458TG1R,6464TG1R PROPANE, EUROPE
Components				
A	1	A77VG023	1.5" VALTRAIN 2MILBTU 10S=EU LT TO RT EN746-2	
B	1	A77VG023A	1.5" VALTRAIN 2MILBTU 10S=EU RT TO LT EN746-2	
all	2	96SD010	FRI712 GAS PRESS/REG #D230475	
all	3	96SD011	FRI MOUNTING KIT #D219968	
all	4	96SD035	DUAL SHUTOFF VAL 110V 50HERTZ	
all	5	96SD013	1-1/2" FLNG ONLY #D222003	
all	6	96SD014	VISUALVAL POSINDIC #217-665	
all	7	96SD026	GW50A5W/2.5-50MBAR GASPRESWITC	
all	8	96SD016	MTGKIT FOR HI GAS PRESS SWITCH 273777	
all	9	96SD017	DMK715/6 1-1/2"NPT BUTRFLY 28M 228783	
all	10	96SD018	DMA 12C120 ACTUATR 12 SEC TIME DMA 12C120	
all	11	96SD019	G 1/8" TEST NIPPLES(PRESSTEST)	
all	13	96G151A	1.5" GAS STOP VAL - NON-LUBE - CE	
all	14	96G030	3/8"GAS BALL VLV/ T- HANDLE-CONBRACO	
all	15	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C-MAXITRL	
all	16	96R3025A37	1/4"BSPP PILOT 2WN/C110V50/60	
all	17	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL # 55-302-01	

CSA Gas Piping

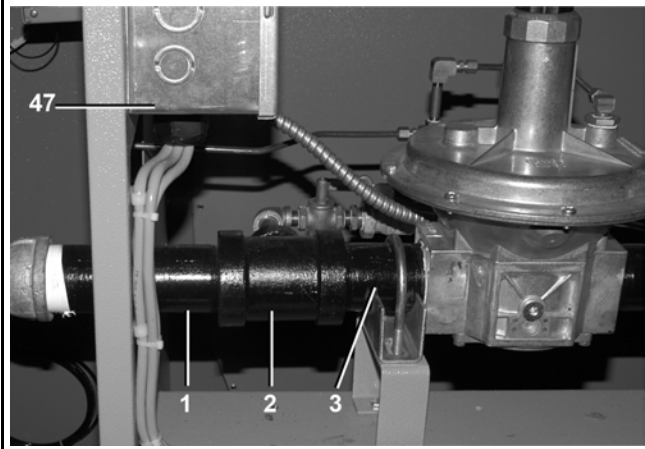
6 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

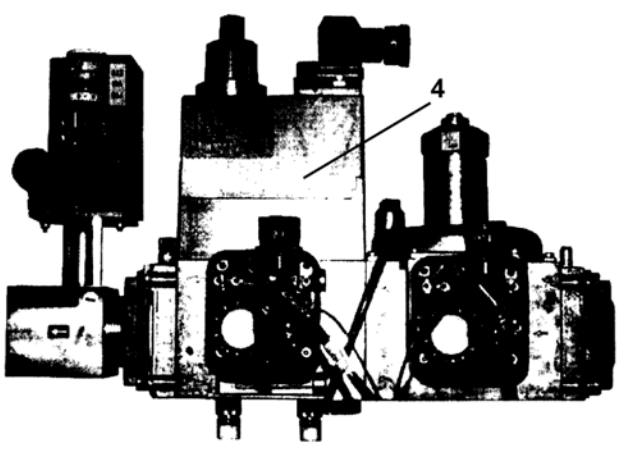
Figure 46. Main Gas Line



Gas Train Entry



A77VG014A, A79VG014A

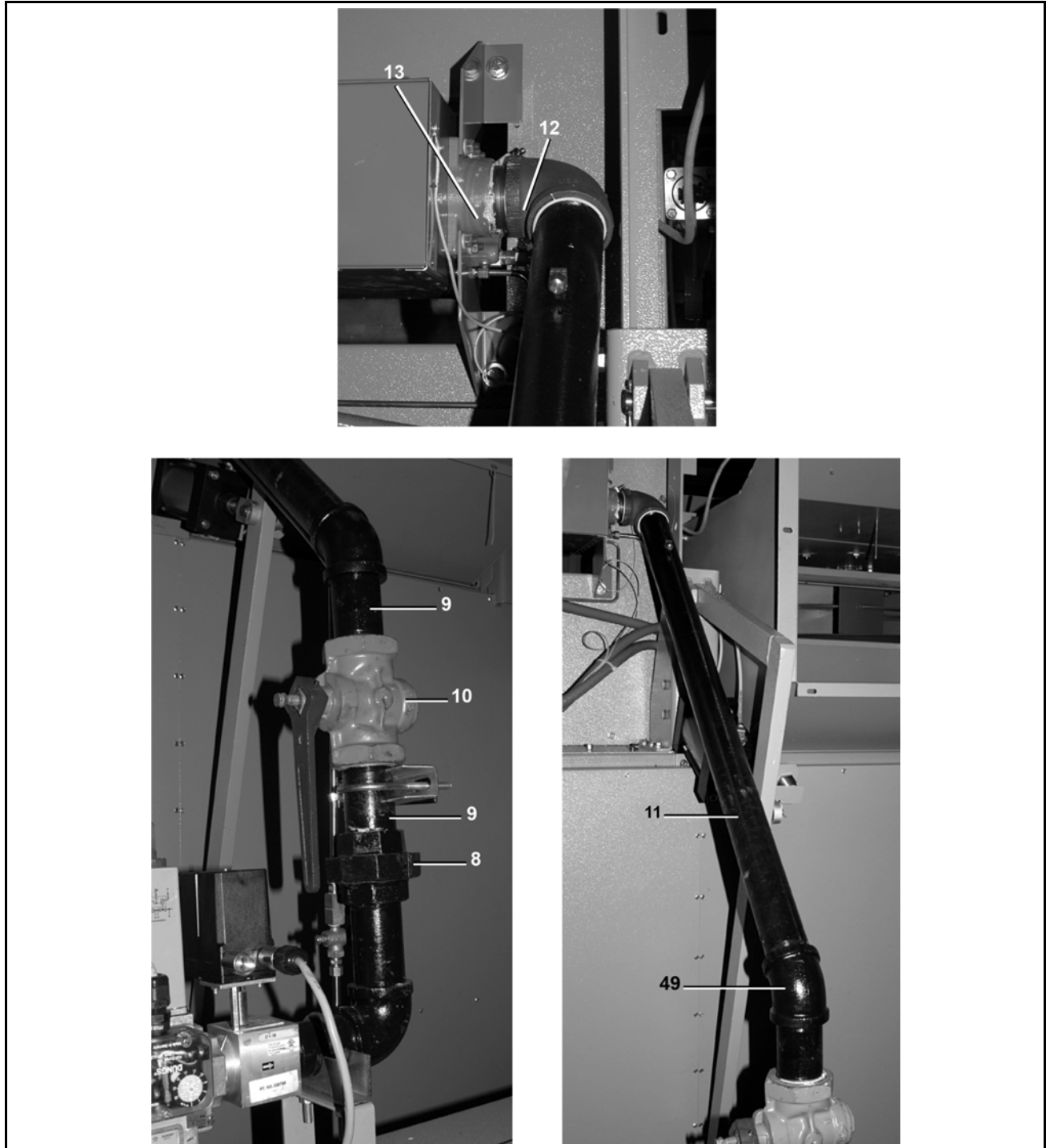


CSA Gas Piping

6458TG1L,TG1R; 6464TG1L,TG1R

6 Sheets

Figure 47. Gas Train Vertical

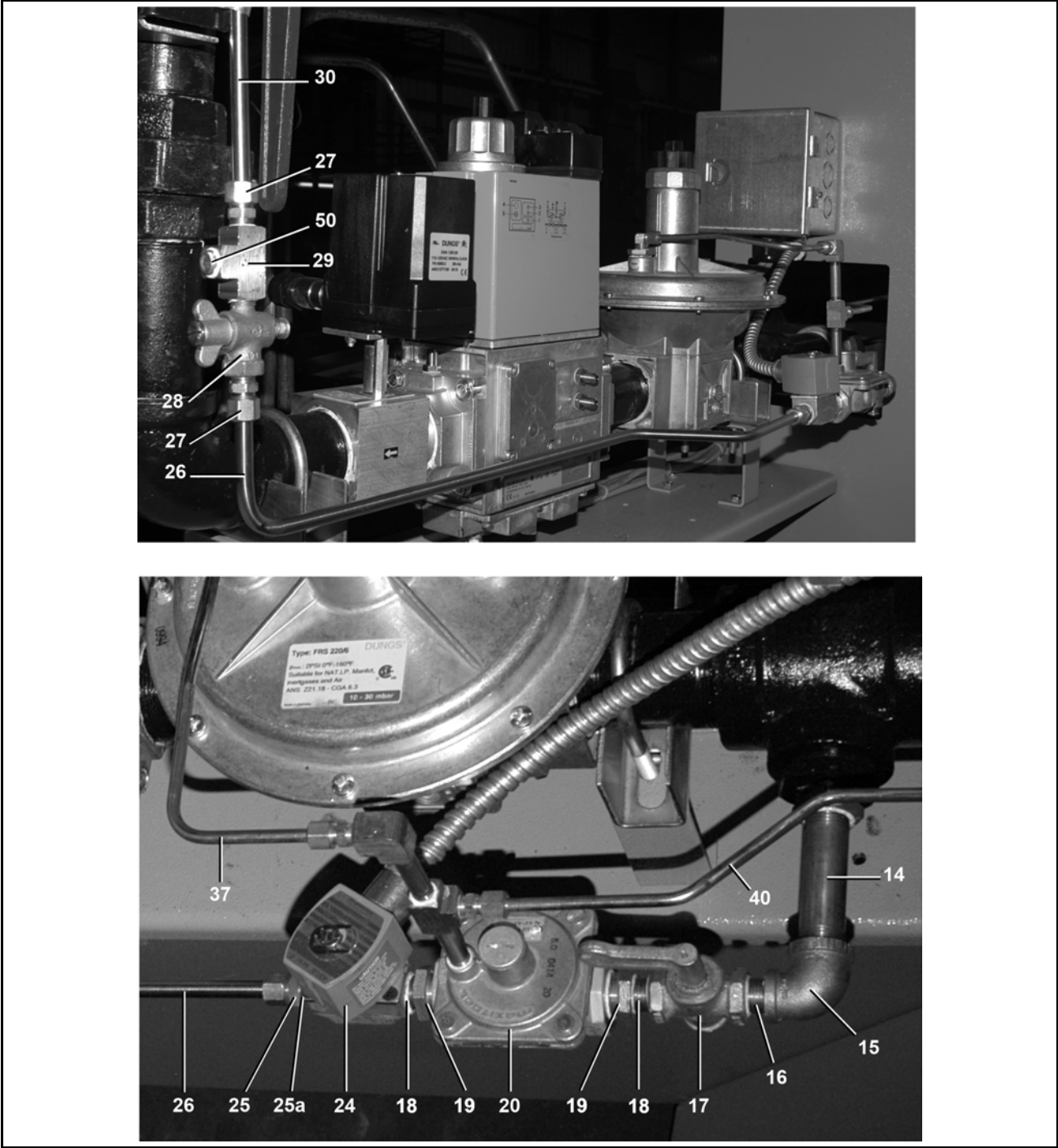


CSA Gas Piping

6 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

Figure 48. Pilot Line

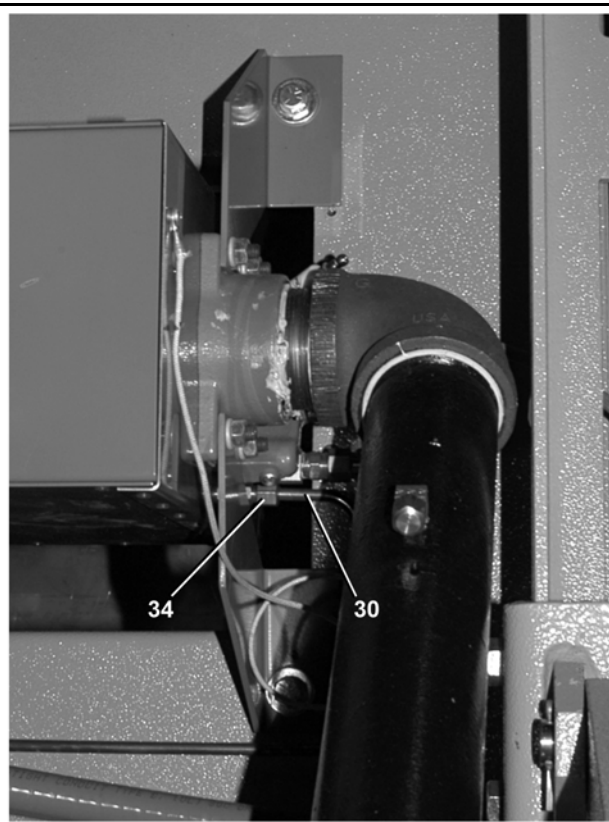
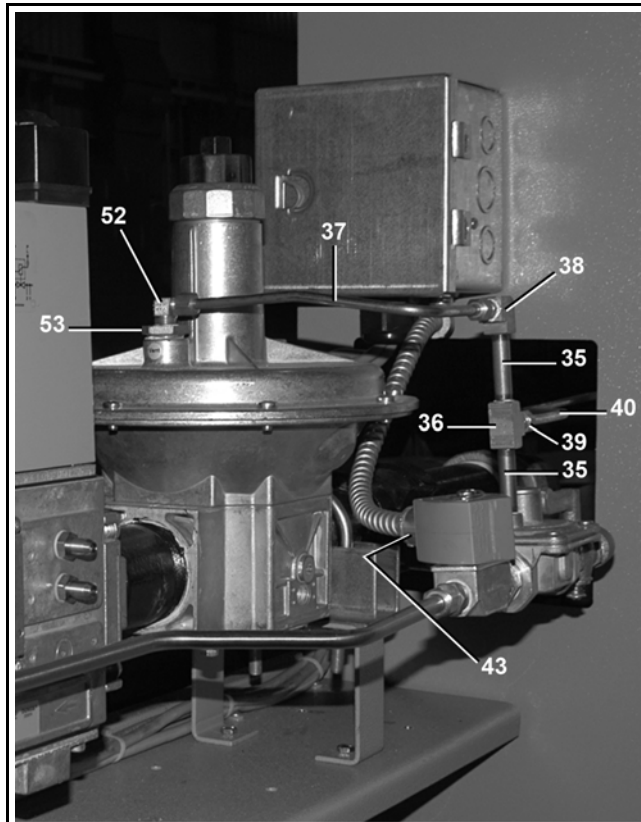


CSA Gas Piping

6 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

Figure 49. Pilot Line



CSA Gas Piping

6 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

Table 57. Parts List—CSA Gas Piping

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	A77VG011	64" DRYER GAS TRAIN ENTRY SECTION	6458,6464
	C	A77VG014	6458/64TG1L AH 2V-NOVENT=CSA SECTION	6458TG1L,6464TG1L
	D	A77VG014A	6458/64TG1R AH 2V-NOVENT=CSA SECTION	6458TG1R,6464TG1R
	G	A77VG015	6458/64 AH GAS TRAIN VERT SECTION=CSA	6458,6464
	J	A77VG013	6458/64 PILOT GAS PIPE	6458,6464
Components				
A	1	5N1K07KF42	NPT NIP 1.5X7.5 TBE BLKSTL SK40	
A	2	5S1KMFA0K	NPT TEE 1.5X1.5X1/2 BLKMAL150#	
A	3	5N1K05AF42	NPT NIP 1.5X5 TBE BLKSTL SK40	
C	4	A77VG020	1.5"VALTRAIN 2MILBTU LT TO RT UL795/CSA	
D	4	A77VG020A	1.5"VALTRAIN 2MILBTU RT TO LT UL795/CSA	
C,D	5	5N1K04AF42	NPT NIP 1.5X4 TBE BLKSTL SK40	
C,D	6	5SL1KMFA	NPT ELB 90DEG 1.5 BLKMAL 150#	
C,D	7	51T311	FLAMEARREST VNTSCREEN.375BRASS	
G	8	5SU1KMF	NPT UNION 1.5" BLKMAL 150#	
G	9	5N1K03KF42	NPT NIP 1.5X3.5 TBE BLKSTL S40	
G	10	96G150C	1.5"GAS STOP VAL - RESUN #R-1430 W/"A" STYLE WRENCH HANDLE	
G	11	5N1K38KF42	NPT NIP 1+1/2"X38+1/2"TBE BLK40	
G	12	5SL2AMFA1K	NPT ELB 90DEG 2X1.5 BLKMAL150#	
all	13	5N2A02KB42	NPT NIP 2X2.5 TBE BLKSTL SK40	
J	14	5N0K03ABE2	NPT NIP 1/2X3 TBE BRASS STD	
J	15	5SL0KBEA0G	NPT ELB 90DEG 1/2X3/8 BRASS 125	
J	16	5N0G02ABE2	NPT NIP 3/8X2 TBE BRASS STD	
J	17	96G030	3/8"GAS BALL VLV/ T- HANDLE-CONBRACO#80-102-07	
J	18	5N0G02ABE2	NPT NIP 3/8X2 TBE BRASS STD	
J	19	5SR0K0GBE	NPT RED 1/2X3/8 BRASS 125#	
J	20	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C-MAXITRL	
J	24	96TCC2BA37	3/8" N/C 2WAY 120V50/60C VALVE	
J	25	53A026	BODYMALECON3/8X3/8 #68C-6-6B	
J	26	87Z010	TUBE 3/8"ODX.035" SS304 *20RM	
J	27	53A023	MALECON3/8X.25COMP ANCHR#68-64	
J	28	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL	

