



heatless desiccant air dryer
user guide



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desiccant air dryers

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1.1 general information

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range: heatless desiccant air dryers
models: 301325, 301326, 301327, 301328, 301329, 301330, 301331
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annotations



CAUTIONS: indicate any situation or operation that may result in potential damage to the product, injury to the user, or render the product unsafe.



NOTES: highlight important sections of information where particular care and attention should be paid.

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1.2 document introduction

This manual provides factory prescribed installation and maintenance procedures for a heatless desiccant compressed air dryer. The procedures illustrated in this document are only to be performed by authorized personnel. For further information regarding the procedures outlined in this document contact the manufacturer before proceeding. Be sure to read this document carefully before attempting to install or operate the dryer. This document should be permanently available at the dryer installation site and be kept in an easily accessible place alongside the dryer.

1.3 warranty guidelines

All products are supplied with a 2 year manufacturer's warranty from the date of purchase, when purchased without an ES (Energy Saving) system and installed and maintained in accordance with the manufacturers guidelines. Only genuine service parts should be used and no modifications made.

When purchased with an ES (Energy Saving) system and installed and maintained in accordance with the manufacturers guidelines the product will be supplied with an extended 5 year valve warranty. This is

1.4 packaging

All products are securely packaged in a specifically designed wooden packing box. The dryer will be held in a horizontal position by wooden struts; using straps to secure the product to the box base. The box top cover can be removed by removing the fixing screws and lifting off in one piece.

1.5 damage to packaging

Check immediately to establish whether damage has occurred to the external packaging and if the damage extends to the product inside. If there is damage to a product, contact the relevant supplier immediately.



In no circumstances must a damaged product be used in operation. Using damaged products can lead to irreparable functional faults or cause serious physical harm.



The support packing box permits limited longitudinal stacking; however the central section of the packing box should not be considered load bearing.

1.6 general safety

No modifications must be made to the product. Any modifications may reduce the operational safety of the product and invalidate the manufacturer's warranty. This could potentially result in damage to the product and serious personal injury.



For your own safety, when carrying out work on this product, all relevant national safety regulations must be complied with relating to pressurized and electrical systems.



WARNING: This product can expose you to chemicals including lead, which is known to the State of California to cause cancer and/or birth defects or other reproductive harm. For more information, go to www.P65Warnings.ca.gov.





desiccant air dryers

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1.7 intended use of the product

The dryer is exclusively intended for the treatment of compressed air, which is free from bulk water, oil and solid matter constituents.

The product should be located within a building and protected from extreme conditions and weather. The dryer must be operated only in accordance with the data on the rating plate. Any operations that do not comply with those stated on the product rating label will render the warranty void.



This product is only designed to operate at pressures of between 4 to 10 barg (58 to 145 psig). It is not suitable for pressures in excess of 10 barg (145 psig).



IMPORTANT: It is essential that the system into which the dryer is installed is fitted with a pressure limiting/relief device. This device should be between the compressor and the dryer. The device must be set to prevent the maximum working pressure of 10 barg (145 psig) from being exceeded.

1.8 personnel

Only authorized, competent and trained personnel are permitted to work on this product. This user guide is intended solely for such personnel and is to be used only as a reference; it should not be used to replace conventional training.

1.9 safe handling

Please ensure the relevant safe engineering practices and handling procedures are employed when handling, installing and operating this product. Ensure that the equipment is depressurized and electrically isolated prior to carrying out any of the scheduled maintenance instructions specified within this user guide.



In no circumstances must a damaged product be used in operation. Using damaged products can lead to irreparable functional faults or cause serious physical harm.



A suitable lifting aid must be used to minimize the risk of physical injury or damage to the product.

desiccant air dryers



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1.10 technical description

The compressed air dryer uses the pressure swing adsorption principle of drying compressed air, utilizing two identical columns each containing a hygroscopic desiccant bed.

- Inlet filtration removes water, oil aerosols and particles (Inlet filtration supplied separately).
- Wet air enters the dryer through the inlet valve and is directed into one of the columns.
- Each column contains a densely filled desiccant cartridge.
- Air then passes through the desiccant cartridge where any remaining moisture is adsorbed.
- Simultaneously, a small amount of dry filtered air is counter flowed through the other desiccant cartridge and exhausted to atmosphere, removing the moisture and regenerating the desiccant bed.
- The dryer controller periodically switches columns after top end repressurization; ensuring a continuous supply of dry air at constant pressure. The dryer can also be controlled using a Zero Volt signal from the compressor. This energy saving feature senses when the compressor is switched off and stops the dryer operation until the compressor restarts.
- The dry air passes out through the final particulate filter (<1micron/ISO8573.1 Class 2).



1.11 product contents

when ordering a series 3 desiccant air dryer you will receive the following;

- 1 x dryer support base and box cover
- 1 x series 3 compressed air dryer
- 1 x user guide
- 1x declaration of conformity

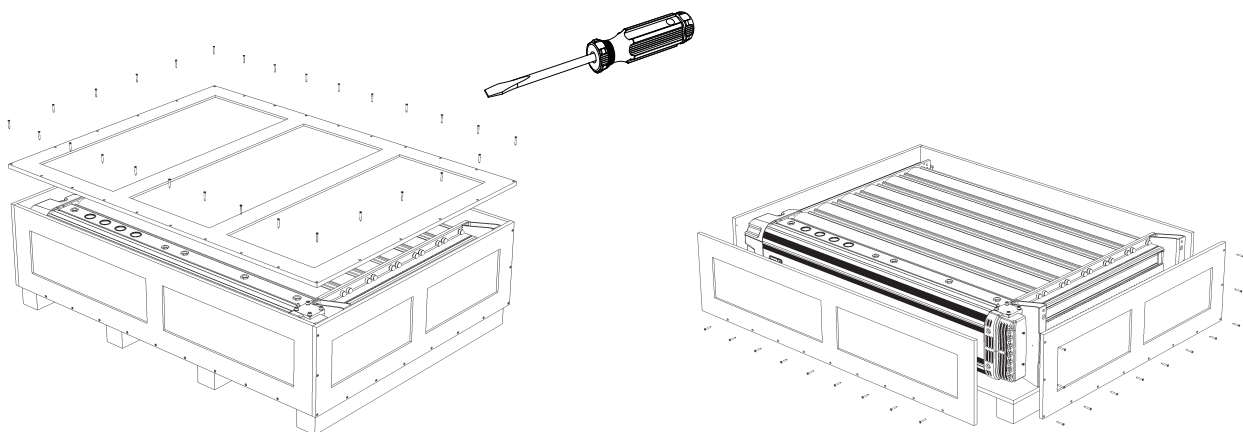


Figure 1: Contents Layout



desiccant air dryers

2.1 technical specification

specifications	standard	optional
maximum water content (ISO class) (4)	class 2 -40°C (-40°F) pdp	class 1: -70°C (-94°F) pdp
minimum operating pressure	4 barg (58 psig)	-
maximum operating pressure	10 barg (145 psig)	-
recommended operating temp range	1.5 to 35°C (35 to 95°F)	-
design operating temperature range	1.5 to 50°C (35 to 122°F)	-
power supply requirements	100 to 240V AC @ 50 or 60 Hz	24V DC



All dryers should be preceded by a coalescing filter regardless of oil or oil free applications, a 0.01mg/m1 grade coalescing filter must be installed on the inlet to the dryer.