CSA Gas Piping

6 Sheets

6458TG1L,TG1R; 6464TG1L,TG1R

Table 57 Parts List—CSA Gas Piping (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
J	29	51V015	TEE 1/4 FGDBRASS 101T7-444	
J	30	87Z010	TUBE 3/8"ODX.035" SS304 *20RM	
J	31	27A032	UBOLT 1.5"PIPE 3/8-16X3-3/4LEG	
J	32	02 16306	CLAMP=1+1/2" PIPE	
J	33	07 71318	6458 PILOT LINE SUPPORT	
J	34	53A026	BODYMALECON3/8X3/8 #68C-6-6B	
J	35	5N0C02ABE2	NPT NIP 1/8X2 TBE BRASS STD	
J	36	51V010A	TEE 1/8"BRSEXTR BLOCTYP#2203P2	
J	37	87Z00EX035	TUBE=1/4"ODX.035WL 316LSS*20RM	
J	38	53A031B	BODY-EL90MALE.25X1/8 #269C-42B	
J	39	53A005B	BODYMALCON1/4X1/8COMP #B68A-4A	
J	40	87Z00EX035	TUBE=1/4"ODX.035WL 316LSS*20RM	
J	42	12F011	3/8" UL FLEX STEEL CONDUIT	
J	43	12M035	3/8" SCREW-IN CONNECTOR	
C,D	44	09V290A	CABLE #18/4 SJTO 7/16"OD 250'	
C,D	45	12M043F050	LIQTITE 1/2" STR. FITTING	
C,D	47	12M043F100	LIQTITE 1" STR. FITTING	
C,D	48	5N2A05KB42	NPT NIP 2X5.5 TBE BLKSTL SK40	
J	50	51P013	PLUG HXCNTRSUNK 1/4"BRASS	
J	51	5SB0G0EBEO	NPTHEXBUSH 3/8X1/4 BRASS 125#	
J	52	53A008B	BODYMALECON.25X.25COMP#B68A-4B	

CSA Gas Piping for Rear Control

6 Sheet

6458, 6464 TG1L/TG1R (AH)

Figure 50. Rear View of Rear Control Boxes (6458TG1L AH 10/2019 shown)

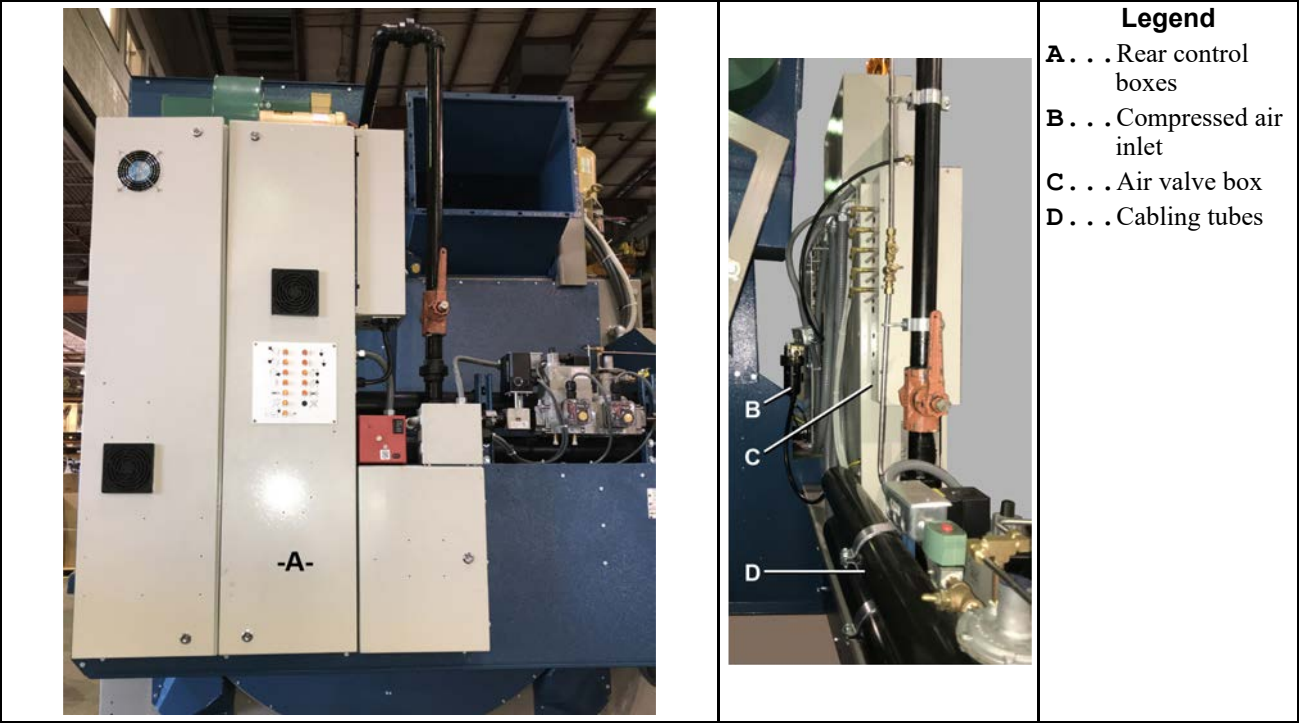
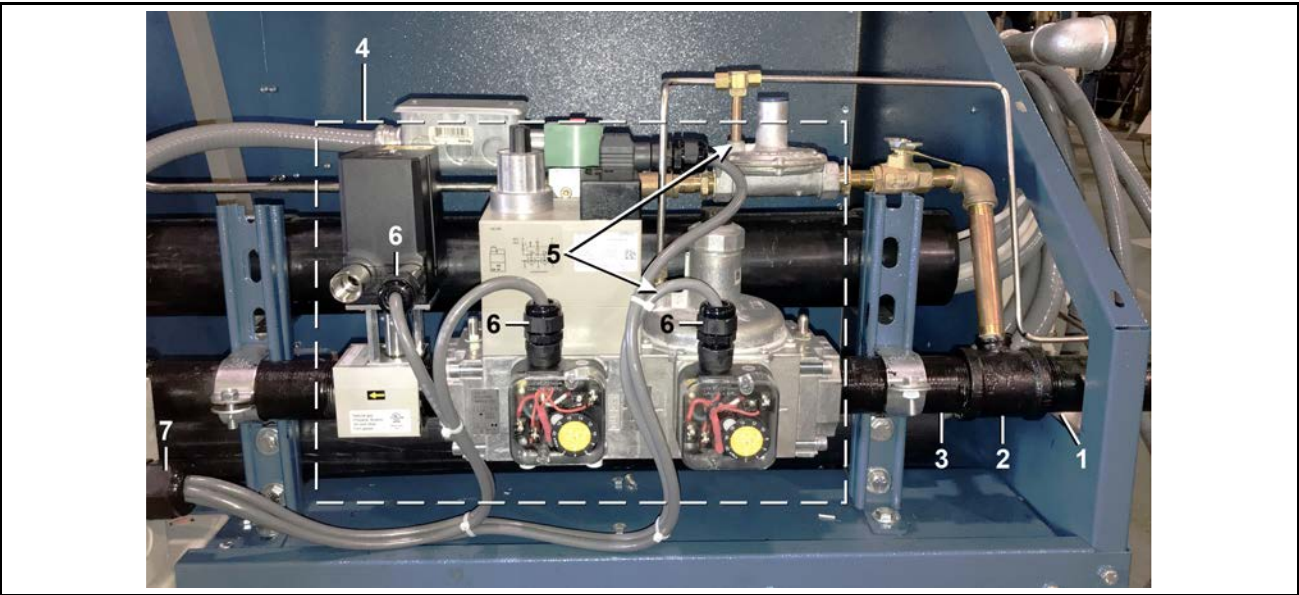


Figure 51. Gas Train

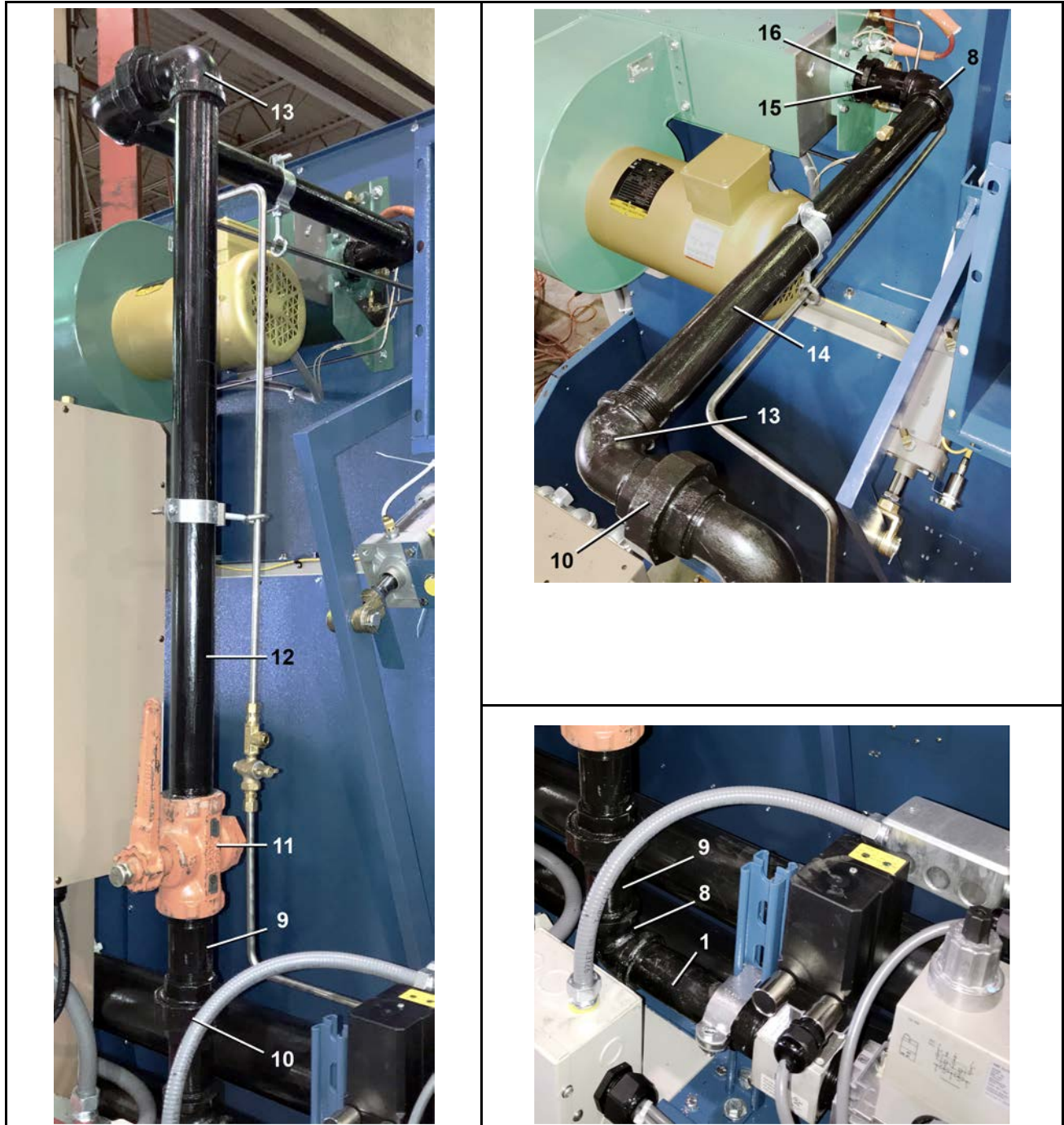


CSA Gas Piping for Rear Controls

6458, 6464 TG1L/TG1R (AH)

6 Sheet

Figure 52. Main Line to AH (Air Heat) Burner

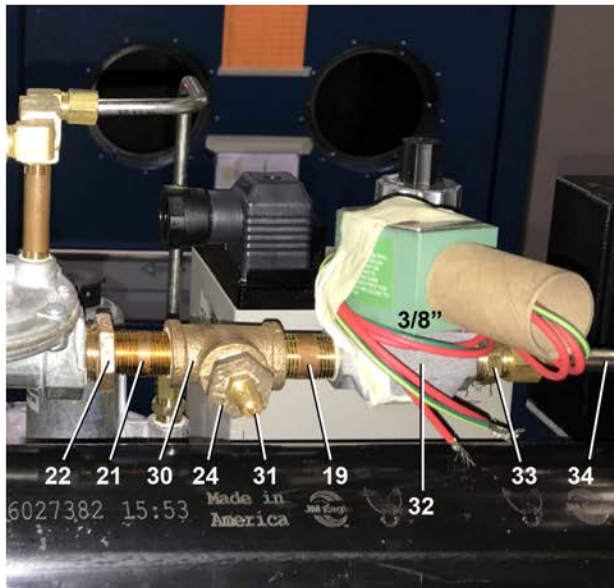
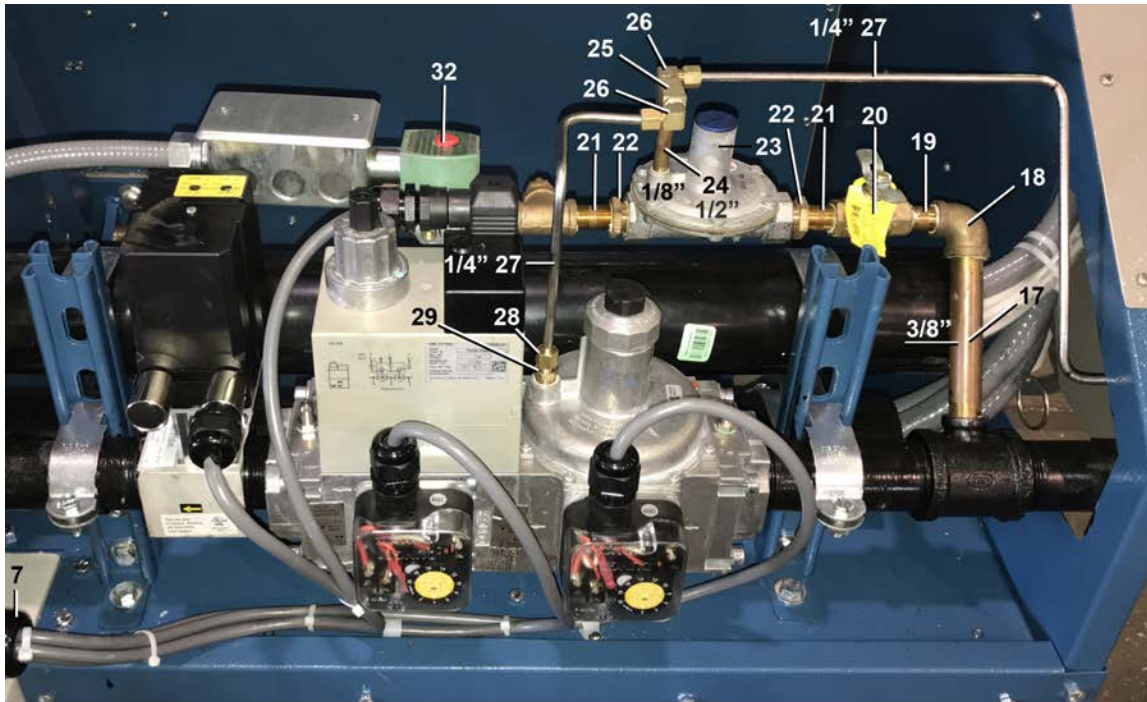


CSA Gas Piping for Rear Controls

6 Sheet

6458, 6464 TG1L/TG1R (AH)

Figure 53. Pilot Line

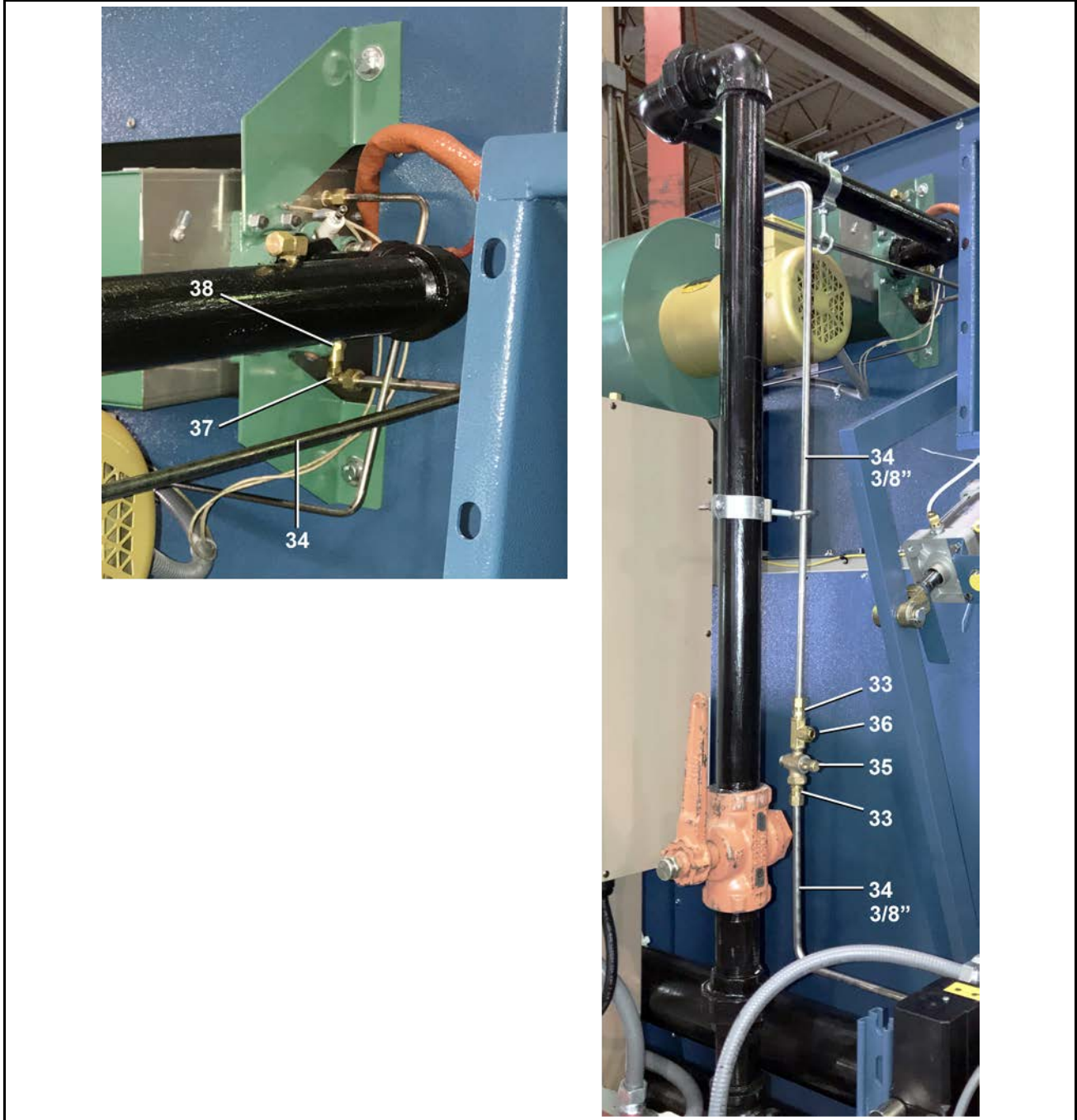


CSA Gas Piping for Rear Controls

6 Sheet

6458, 6464 TG1L/TG1R (AH)