2.2 flow rates

model	inlet flow rate		connection	
	Nm ³ /hr	scfm	inlet	outlet
301325	360	212	2" BSPP or NPT	2" BSPP or NPT
301326	469	276		
301327	680	400		
301328	951	560		
301329	1274	750	2 ½" BSPP or NPT	2 ½" BSPP or NPT
301330	1407	828		
301331	1886	1110		

2.3 correction factors

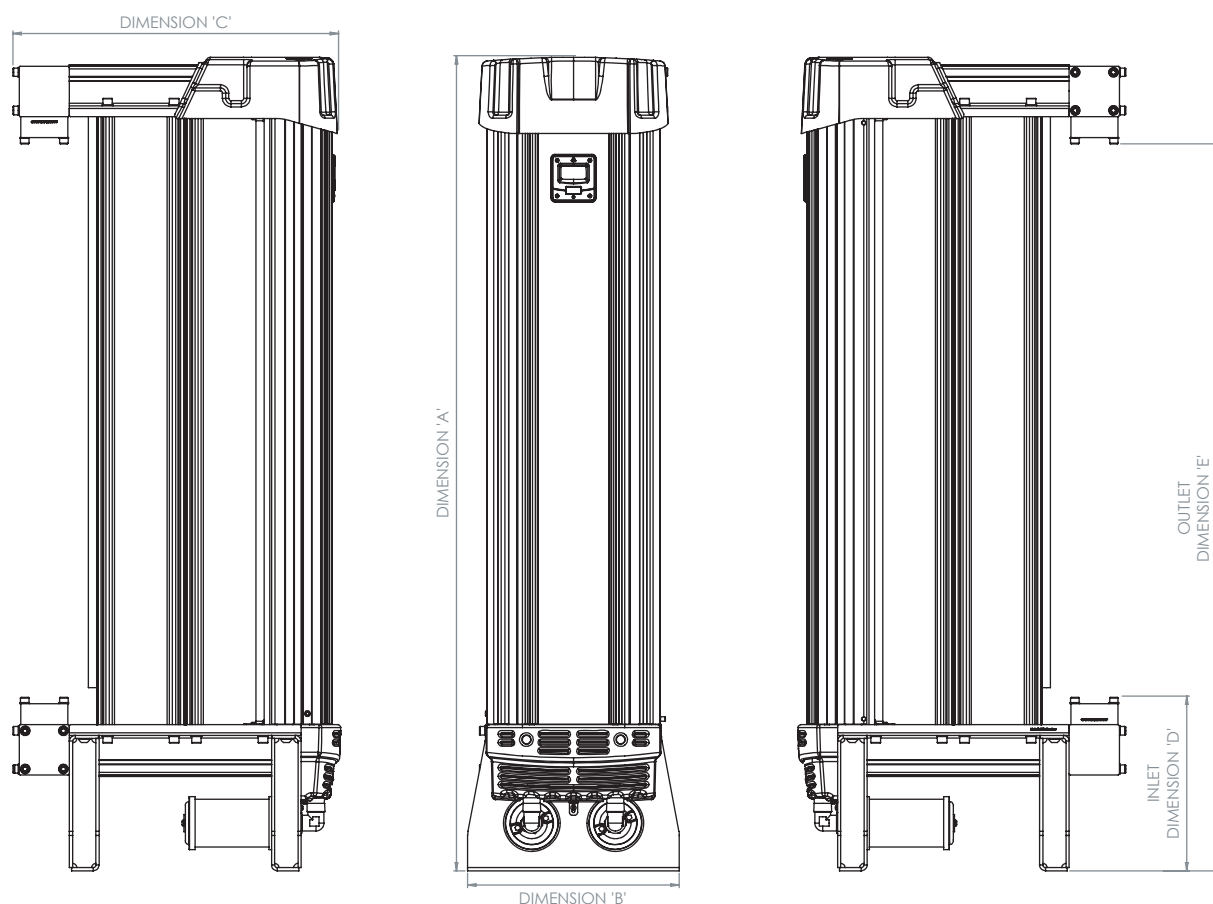
inlet air pressure	barg	4	5	6	7	8	9	10
	psig	58	72	87	101	116	130	145
correction factor		0.63	0.75	0.88	1.00	1.13	1.25	1.38

inlet air temperature	°C	25	30	35	40	45	50	pressure dew point	°C	-20	-40	-70
	°F	77	86	95	104	113	122		°F	-4	-40	-94
correction factor		1.00	1.00	1.00	0.97	0.88	0.73	correction factor		1.10	1.00	0.70