Figure 54. Pilot Line to AH Burner



CSA Gas Piping for Rear Controls

6 Sheet

6458, 6464 TG1L/TG1R (AH)

Table 58. Parts List—CSA Gas Piping for Rear Controls

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				
	Y	A77VG060B	6458/64TG1L AH NAT. 2V-NOVENT=CSA REAR CNTRL	Reference
	Z	A77VG060C	6458/64TG1R AH NAT. 2V-NOVENT=CSA REAR CNTRL	Reference
	A	A77VG063B	6458/64TG1L AH NAT. 2V-NOVENT=CSA REAR CNTRL	Gas Train TG1L
	B	A77VG063C	6458/64TG1R AH NAT. 2V-NOVENT=CSA REAR CNTRL	Gas Train TG1R
	C	A77VG064	6458/64 PILOT GAS PIPE=CSA REAR CNTRL	Pilot Line
	D	A77VG065B	6458/64 AH NAT. GAS TRAIN ENTRY SECTION=CSA REAR CNTRL	Main Line Entry
	E	A77VG061B	6458/64 AH NAT. GAS TRAIN VERT SECTION=CSA REAR CNTRL	Main Line Vertical
	F	A77VG062B	6458/64 AH GAS TRAIN UPPER SECTION=CSA REAR CNTRL	Main Line Upper
Components				
all	1	5N1K07KF42	NPT NIP 1.5X7.5 TBE BLKSTL SK40	
all	2	5S1KMFA0K	NPT TEE 1.5X1.5X1/2 BLKMAL150#	
A	3	5N1K05KF42	NPT NIPPLE 1.5X5.5 TBE BLKSTL	
B	4	A77VG020A	1.5"VALTRAIN 2MILBTU RT TO LT UL795/CSA	
all	4	A77VG020	1.5"VALTRAIN 2MILBTU LT TO RT UL795/CSA	
all	5	51T311	FLAMEARREST VNTSCREEN.375BRASS	
all	6	12M043F050	LIQTITE 1/2" STR. FITTING	
all	7	12M043F100	LIQTITE 1" STR. FITTING	
all	8	5SL1KMFA	NPT ELB 90DEG 1.5 BLKMAL 150#	
all	9	5N1K04AF42	NPT NIP 1.5X4 TBE BLKSTL SK40	
all	10	5SU1KMF	NPT UNION 1.5" BLKMAL 150#	
all	11	96G150C	1.5"GAS STOP VAL - W/"A" STYLE WRENCH HANDLE	
all	12	5N1K31KF42	NPT NIP 1.5"X31.5" TBE BLK SCH40	
all	13	5SL1KMFC	NPT ELB 90DEG STRT 1.5 BLK 150#	
all	14	5N1K25AF42	NPT NIP 1.5"X25" TBE BLK SCH40	
all	15	5N1K03KF42	NPT NIP 1.5X3.5 TBE BLKSTL S40	
all	16	5SB2A1KCEO	NPT HEXBUSH 2X1.5 BLKCI 125#	
all	17	5N0K05KBE2	NPT NIP 1/2X5.5 TBE BRASS STD	
all	18	5SL0KBEA0G	NPT ELB 90DEG 1/2X3/8 BRASS 125	
all	19	5N0GCLSBE2	NPT NIP 3/8XCLS TBE BRASS STD	
all	20	96G030	3/8"GAS BALL VLV/ T- HANDLE-	
all	21	5N0G02ABE2	NPT NIP 3/8X2 TBE BRASS STD	
all	22	5SR0K0GBE	NPT RED 1/2X3/8 BRASS 125#	

CSA Gas Piping for Rear Controls

6 Sheet

6458, 6464 TG1L/TG1R (AH)

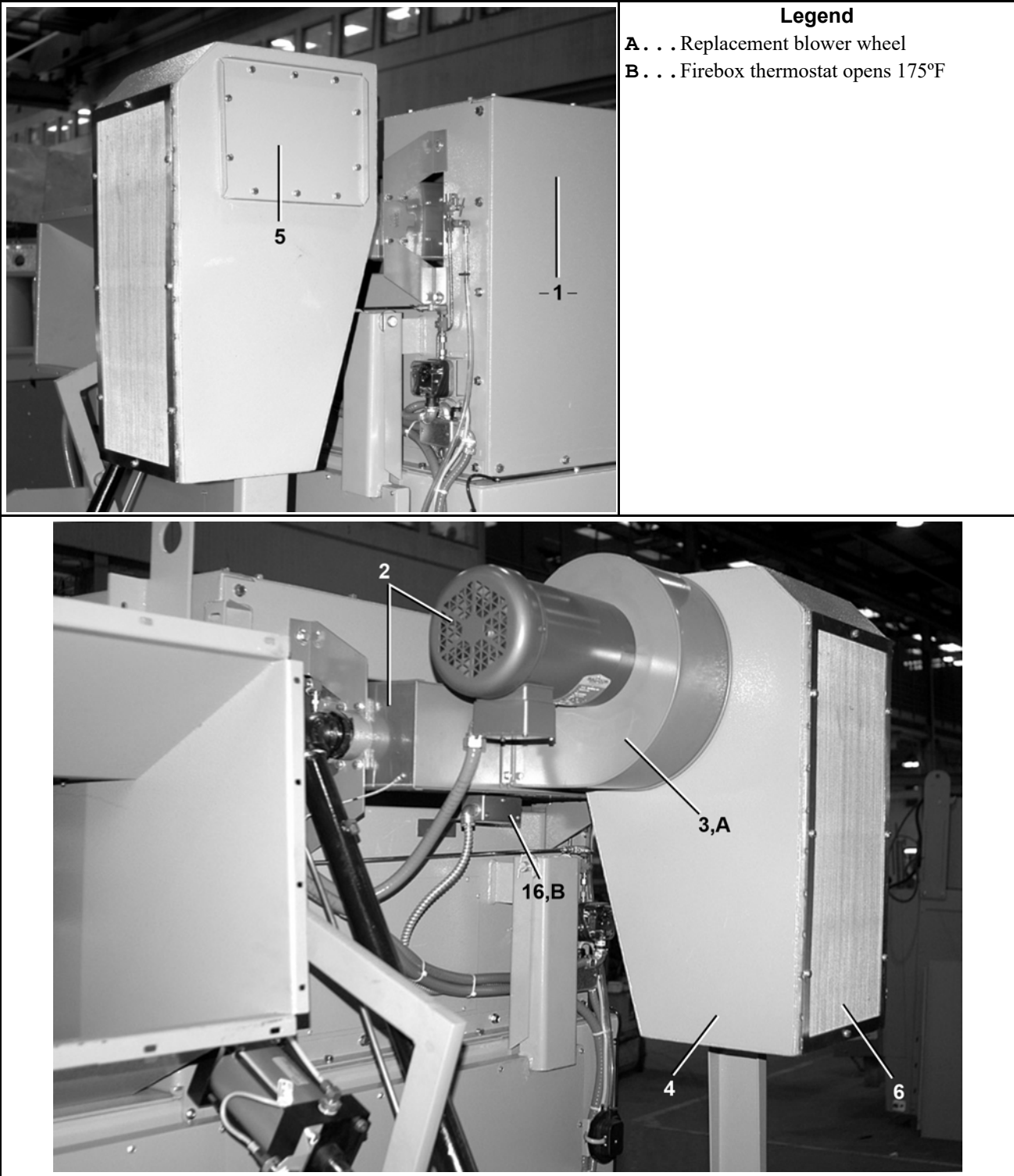
Table 58 Parts List—CSA Gas Piping for Rear Controls (cont'd.)

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	23	96J507	1/2"INLET GASREG LEVER ACTING 7"W.C	
all	24	5N0C03ABE2	NPT NIP 1/8X3 TBE BRASS STD	
all	25	51V010A	TEE 1/8"BRSEXTR BLOCTYP#2203P2	
all	26	53A031B	BODY-EL90MALE.25X1/8 #269C-42B	
all	27	87Z00EX035	TUBE=1/4"ODX.035WL 316LSS*20RM	
all	28	53A008B	BODYMALECON.25X.25COMP#B68A-4B	
all	29	5SB0G0EBEO	NPTHEXBUSH 3/8X1/4 BRASS 125#	
all	30	5S0GBEA	NPT TEE 3/8" BRASS 125#	
all	31	96G0001	GAS TEST PORT ECLIPSE 13445	
all	32	96TCC2BA37	3/8" N/C 2WAY 120V50/60C VALVE	
all	33	53A023	MALECON3/8X.25COMP ANCHR#68-64	
all	34	87Z010	TUBE 3/8"ODX.035" SS304 *20RM	
all	35	96G037AGA	1/4X1/4 GAS COCK VALVE W/T-HDL	
all	36	51V015	TEE 1/4 FGDBRASS 101T7-444	
all	37	51P013	PLUG HXCNTRSUNK 1/4"BRASS	
all	38	53A044	EL90 3/8TXMP AND#69A-6C	
all	39	53A026	BODYMALECON3/8X3/8 #68C-6-6B	

Firebox, Burner and Combustion Air

3 Sheets

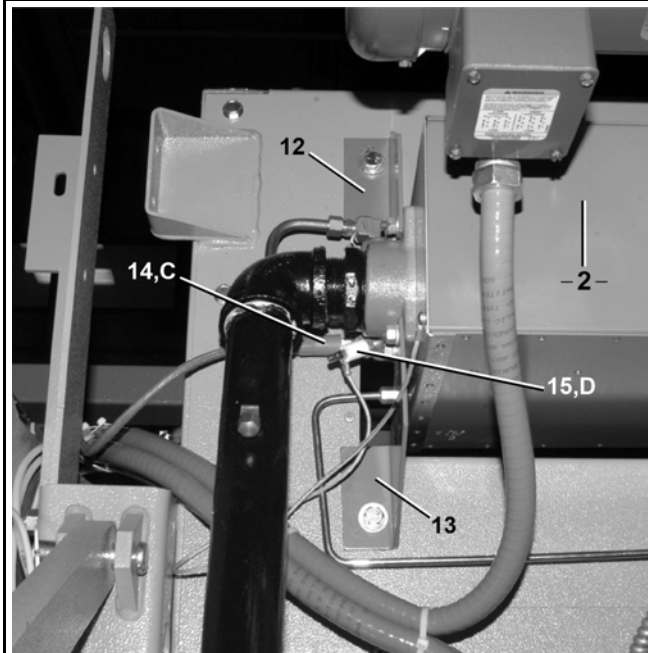
6458TG1R,TG1L; 6464TG1R,TG1L



Firebox, Burner and Combustion Air

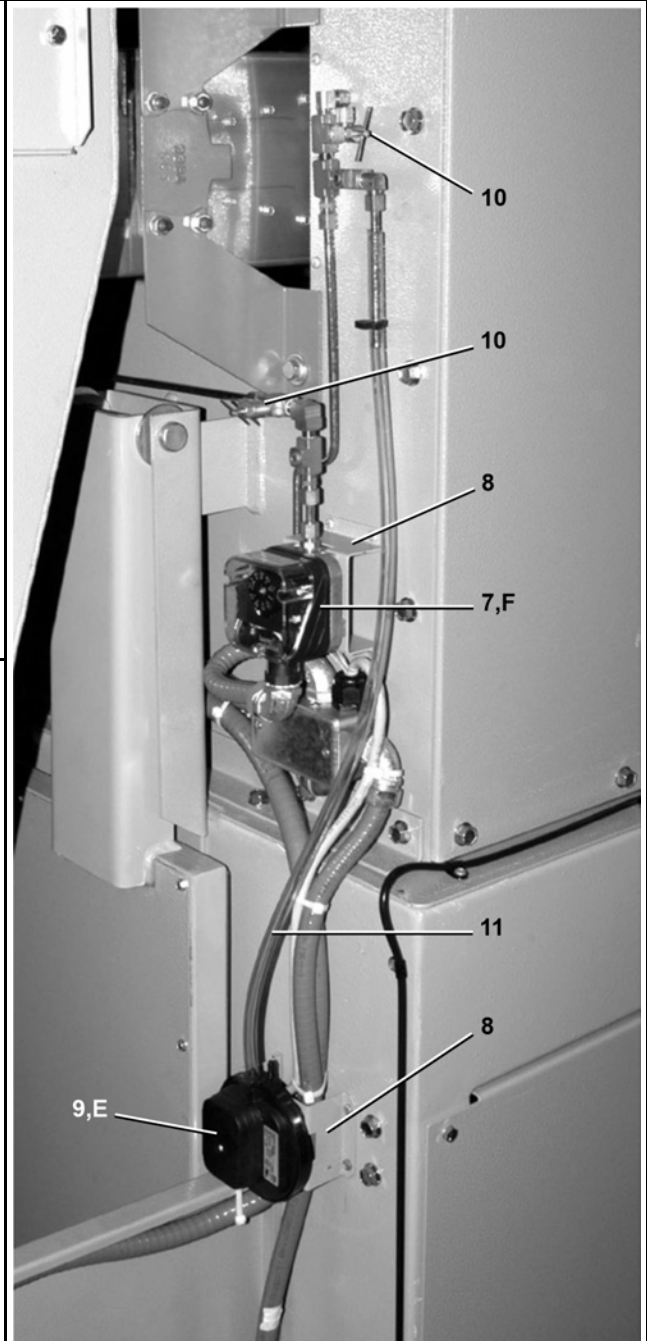
3 Sheets

6458TG1R,TG1L; 6464TG1R,TG1L



Legend

- C . . . Spark plug or igniter
- D . . . Flamerod
- E . . . Firebox back-pressure switch
- F . . . Combustion pressure switch



Firebox, Burner and Combustion Air

3 Sheets

6458TG1R,TG1L; 6464TG1R,TG1L

Table 59. 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	A77FB003A	64" DRYER LF AIR HEAT BRNR FILTERBOX ASSEMBLY	6458, 6464 LEFT
	B	A77FB003B	64" DRYER RT AIR HEAT BRNR FILTERBOX ASSEMBLY	6458, 6464 RIGHT
	E	A77CP001	6458 COMB. PRES. SW. ASSY	
	F	G77FB001B	6458 FIREBOX INSTALL	LEFT
	G	G77FB001C	6458A FIREBOX INSTALL	RIGHT
	J	A77FP001	64" DRYER FIREBOX PRESSURE SW ASSY	
	K	EC61DGFB37	*M5 6458 GAS FIRE EYE ASSY	U.S.
	L	EC61DGFC37	*M5 6458 GAS L&G FIRE CNT ASSY	CE (EUROPE)
Components				
A	1	A77FB001B	6458 FIREBOX ASSEMBLY	
B	1	A77FB001C	6458A FIREBOX ASSEMBLY	
AB	2	25AB242	64" AH DRYER: BURNR/BLWWHEL 160AH 2MLW/201AH	
all	3	25AB242BW	BLOWERWHEL FOR 160AH 240AH BNR	
A	4	W7 71010	WLMT=COMB AIR 6458	
B	4	W7 71010A	WLMT=COMB AIR 6458A	
all	5	07 71014	COVER=CLEAN OUT 6458COMB AIR	
AB	6	W7 71035	WLMT=6458 COMB AIR SCREEN	
K	7	09N19106B	GAS PRESS SW RANGE .2-2.4"WC	U.S.
L	7	09N19106C	GAS PRESS SW RANGE .2-2.4"WC=CE	CE (EUROPE)
all	8	03 BL3X4	PRESSURE SWITCH BRACKET 6458	
K	9	09N19111	AIR PRESSW RANGE .08-.4	U.S.
L	9	09N19111A	AIR PRESSW RANGE .08-.4 CE	CE (EUROPE)
all	10	96H018	ANGLE NEEDLE VLV 1/4" T X 1/8MP	
all	11	60E005D	TUBING 1/4" ID X 7/16" OD EXCELLON	
all	12	07 71067	6458 BURNER SUPP BKT TOP LF	
all	13	07 71067A	6458 BURNER SUPP BKT TOP RF	
all	14	25AS002	SPARK PLUG SELF GROUNDING AUBURN I-3	
all	15	25AR001A	FLAME ROD, 0.25NPT, 5.75" LONG FRS 4-6	
all	16	30RA175T	THERMOSTAT OPENS AT 175F	

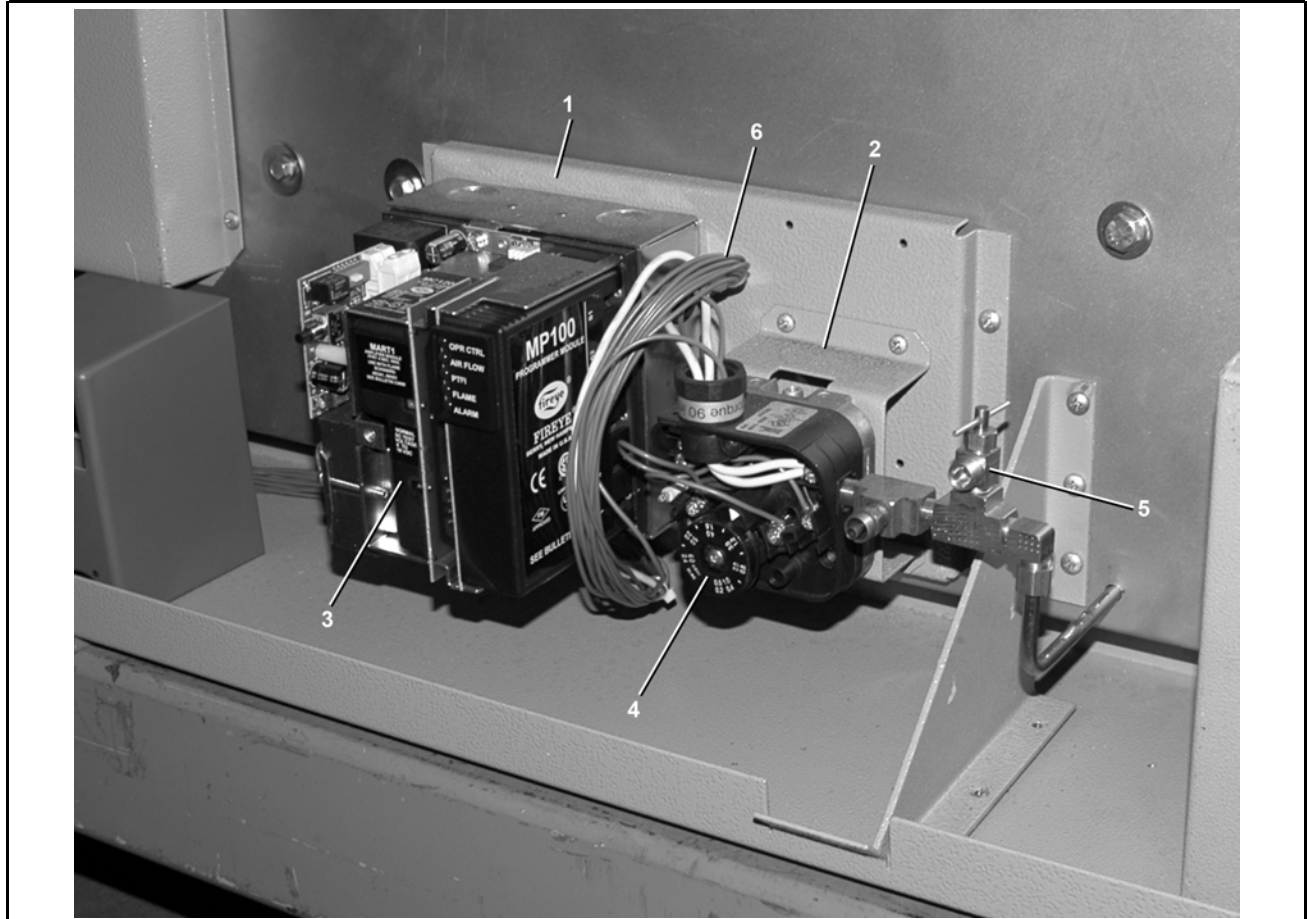
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Gas Fire Eye Assembly

1 Sheet

6458TG1L/R; 6464TG1L/R

**Table 60. Parts List—Gas Fire Eye 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	EC61DGFB37	*M5 6458 GAS FIRE EYE ASSY	
Components				
all	1	07 71207	6458 FIREYE MOUNT BKT	
all	2	03 BL3X4	PRESSURE SWITCH BRACKET 6458	
all	3	09X150A3	FLAMESAFE CTL ASSY #MC120	
all	4	09N19106B	GAS PRESS SW RANGE .2-2.4"WC	
all	5	96H018	ANGLE NEEDLE VLV 1/4" T X 1/8MP	
all	6	10Y6DR6FE	MK V 64 DRYER FIRE EYE	

Inlet Probe Assembly

1 Sheet

6458TG1L/R; 6464TG1L/R

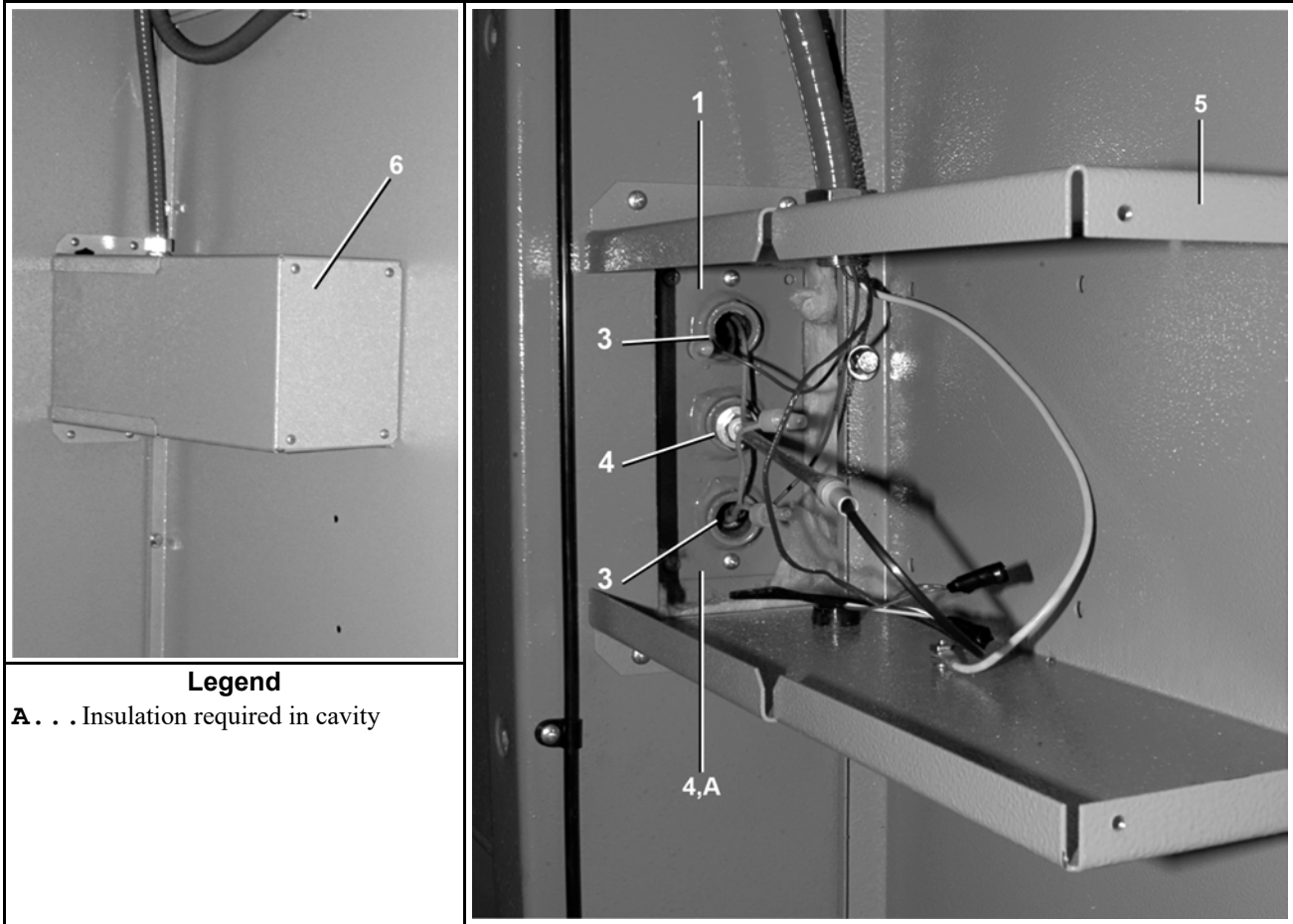


Table 61. Parts List—Inlet Probe Assembly

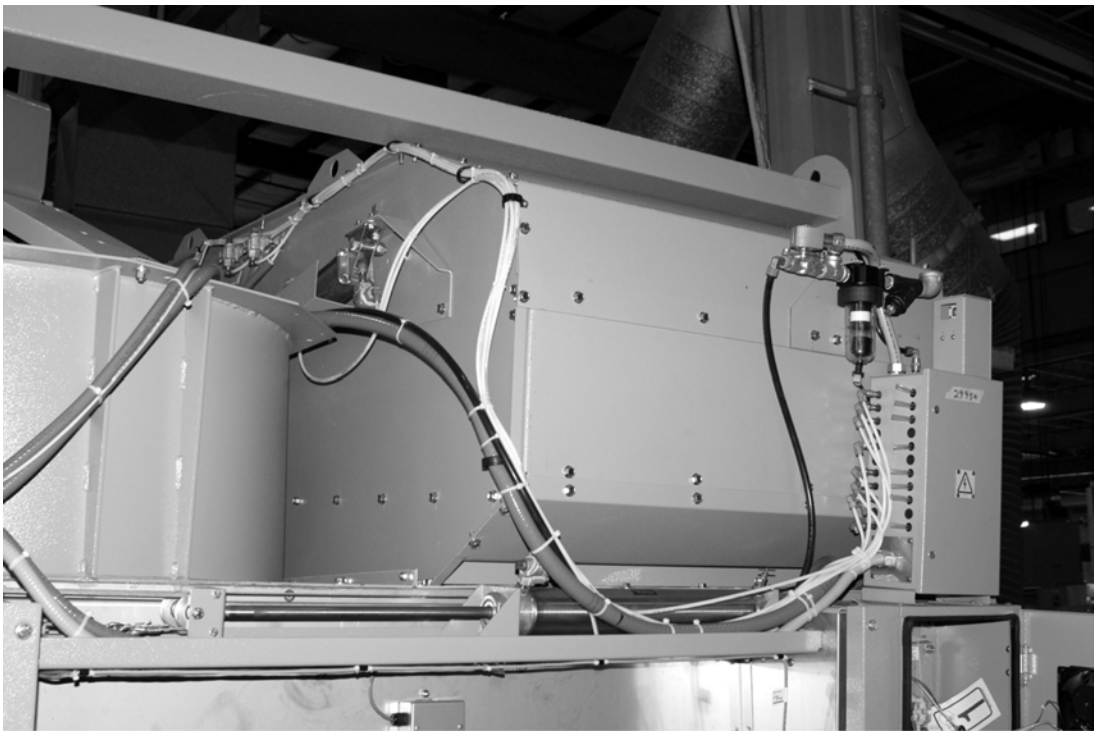
Find the assembly for your machine and the letter shown in the "Item" column. The components for your machine will show this letter or the word "all" in the "Used In" column. The numbers shown in the "Item" column are those shown in the illustrations.				
Used In	Item	Part Number	Description/Nomenclature	Comments
Reference Assemblies				
	A	A77TP001	6458 INLET PROBE ASSEMBLY	
Components				
all	1	W3 BF3X5C	DRYER ANGLED INLET TEMP PROBE HOLDER	
all	2	30R0045PP	DRYER T/C 24" PROBE ASSY	
all	3	30R0550P	THERMOSW.FENWAL OPEN @ 550F	
all	4	98P030	INSUL.FIBRGLS.24X48X1+1/2E=1SH	
all	5	07 71306	6458 TEMP PROBE BOX	
all	6	07 71307	6458 TEMP PROBE BOX COVER	

8 Steam Assemblies

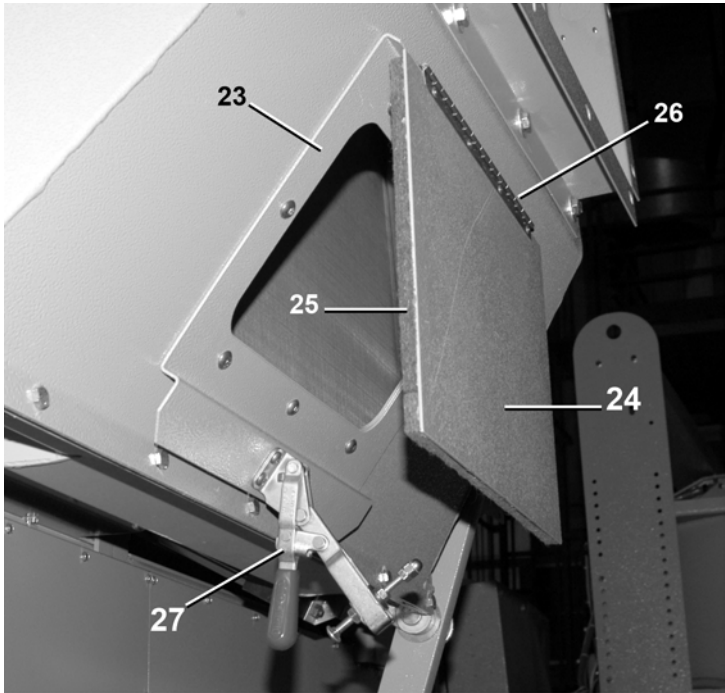
Steam Components

8 Sheets

6450TS1L/R; 6458TS1R/L; 6464TS1R/L



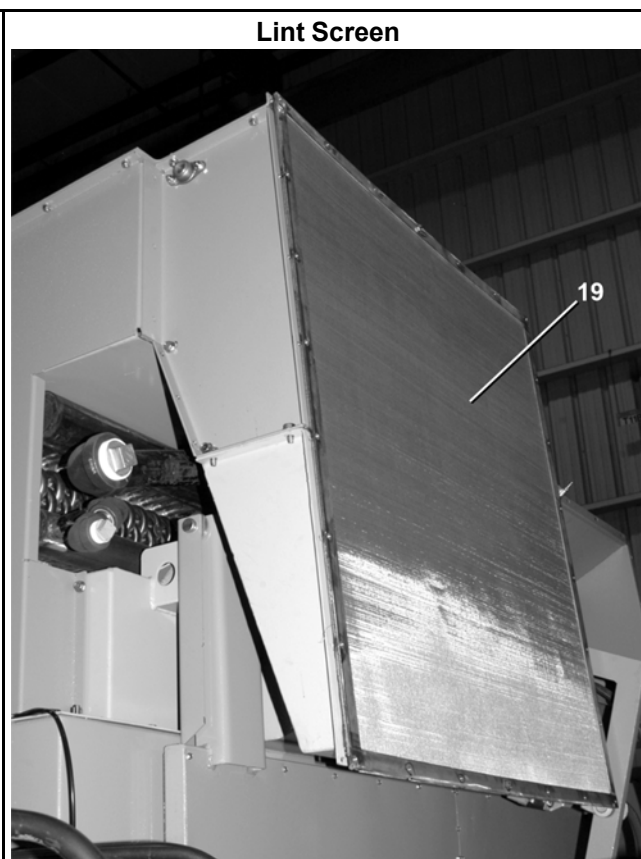
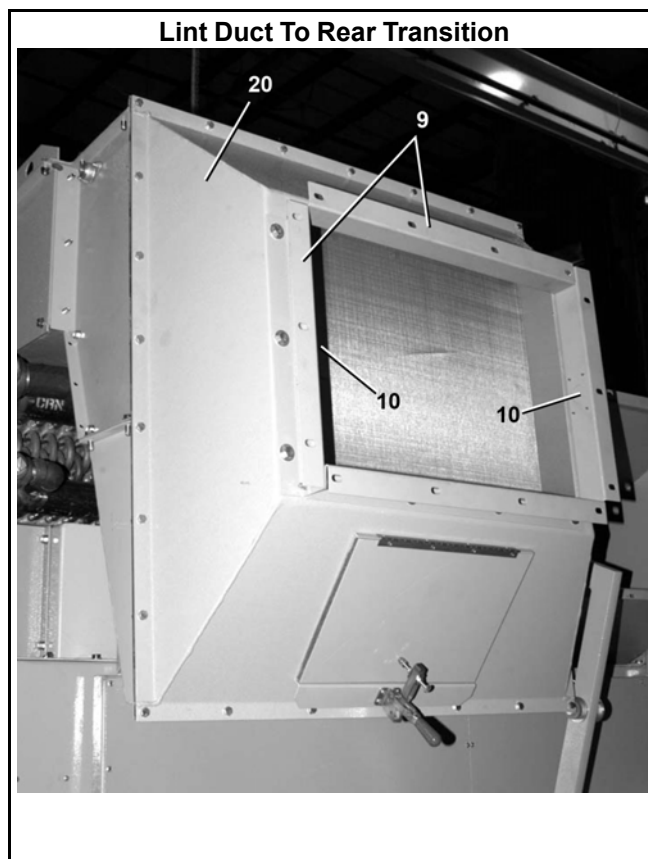
Lint Access Door