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2.4 product dimensions



2



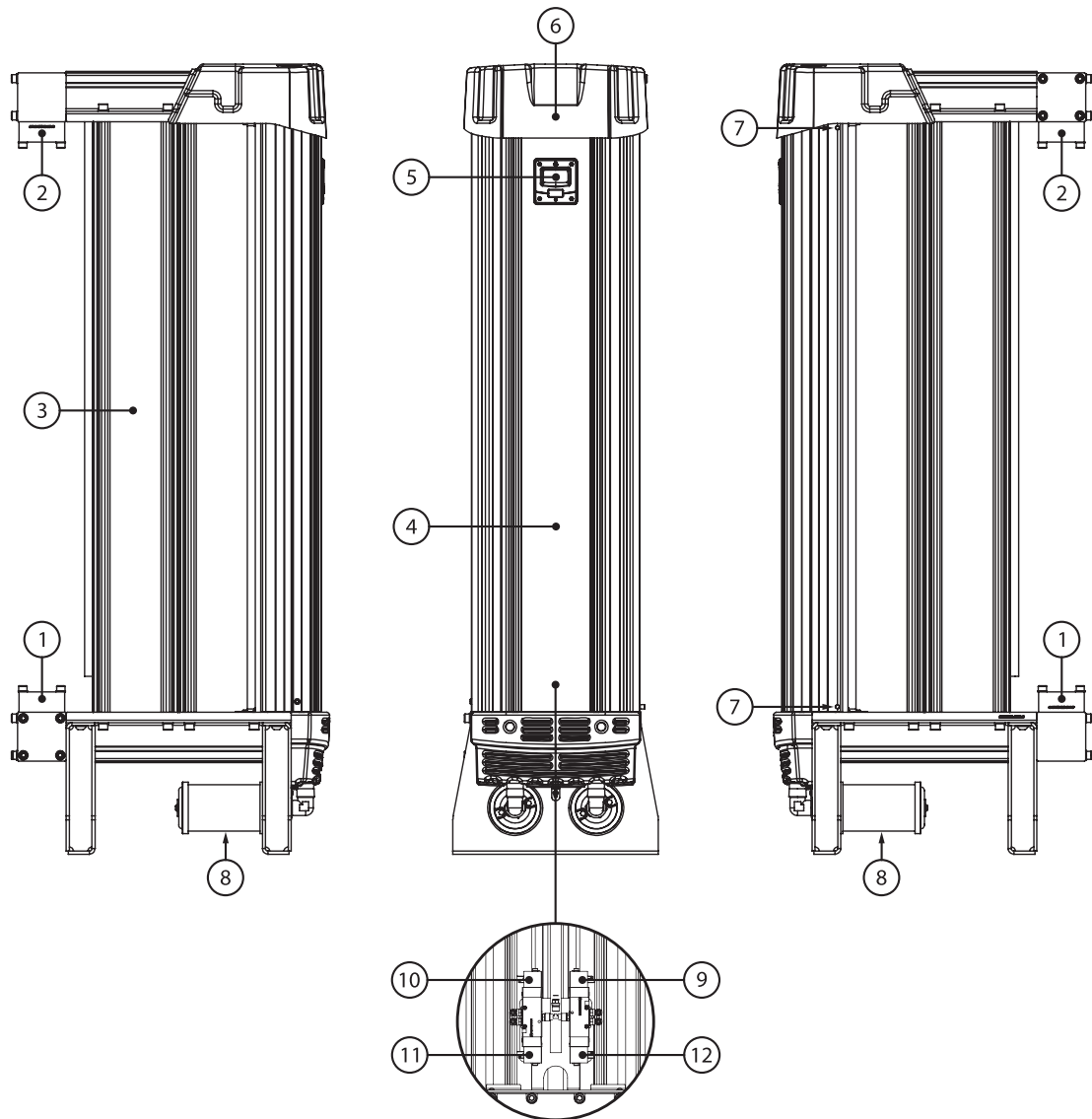
model	dimension										weight	
	A		B		C		D		E		kg	lbs
	mm	inches	mm	inches	mm	inches	mm	inches	mm	inches		
301325	1288	51.5			619	24.3			1136	44.7	120	264
301326	1538	60.6			619	24.3			1386	54.5	224	493
301327	1888	74.3			619	24.3			1657	65.2	261	575
301328	1888	74.3	400	15.7	787	31.0	316	12.4	1657	65.2	343	756
301329	1888	74.3			955	37.6			1657	65.2	425	936
301330	1538	60.6			1291	50.8			1386	54.5	470	1036
301331	1888	74.3			1291	50.8			1657	65.2	507	1117