Steam Components

8 Sheets

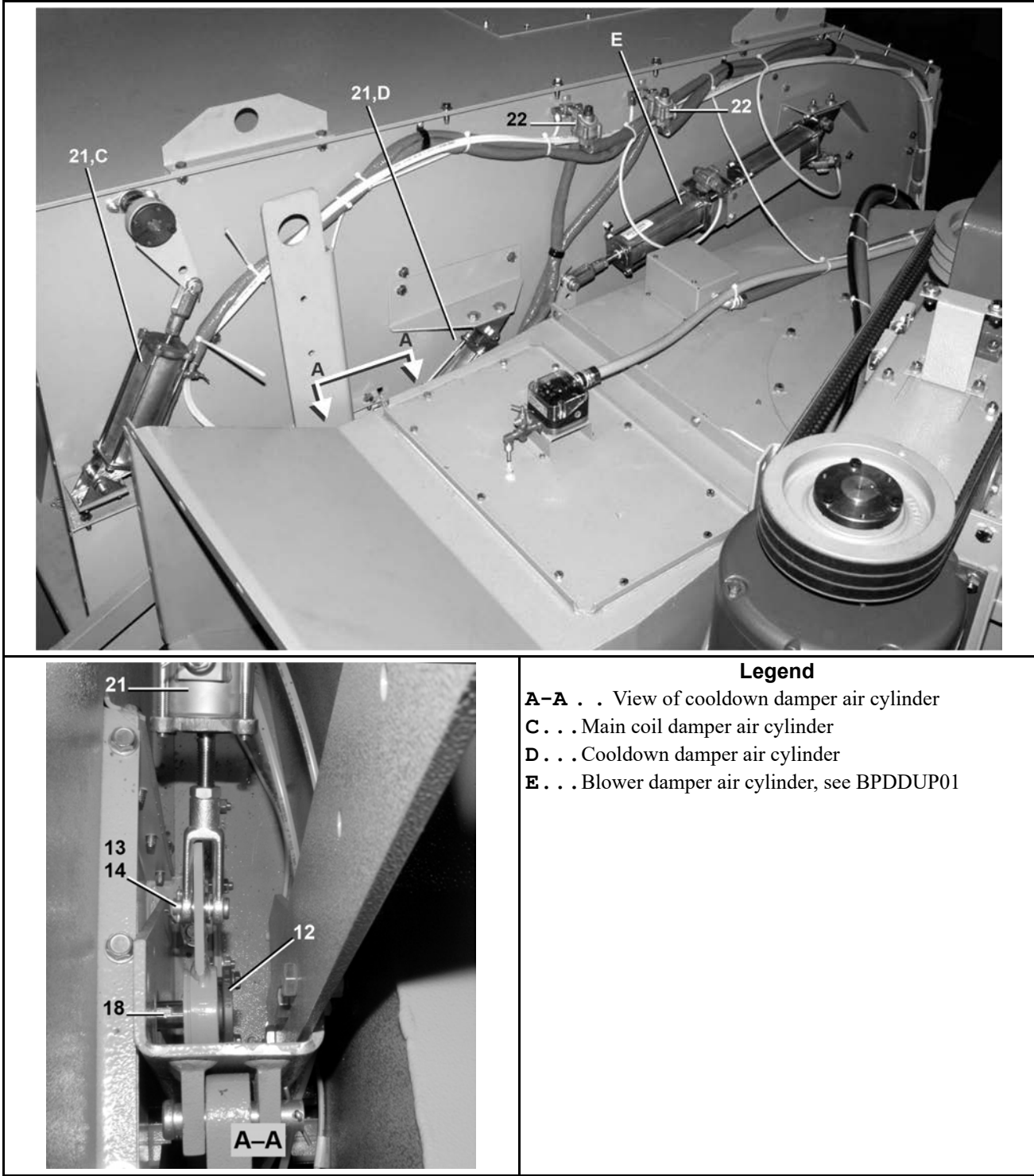
6450TS1L/R; 6458TS1R/L; 6464TS1R/L



Steam Components

8 Sheets

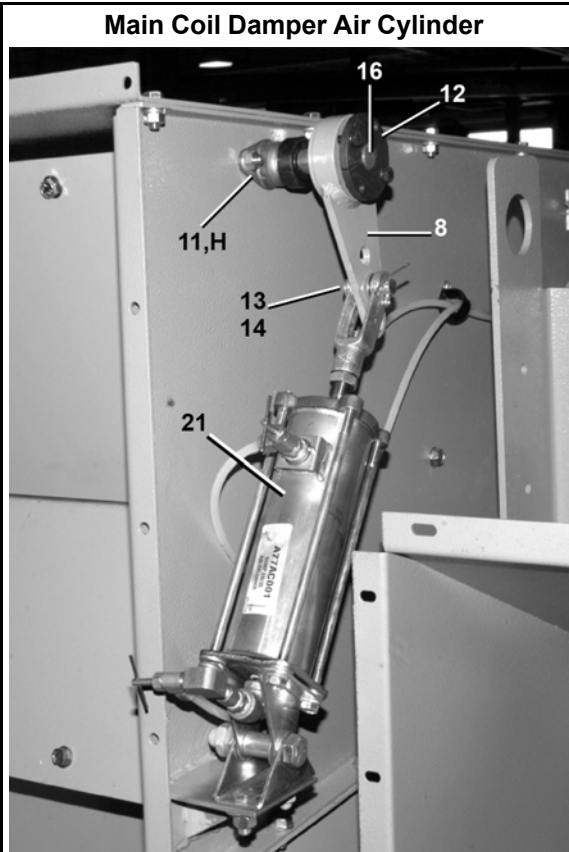
6450TS1L/R; 6458TS1R/L; 6464TS1R/L



Steam Components

8 Sheets

6450TS1L/R; 6458TS1R/L; 6464TS1R/L



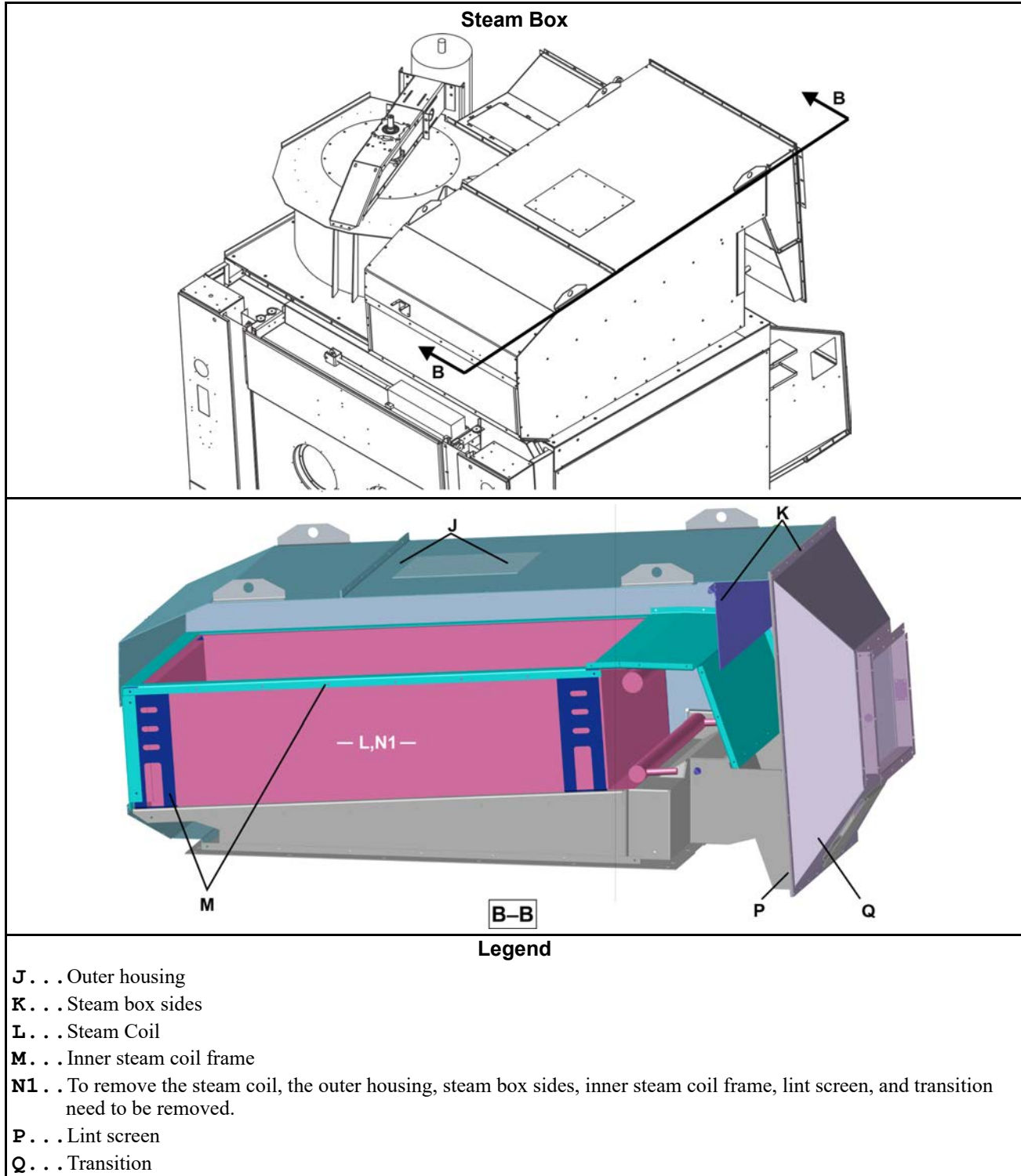
Legend

- F** . . . Main coil damper
- G** . . . Cooldown damper
- H** . . . 4 places

Steam Components

8 Sheets

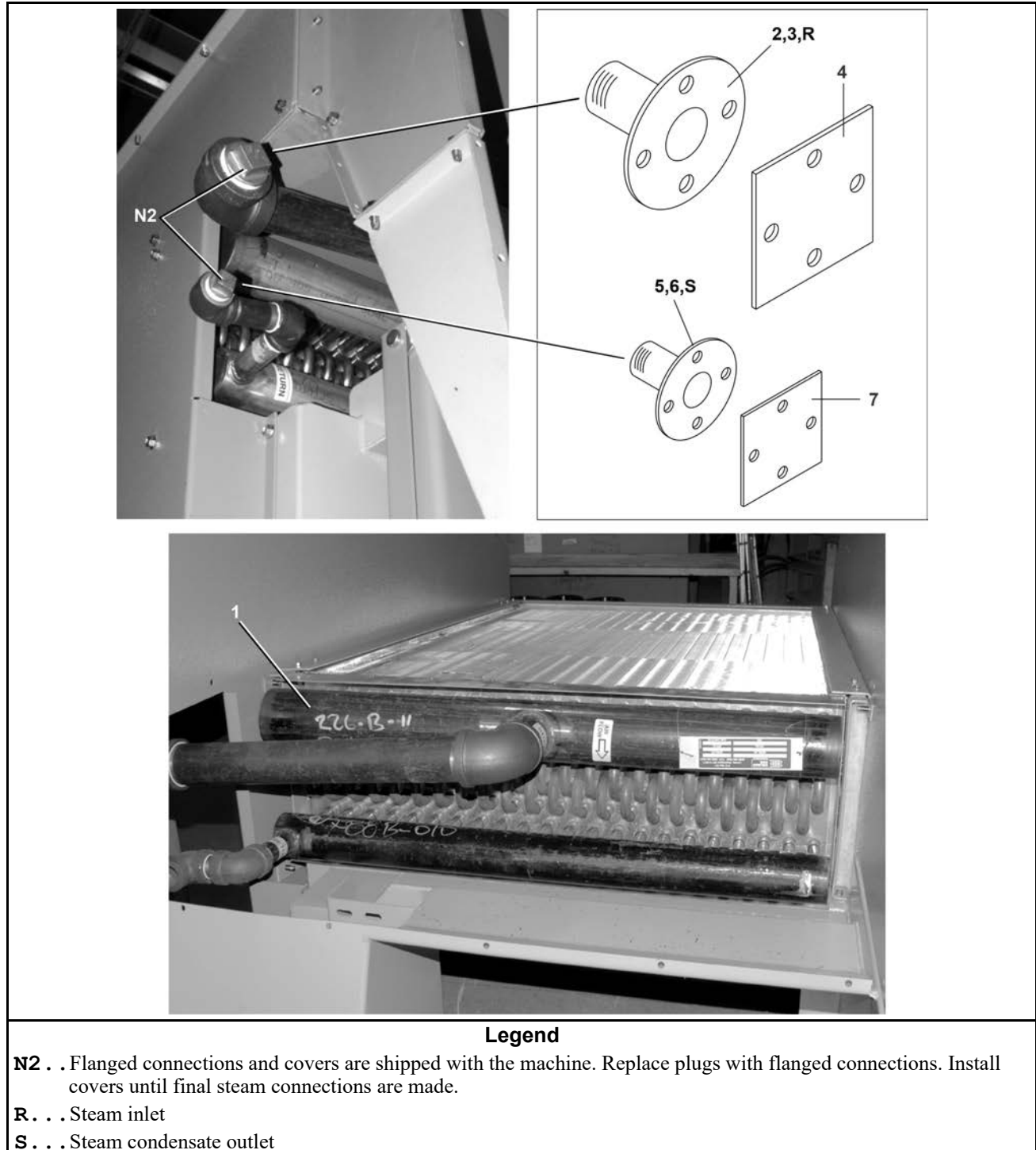
6450TS1L/R; 6458TS1R/L; 6464TS1R/L



Steam Components

8 Sheets

6450TS1L/R; 6458TS1R/L; 6464TS1R/L



Steam Components

8 Sheets

6450TS1L/R; 6458TS1R/L; 6464TS1R/L

Table 62. Parts List—Steam 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				
	A	G77SB002	6458 LOW STEAM BOX LEFT	
	B	G77SB002A	6458 LOW STEAM BOX RIGHT	
Components				
all	1	27HS3452FL	STEAMCOIL 34.5"X52" CARB LFT	6458/6464TSIL
all	1	27HS3452FR	STEAMCOIL 34.5"X52" CARB RGT	6458/6464TSIR
all	1	27HS3452SL	STEAMCOIL 34.5"X52" SS LEFT	6458/6464TSIL
all	1	27HS3452SR	STEAMCOIL 34.5X52 STAINLESS RT	6458/6464TSIR
all	2	51KE2ANA	NPTFLANGE 2"CS 150#RAISED FACE	
all	3	51KE2ANGAK	2 INNER X4 OUTER DIAMETER STEAM FLANGE GASKET	
all	4	07 40609	2" NPT FLANGE COVER	
all	5	51KE1ANA	NPTFLANGE 1"CS, 150#RAISEDFACE	
all	6	51KE2ANAG	GSKT-1"FLANGE-1 5/16X 2 5/8	
all	7	07 40608	1" NPT FLANGE COVER	
all	8	W7 71098	6458 BLOWER DAMPER ARM WELD	
all	9	07 71116	6458 FENWAL DUCT SIDE	
all	10	07 71115A	6458 FIRBOX FENWAL HOLE CVR	
all	11	54E015	FLGMTBRG 3/4 BORE BRZ #FLB12	
all	12	56Q0PH	3/4" BROWNING H BUSHING TYPE 1	
all	13	17A040	CLEVIS PIN 1/2"X1+3/8" DRILLED	
all	14	15H051	STDCOTTERPIN 1/8X1+1/2ZINCPL	
all	15	07 71735	6458 STM- MAIN COIL DAMPER	
all	16	X7 71738	6458 STM- SHAFT COIL DAMPER	
all	17	07 71736	6458 STM- COOLDOWN DAMPER	
all	18	X7 71739	6458 STM- SHAFT COOL-DOWN	
all	19	W7 71742	6458 - STM LINT SCREEN	
all	20	W7 71730A	6458 STM- INLET WLMT RT	
all	21	A77AC001	6458 STEAM 4" LARGE DAMP CYL	
all	22	96M055	DELTROL QUICK EXHAUST VLV.1/4"	
all	23	07 71750	LINT CLEAN OUT MOUNT	
all	24	07 71751	6458 STM LINT CLEANOUT CVR	
all	25	27A682	FELT 3/8"THK X 1"W SAE F-7	

Steam Components

8 Sheets

6450TS1L/R; 6458TS1R/L; 6464TS1R/L

Table 62 Parts List—Steam 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
all	26	X2 18682	HINGE=SOAP CHUTE LID-11 7/8"	
all	27	27A700	TOGGLECLAMP GOODHAND E=1	

9 Water Assemblies

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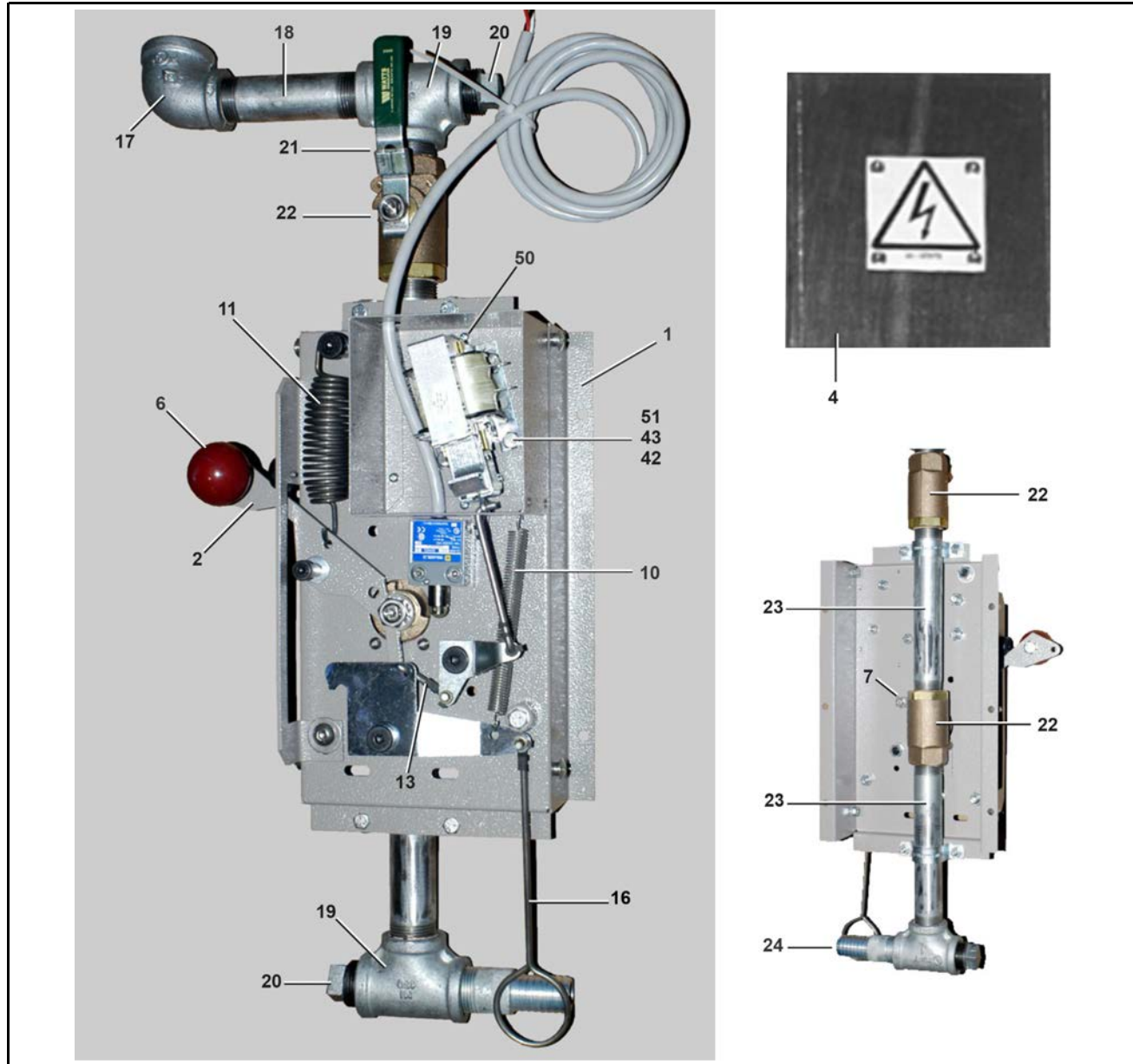
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Sprinkler Assembly

4 Sheets

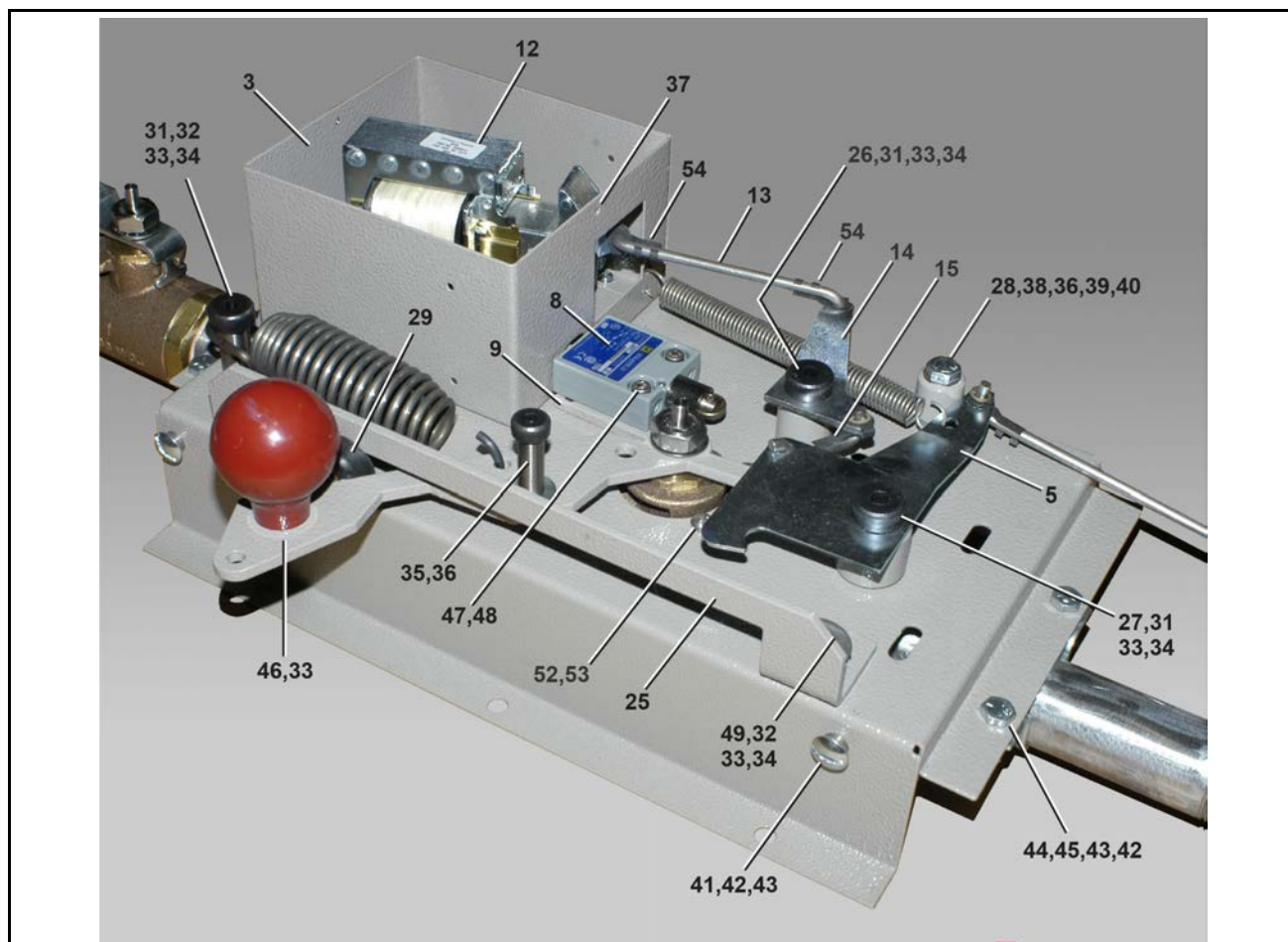
All Dryers



Sprinkler Assembly

4 Sheets

All Dryers



Sprinkler Assembly

4 Sheets

All Dryers

Table 63. 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	NPTLNB 90DEG 1.25X1 GALM 150#	
all	18	5N1A05AG42	NPT NIPPLE 1X5 TBE GALSTL SK40	
all	19	5S1ANFA	NPT TEE 1" GALMAL 150#	
all	20	5SP1ADESC	NPT PLUG 1" SQ CORED GAL CI	
all	21	5N1ACLSG42	NPT NIP 1XCLS TBE GALSTL SK40	
all	22	96D085WEXS	BALVAL 1"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 63 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 Pneumatics

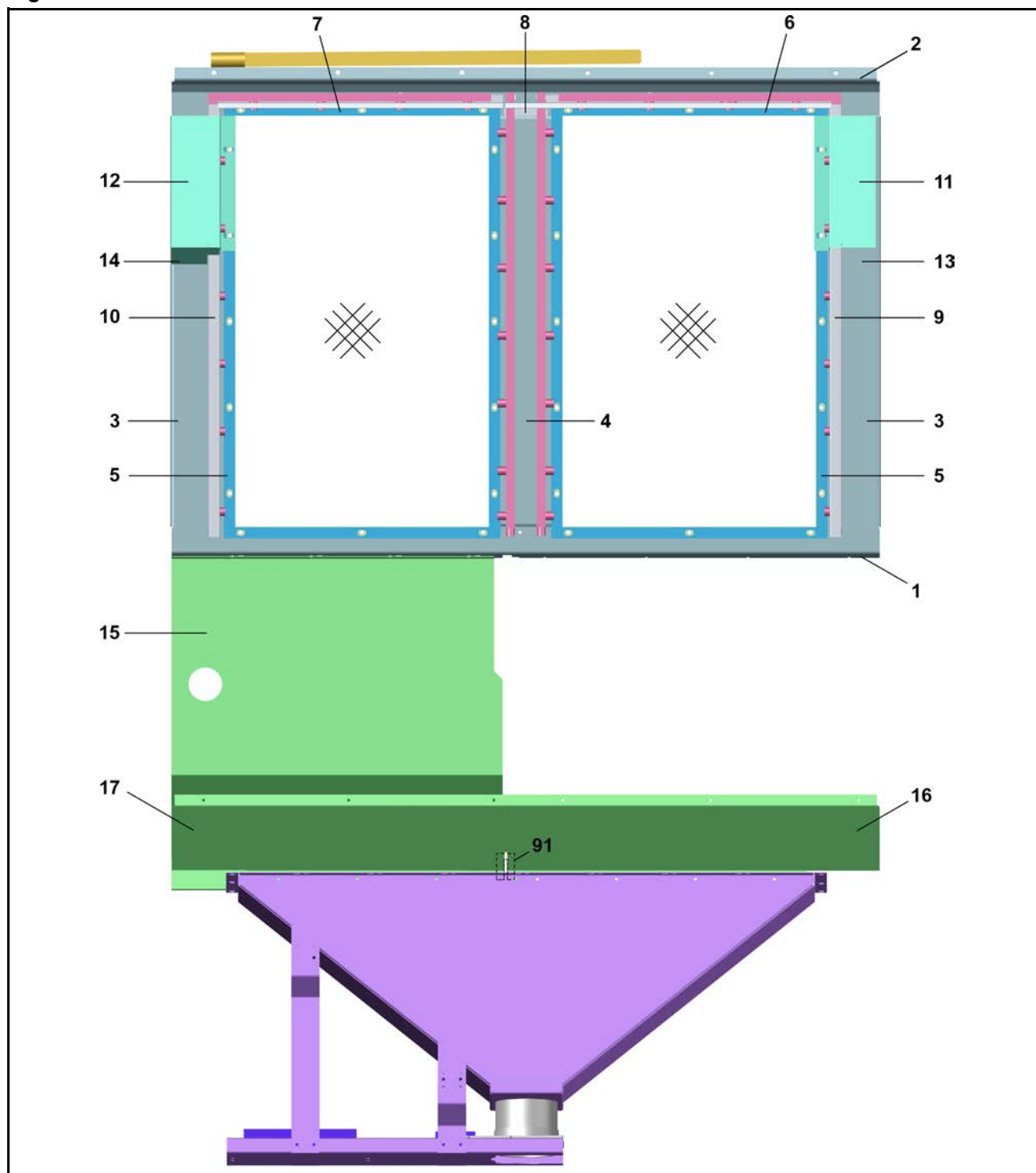
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Internal Lint Screens