desiccant air dryers

2.5 product overview

2

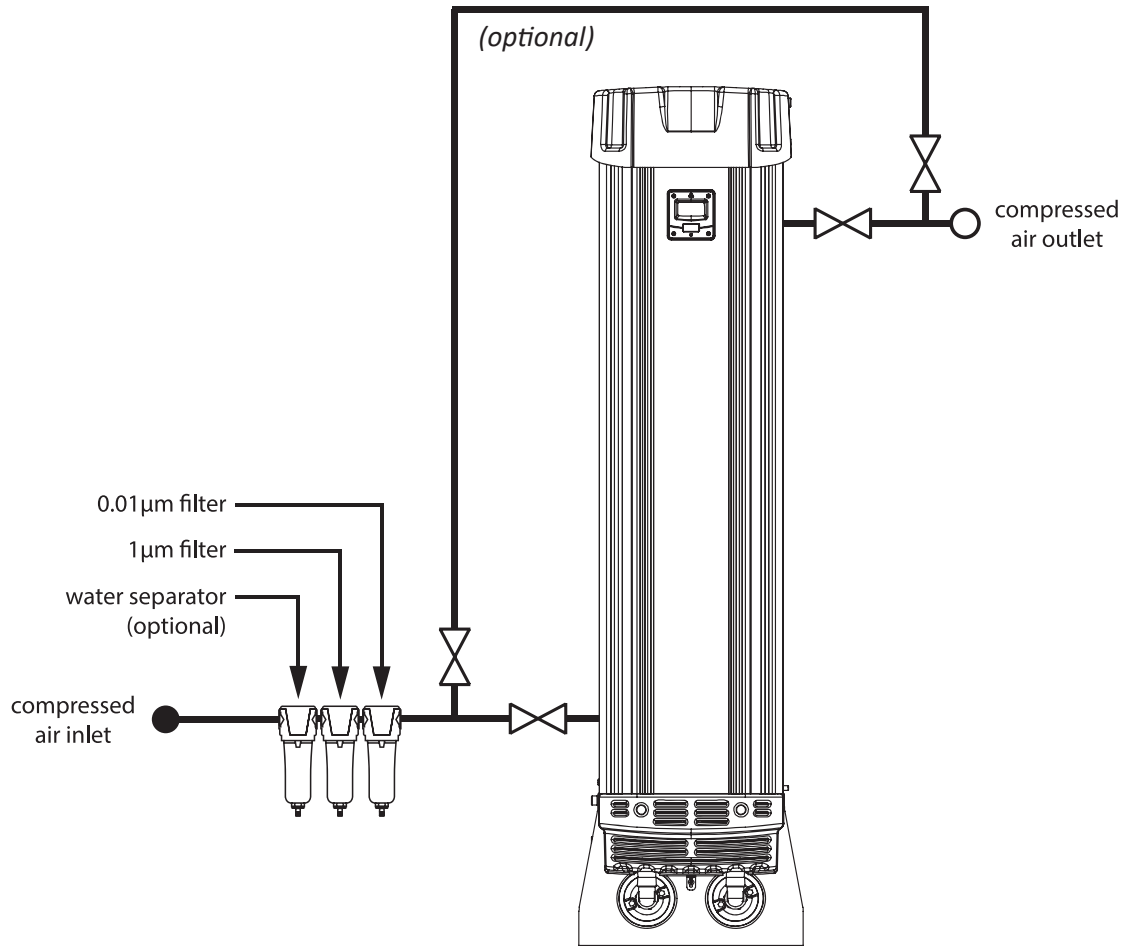


number	description	number	description
1	compressed air inlet	7	shroud latches
2	air outlet	8	external exhaust silencer
3	dryer column	9	exhaust valve 'A'
4	dryer shroud	10	inlet valve 'A'
5	dryer control panel display	11	inlet valve 'B'
6	dryer top cover	12	exhaust valve 'B'

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2.6 typical system layout



2



IMPORTANT: It is essential that the system into which the dryer is installed is fitted with a pressure limiting/relief device. This device should be installed between the compressor and the dryer.

2.7 site location

When selecting an installation site for the dryer, ensure the following conditions are met:

- Installation site should be located indoors on a flat surface protected from the weather and other harmful conditions.
- The ambient temperature must not drop below 1.5°C (34.7°F) or exceed 50°C (122°F).
- The installation site should be level and able to support the weight of the product.
- Ensure sufficient space around the product, to allow access for operation and maintenance.
- Take into account the noise generated by the dryer exhausting while in use when considering location.



desiccant air dryers

2.8 electrical installation

To install the mains power cable:

- Remove the two M5 screws from the top cover and lift away from the dryer.
- Locate the two latches on the top and bottom manifold and pull in the opposite direction to each other to open the shroud, this will then expose the controller (See Fig 1.)
- Remove the IEC plug from the controller socket (See Fig 1.)
- Unscrew the cap head screw to remove the IEC plug top cover.
- Feed the mains power cable through the cable glands located near the bottom of the shroud.
- Wire the mains power cable into the IEC plug (See Fig 2.)
- Once the mains cable is correctly wired into the IEC plug, re-fit the IEC plug top cover and cap head screw.
- Reattach the IEC plug into the controller socket, securing with the swing clip.
- Close the shroud and pull the two latches back into position and refit the top cover and secure with M5 screws.



IMPORTANT: Ensure the mains is isolated/switched off prior to the service of the product. Under no circumstances should the controller be used without being fitted to the product. This product should be connected to a grounded, metallic, permanent wiring system or an equipment-grounding terminal or lead.