15 Sheets

50050, 64058, 64064, 76076, 82082 Dryers

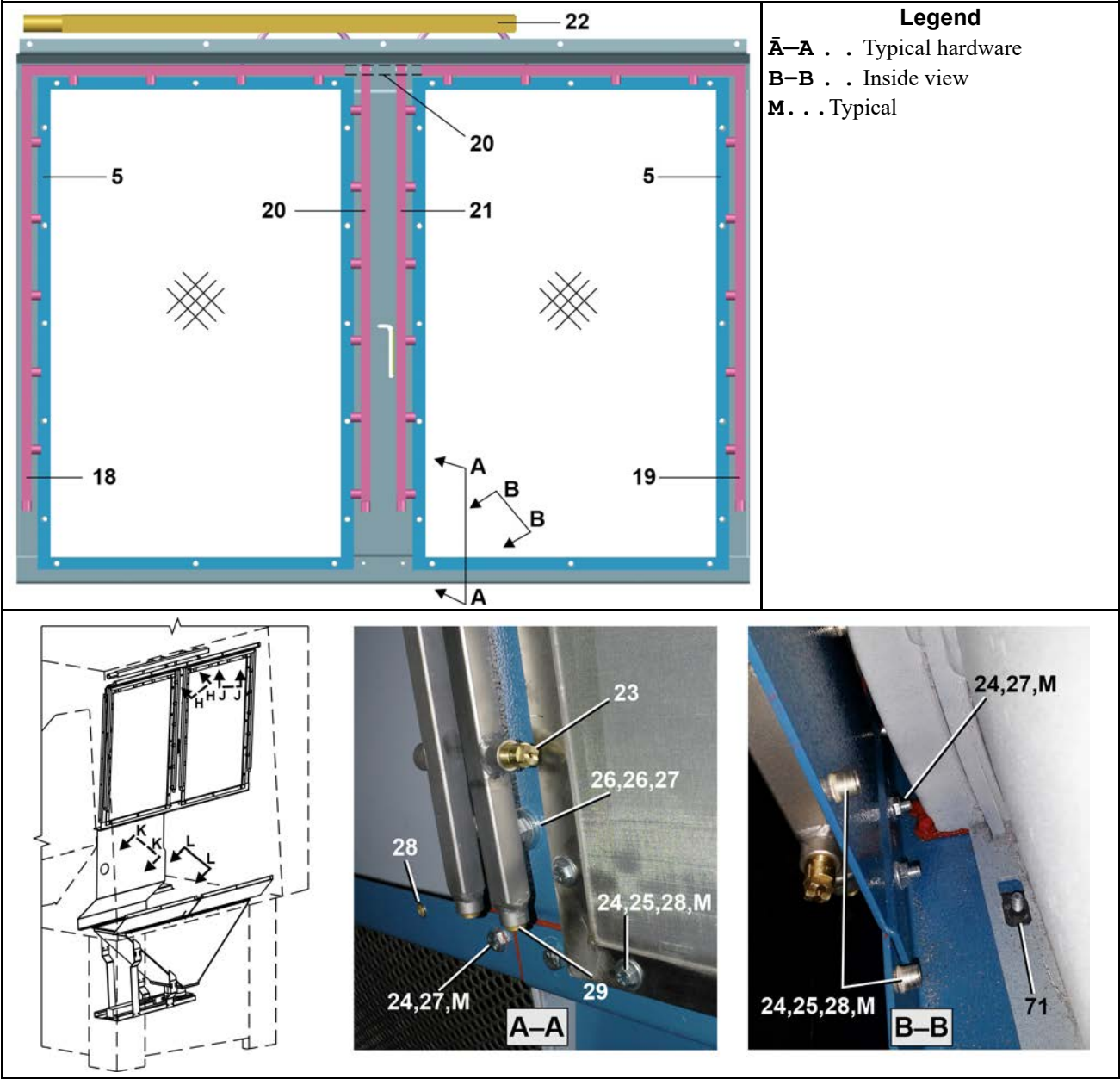
Figure 55. Installation Lint Screens

Internal Lint Screens

50050, 64058, 64064, 76076, 82082 Dryers

15 Sheets

Figure 56. Air Nozzles, Hardware

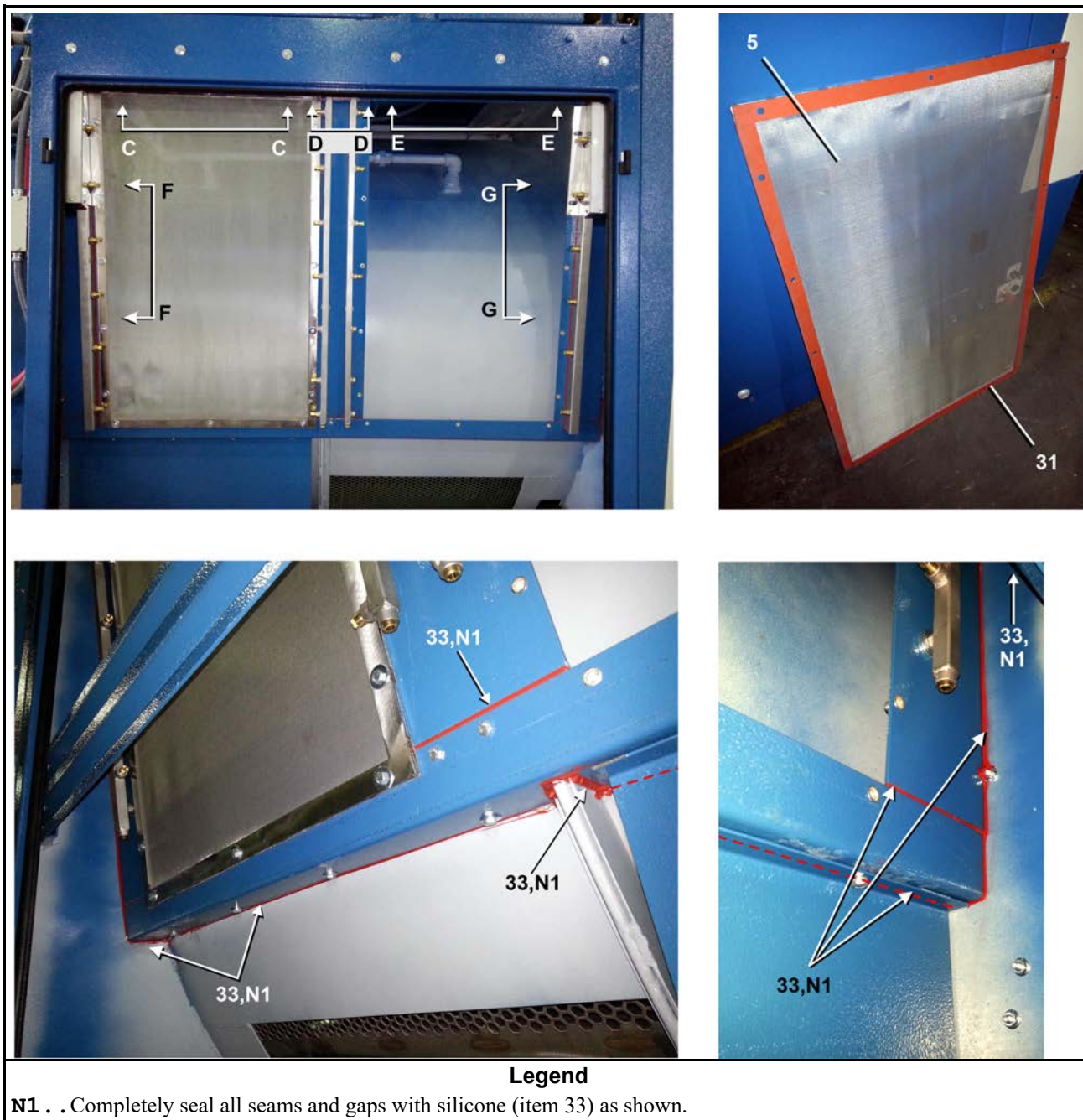


Internal Lint Screens

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Figure 57. Silicone Sealing

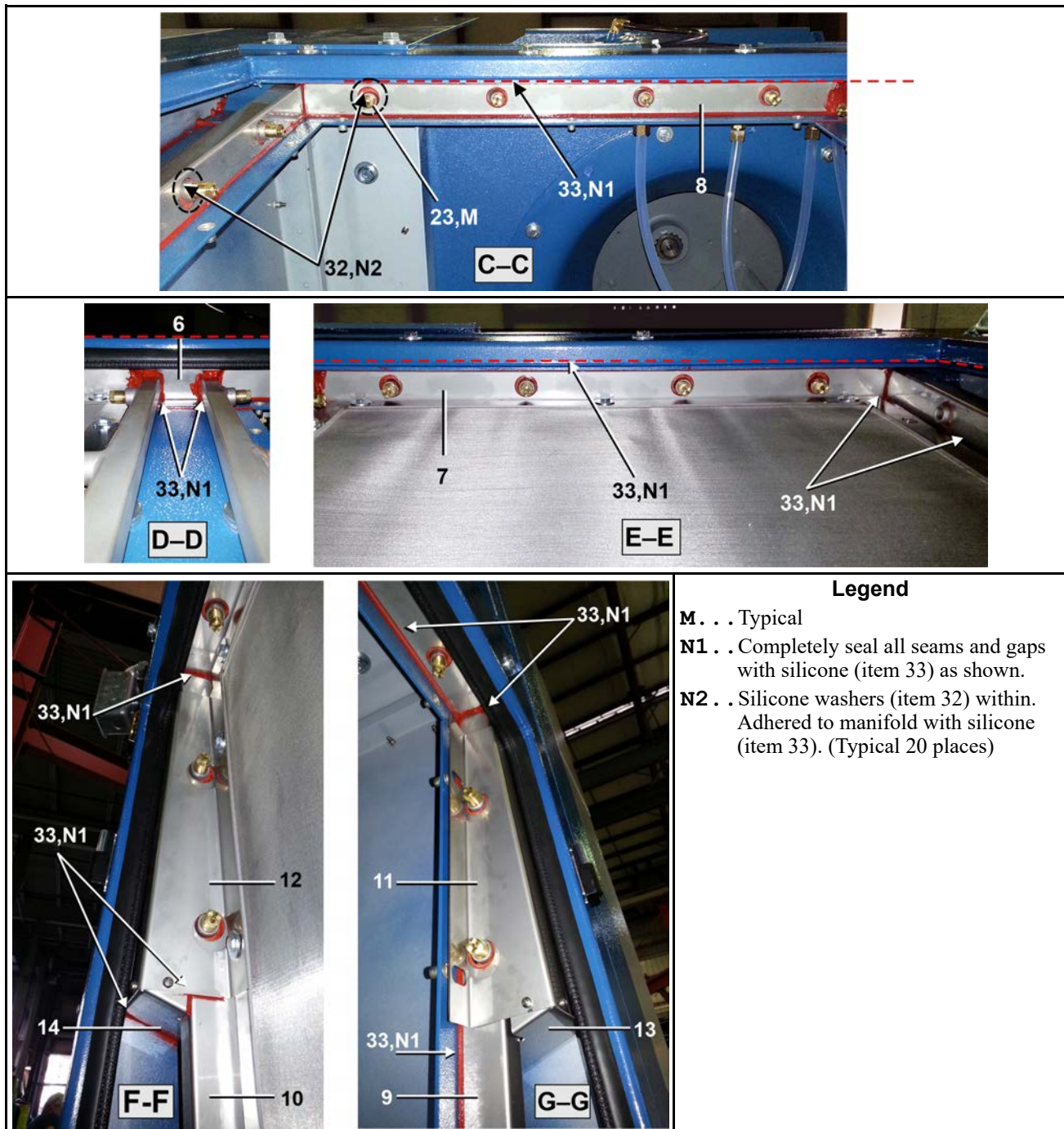


Internal Lint Screens

50050, 64058, 64064, 76076, 82082 Dryers

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Figure 58. Silicone Sealing Continued

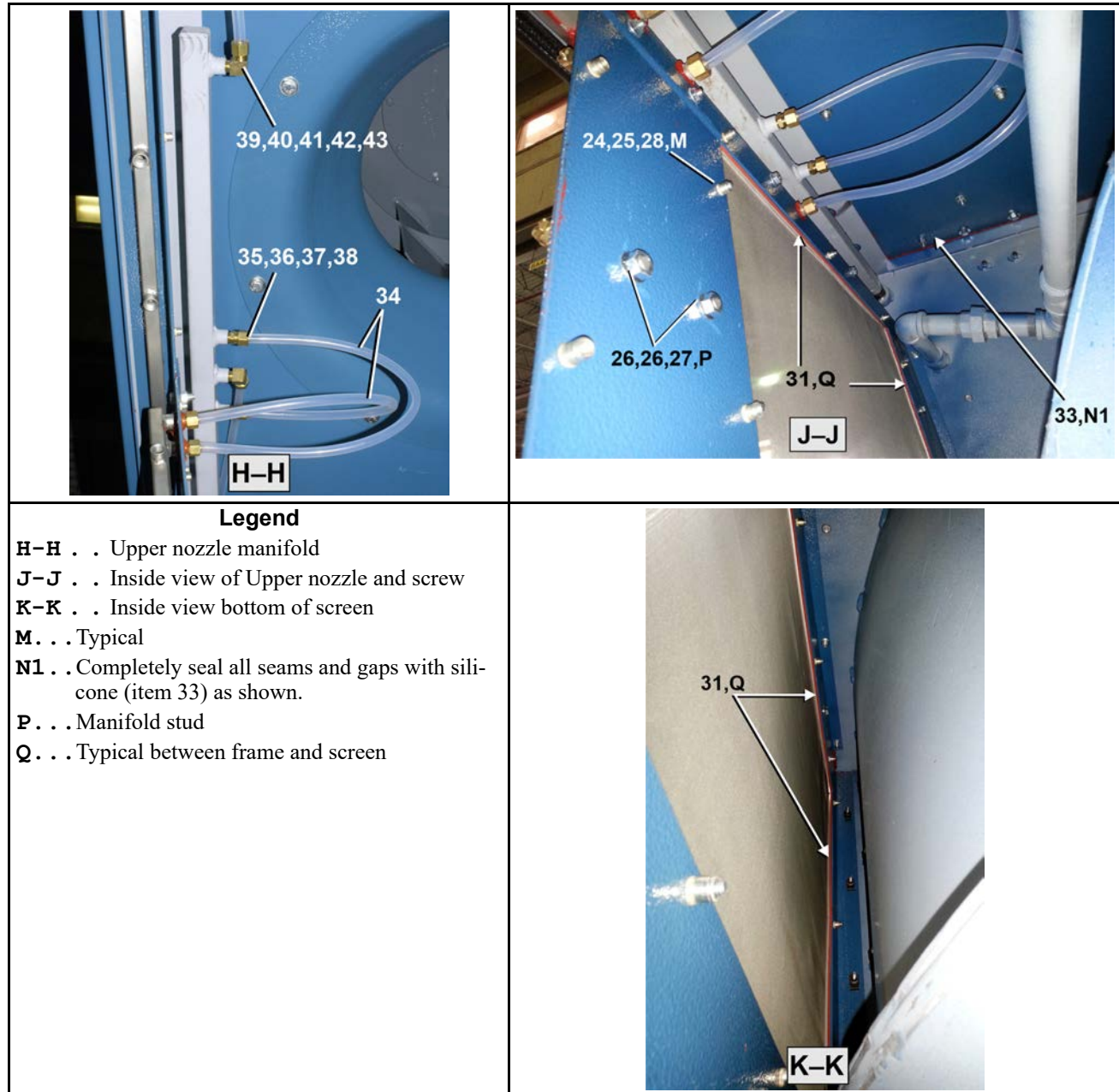


Internal Lint Screens

50050, 64058, 64064, 76076, 82082 Dryers

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Figure 59. Lint Screens, Air Nozzles, Silicone Sealing

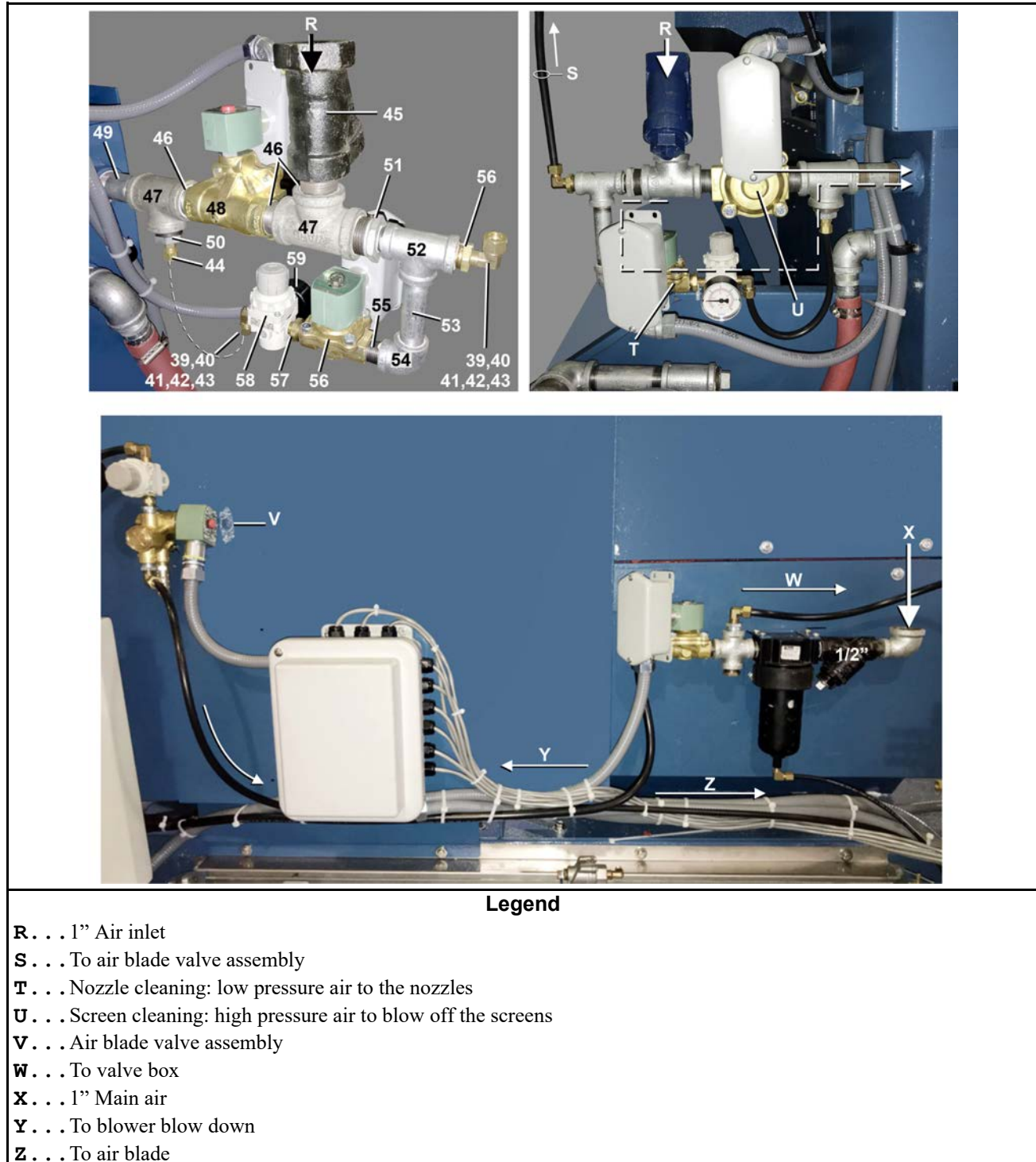


Internal Lint Screens

50050, 64058, 64064, 76076, 82082 Dryers

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Figure 60. Internal Lint Air Inlet and Valves

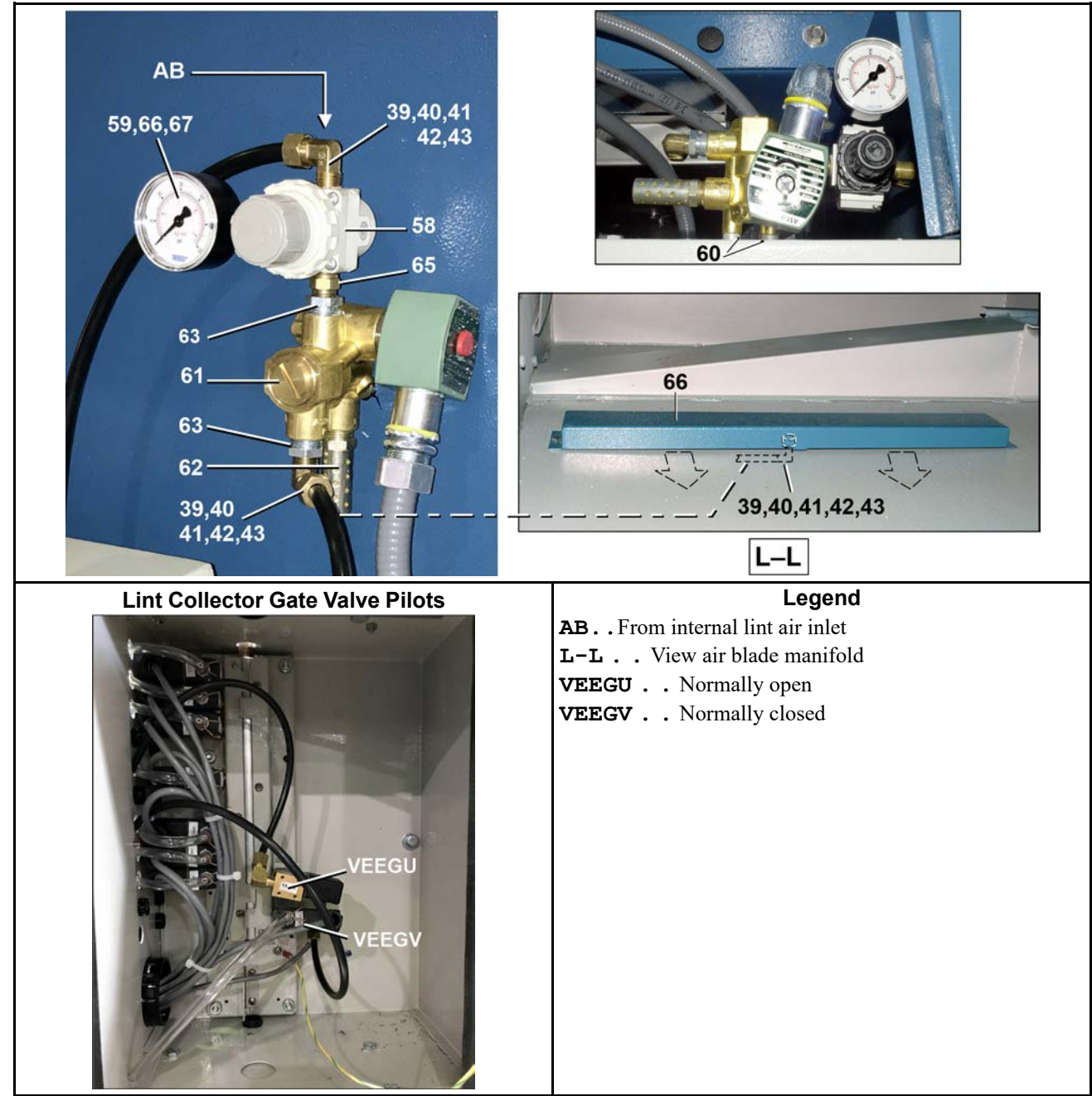


Internal Lint Screens

15 Sheets

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Figure 61. Air Blade Valve Assembly and Lint Collector Pilots

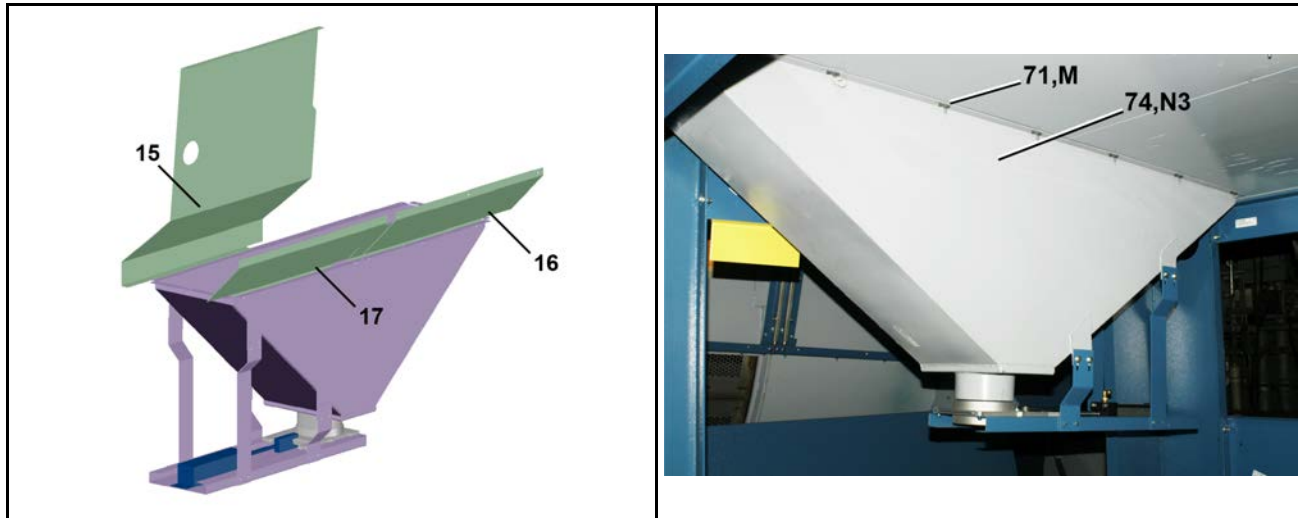


Internal Lint Screens

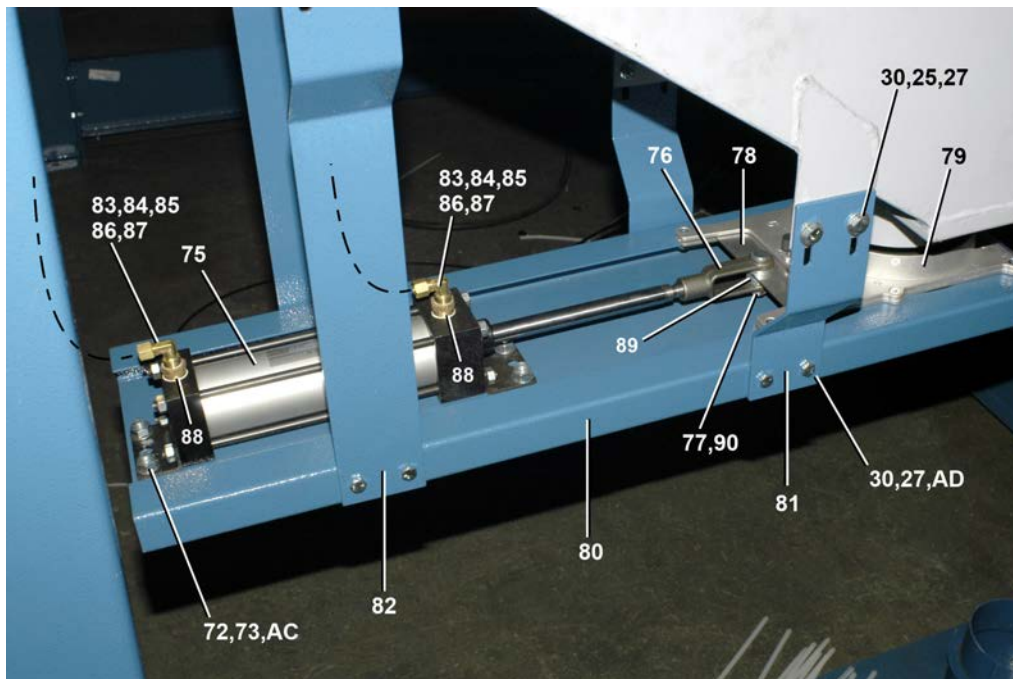
50050, 64058, 64064, 76076, 82082 Dryers