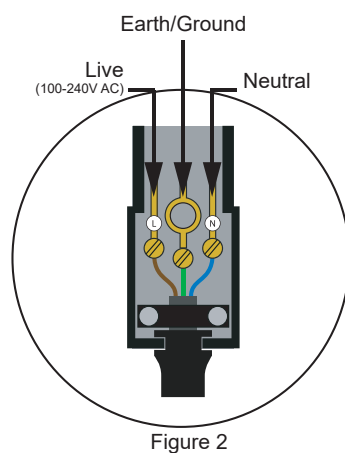


Figure 2

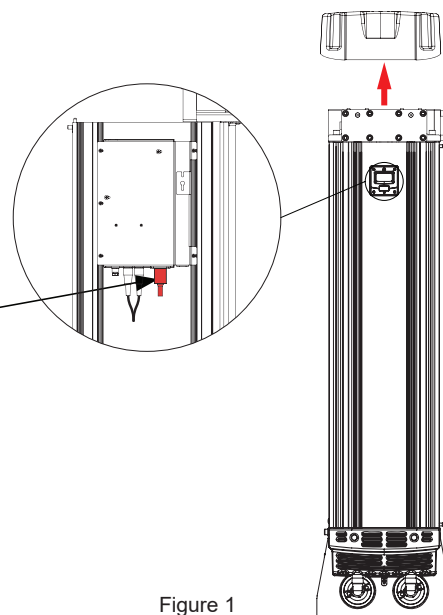


Figure 1

desiccant air dryers



2



IMPORTANT: This product must be grounded. In the event of an electrical short circuit, grounding reduces the risk of electric shock by providing an escape wire for the electric current. This product is equipped with a cord having a grounding wire with an appropriate grounding plug. The plug must be plugged into an outlet that is properly installed and grounded in accordance with all local codes and ordinances. Check with a qualified electrician or serviceman when the grounding instructions are not completely understood, or when in doubt as to whether the product is properly grounded. Do not modify the plug provided; if it does not fit the outlet, have the proper outlet installed by a qualified electrician.

2.9 remote start/stop control

To gain access to the remote start/stop feature:

- Remove the two M5 screws from the top cover and lift away from the dryer.
- Locate the two latches on the top and bottom manifold and pull in the opposite direction to each other to open the shroud, this will then expose the controller (See Fig 1.)
- Remove the insulation from the flying lead (See Fig 4.)
- There are six wires;
 1. Brown Wire - 24V DC Output
 2. Blue Wire - 24V DC Output
 3. Black Wire - Remote Start/Stop Input
 4. White Wire - Alarm Input (Zero volt contact)
 5. Green Wire - Alarm Output (Zero volt contact)
 6. Red Wire - Remote Stop Input
- To set up the Remote Start/Stop control, remove/break the connection between the brown and Black wires and connect externally to a remote switch or relay.
- A 24V DC Output must be connected to the Black wire to enable the dryer to operate, if the connection is broken or if there is no voltage the dryer will switch off and revert to standby mode, displaying "REMOTE STOP ACTIVE" on the controller display.



Under no circumstances should an external voltage or current be applied to any of these wires, as damage to the control system will occur, negating the warranty.

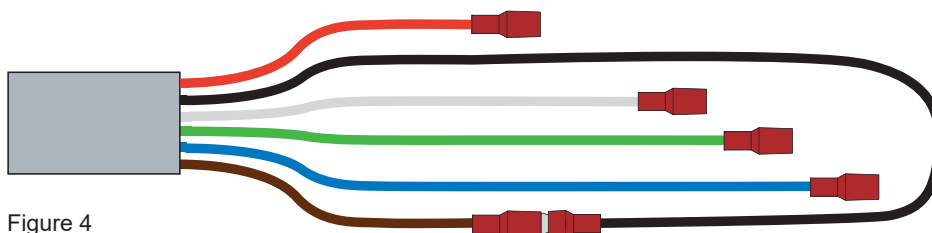


Figure 4



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2.10 remote stop control

To gain access to the remote stop feature:

- Remove the two M5 screws from the top cover and lift away from the dryer.
- Locate the two latches on the top and bottom manifold and pull in the opposite direction to each other to open the shroud, this will then expose the controller (See Fig 1.)
- Remove the insulation from the flying lead (See Fig 3.)
- There are six wires;
 1. Brown Wire - 24V DC Output
 2. Blue Wire - 24V DC Output
 3. Black Wire - Remote Start/Stop Input
 4. White Wire - Alarm Input (Zero volt contact)
 5. Green Wire - Alarm Output (Zero volt contact)
 6. Red Wire - Remote Stop Input
- To set up the Remote Stop control, make a connection between the red and blue wire, when a connection is detected the dryer will automatically shut down. Break the connection to allow the dryer to start again.
- A 24V DC Output must be connected to the Black wire to enable the dryer to operate, if the connection is broken or if there is no voltage the dryer will switch off and revert to standby mode, displaying "REMOTE STOP ACTIVE" on the controller display.

2



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2.11 dryer operation



Do not allow the dryer to flow air unless switched on and cycling. Resulting effect could be desiccant contamination; requiring replacement of desiccant cartridges.