15 Sheets

Figure 62. 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

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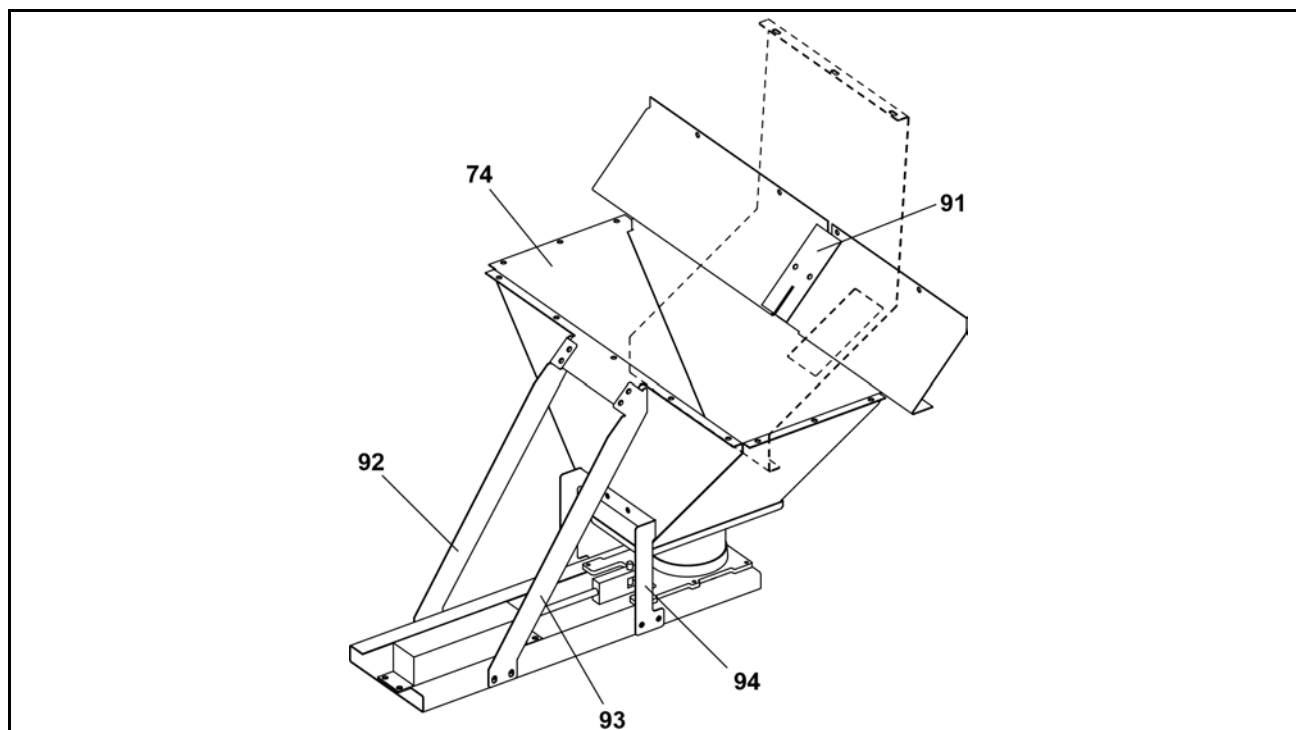


Table 64. Parts List—Internal Lint Screens

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

50050, 64058, 64064, 76076, 82082 Dryers

Table 64 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 SCRIN 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 BTM-REAR	
K	1L	A79RN022A	ASSY=7676 RITE LINT SCREEN BRKT BTM-FRONT	
J	1R	A79RN022	ASSY=7676 LEFT LINT SCREEN BRKT BTM-FRONT	
K	1R	A79RN025A	ASSY=7676 RITE LINT SCREEN BRKT BTM-REAR	
L	1	A82RN131	8282 LT LINT SCREEN LOWR SPRT W/RVNT	
M	1	A82RN131A	8282 RT LINT SCREEN LOWR SPRT W/RVNT	
AB	2	A74LS002	5040 LINT SCREEN RIVNUT TOP	
CD	2	A77RN002	ASSY=UPPER SCRIN 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

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Table 64 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

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50050, 64058, 64064, 76076, 82082 Dryers

Table 64 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 1/4-20UNC2AX1 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

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50050, 64058, 64064, 76076, 82082 Dryers

Table 64 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	NPTLNB 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	NPTLNB 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 64 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 64 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	

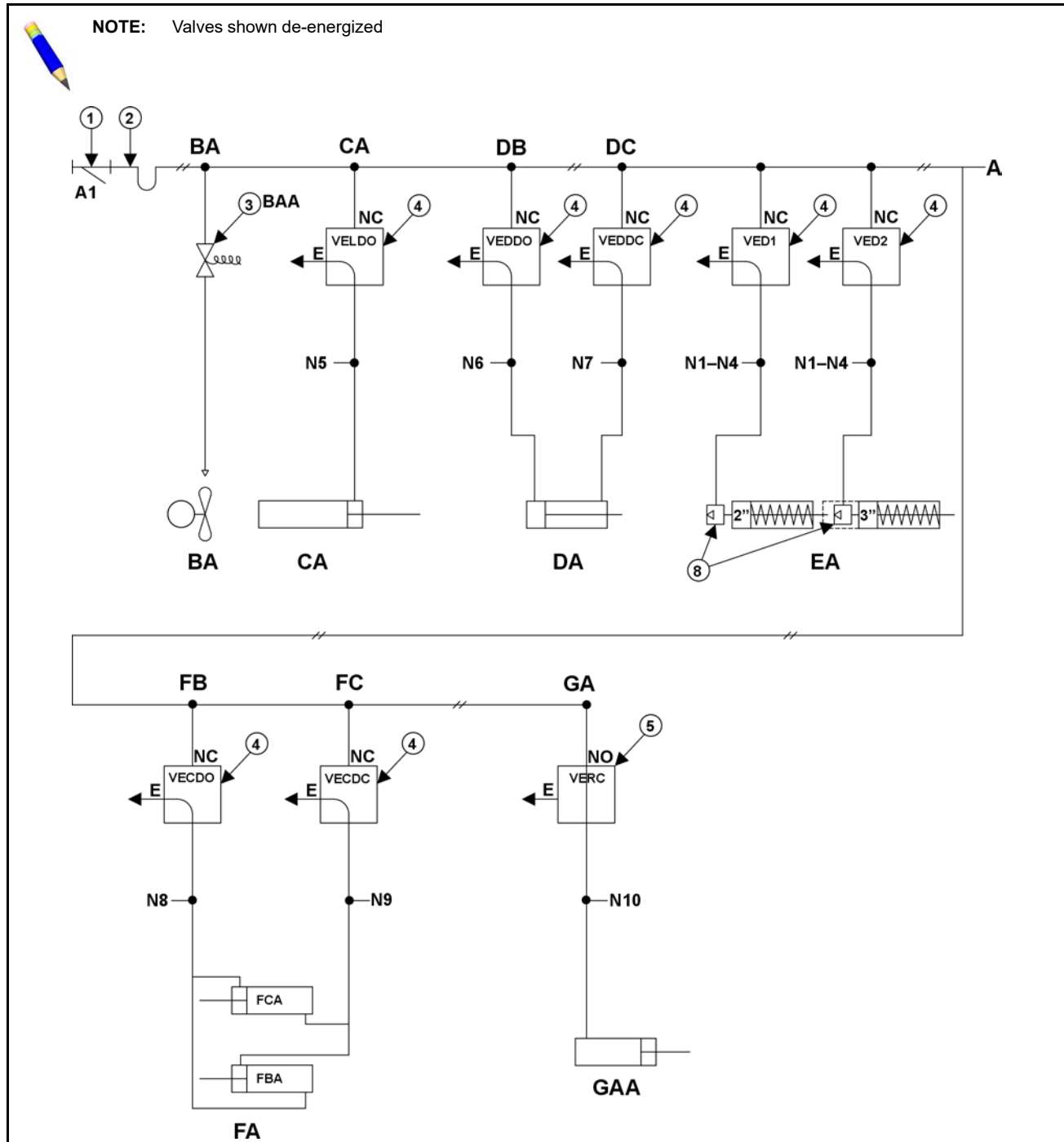
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Pneumatic Schematic

5 Sheets

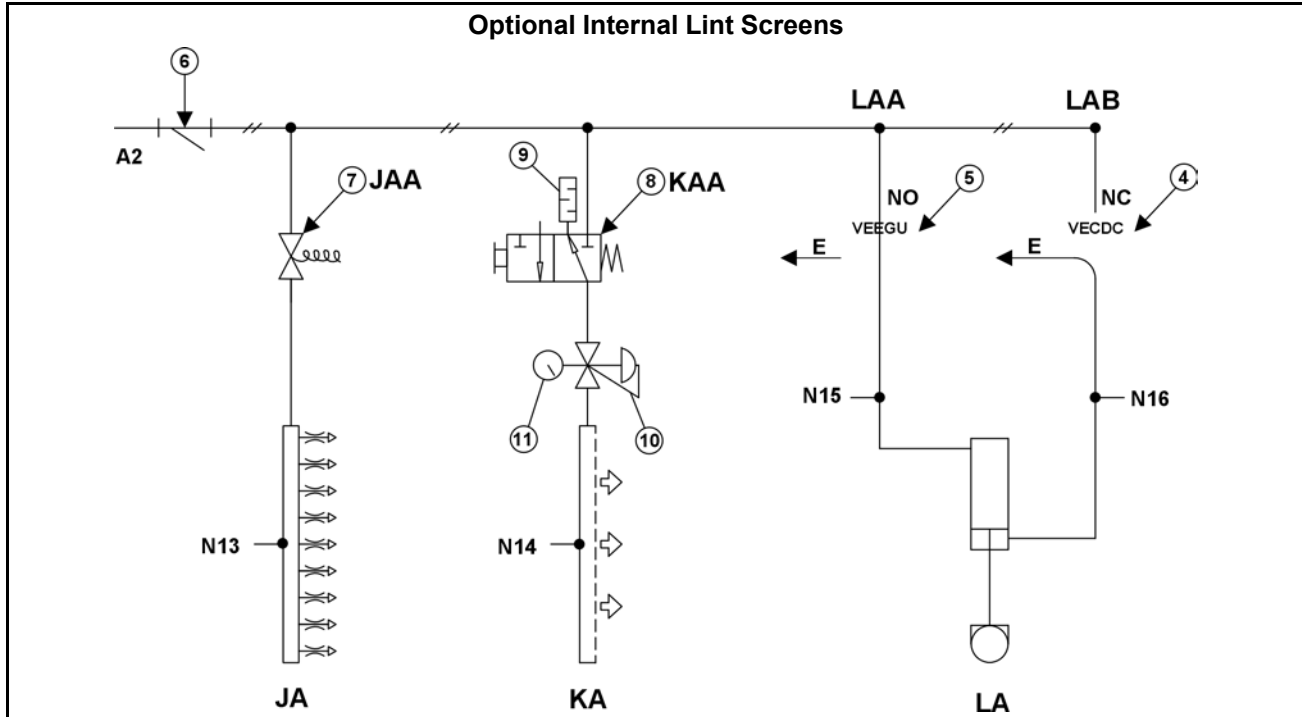
5050TG1L/R, TS1L/R; 6458TG1L/R, TS1L/R; 6464TG1L/R, TS1L/R; 7676TG1L/R; 8282TG1L/R



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

Legend	Legend
A . . . Connection point between schematic pages. A1 . . Main air 80–100 PSI A2 . . Secondary air inlet 80–100 PSI BA . . Blower blow down BAA . . N/C 2-way valve 1/2” CA . . Load door DA . . Unload door DB . . Discharge door open DC . . Discharge door closed E . . Exhaust EA . . Blower damper FA . . Steam Dampers (TS1 models only) FB . . Cooldown damper open FBA . . Cooldown damper FC . . Cooldown damper closed FCA . . Main coil damper 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	N1 . . Minimum air flow occurs when pressure is applied to all blower damper air cylinder actuators. N2 . . More than minimum air flow occurs when pressure is applied only to the 3” blower damper air cylinder actuator. N3 . . Less than maximum air flow occurs when pressure is applied only to the 2” blower damper air cylinder actuator. N4 . . Maximum air flow occurs when no pressure is applied to actuators. N5 . . Pressure is applied to actuator to open load door when pilot is energized. N6 . . Pressure is applied to actuator to close unload door when pilot is energized. N7 . . Pressure is applied to actuator to open unload door when pilot is energized. 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. 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. 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. 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. 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. N13 . . When the 2-way valve is energized, air flows to the lint screen blow down manifolds. N14 . . When the 3-way valve is energized, air flows to the pressure regulator and to the air blade. 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. N16 . . When the pilot is energized, air is allowed to retract the cylinder and open the gate valve.

Pneumatic Schematic

5 Sheets

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

Table 65. 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	

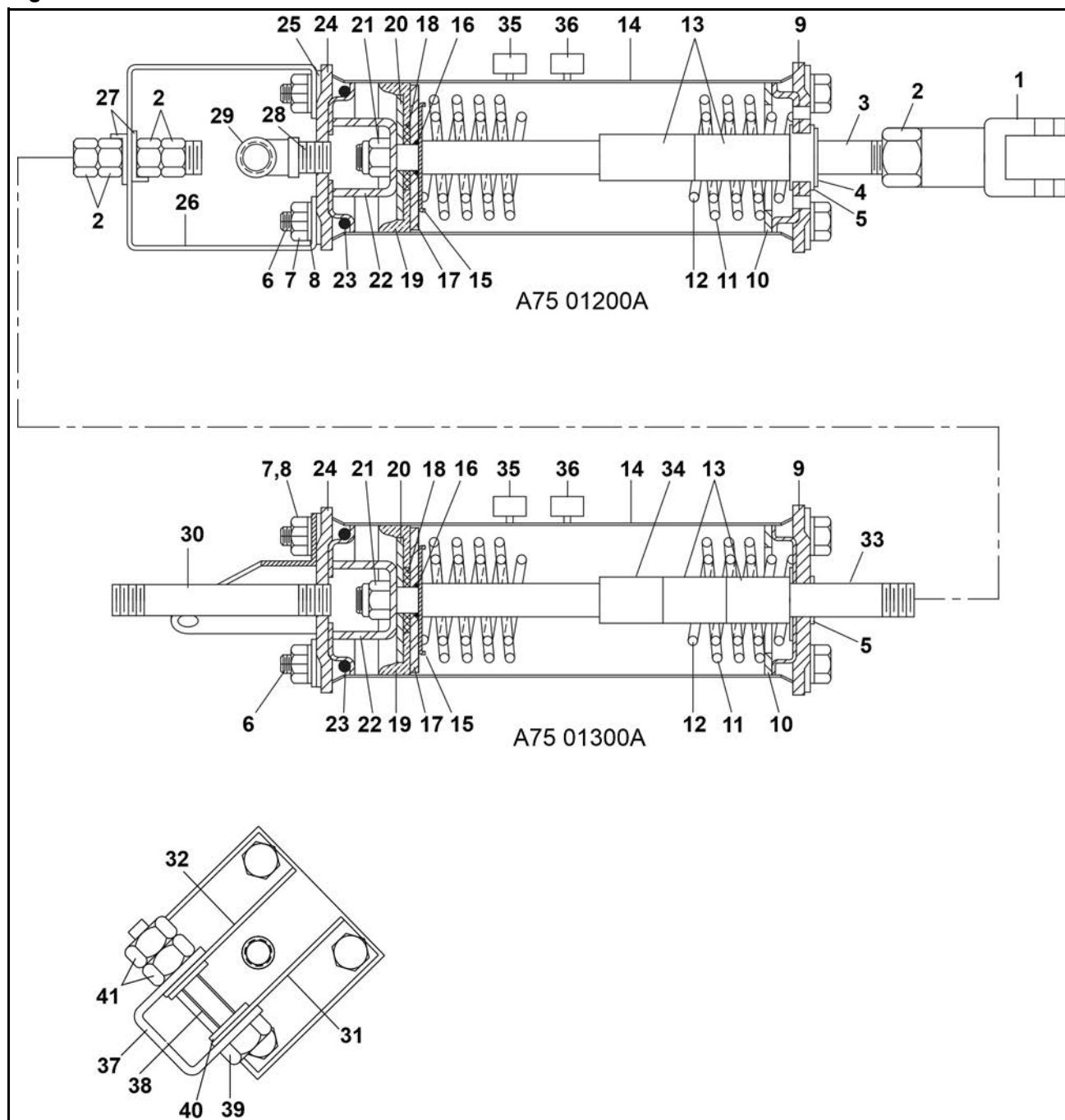
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Blower Main Damper Air Cylinders

3 Sheets

5050, 6458, 6464, 7676, and 8282 Dryers

Figure 63. Cross Section

Blower Main Damper Air Cylinders

3 Sheets

5050, 6458, 6464, 7676, and 8282 Dryers

Table 66. 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#	

Safety

3 Sheets

5050, 6458, 6464, 7676, and 8282 Dryers

Table 66 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	