- Ensure all pipe work is connected as per section 8 and the dryer is securely hardwired into the electrical supply.
- Ensure the inlet operating pressure parameters are between 4 and 10barg (58 and 145 psig).
- Ensure the inlet air temperature is between 1.5°C and 50°C (34.7°F and 122°F).
- Turn on the power to the dryer, the dryer will display its' status.
- Slowly open the inlet valve and allow the dryer to pressurize.
- Check for leaks and rectify if any are found.
- Allow the dryer to cycle at least 2 times before slowly opening the outlet valve.
- In case of using the Remote Start/Stop function, ensure external voltage is active.

2





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2.12 control panel displays

1	Power-up Display (only visible on power start-up for 10 seconds)	
	<p>During power-up the screen will display:</p> <ul style="list-style-type: none"> • Program operation; <ul style="list-style-type: none"> • If (S) is shown: standard -40°C (-40°F) operation • If (L) is shown: low dew point -70°C (-94°F) operation • Program number followed by the revision. • Total hours dryer has operated. 	
2	Normal Operation Display	
	<p>During normal operation the screen will display:</p> <ul style="list-style-type: none"> • Column 'A' status and Column 'B' status, this will be shown as one of three sequences; <ul style="list-style-type: none"> • ONLINE; this column is flowing • PURGE; this column is regenerating • READY; this column is waiting to switch • Hours the dryer has run between services 	
3	Service Re-set Display	
	<p>When servicing the dryer, you will be required to re-set the service hours run counter. When holding a magnet to the specified area on the shroud for 10seconds the screen will display;</p> <ul style="list-style-type: none"> • Column 'A' status and Column 'B' status, this will be shown as one of three sequences; <ul style="list-style-type: none"> • ONLINE; this column is flowing • PURGE; this column is regenerating • READY; this column is waiting to switch • 'SERVICE RE-SET' will appear once the service hours run counter has reverted back to 0. 	
4	Normal Operation Display (ES Models)	
	<p>During normal operation of an ES enabled dryer the screen will display:</p> <ul style="list-style-type: none"> • Column 'A' status and Column 'B' status, this will be shown as one of three sequences; <ul style="list-style-type: none"> • ONLINE; this column is flowing • PURGE; this column is regenerating • READY; this column is waiting to switch • Hours the dryer has run between services/hours in ES mode • Constantly updated pressure dew point reading. This can be displayed in either degrees celsius or degrees fahrenheit depending on how the controller is configured. <p>Speak to the manufacturer about your requirements.</p>	

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5	Energy Saving Mode Active Display While energy saving mode is active the screen will display: <ul style="list-style-type: none"> • Column 'A' status and Column 'B' status, this will be shown as; <ul style="list-style-type: none"> • ONLINE; this column is flowing • 'ENERGY SAVING MODE' • Hours the dryer has run between services/hours in ES mode • Constantly updated dew point reading, this can be displayed in either degrees celsius or degrees fahrenheit. 	
6	Dew point Sensor Fault Display If a fault occurs with the dew point sensor or the connection to the dew point sensor, the screen will display: <ul style="list-style-type: none"> • Column 'A' status and Column 'B' status • Hours the dryer has run between services/hours in ES mode • 'DEWPT SENSOR FAULT' 	
7	Dew point Alarm Display If the dew point sensor reading falls below the desired alarm limit the screen will display: <ul style="list-style-type: none"> • Column 'A' status and Column 'B' status • Hours the dryer has run between services/hours in ES mode • 'DEWPOINT ALARM' 	
8	Energy Savings Adjustment Display When adjusting the ES set-point the screen will display: <ul style="list-style-type: none"> • 'Upper Limit' this is the point which the dryer de-activates ES mode. • 'Lower Limit' this is the point which the dryer activates ES mode. • 'Alarm Limit' this is the point which the dryer will activate the dew point alarm and remote alarms. 	

2

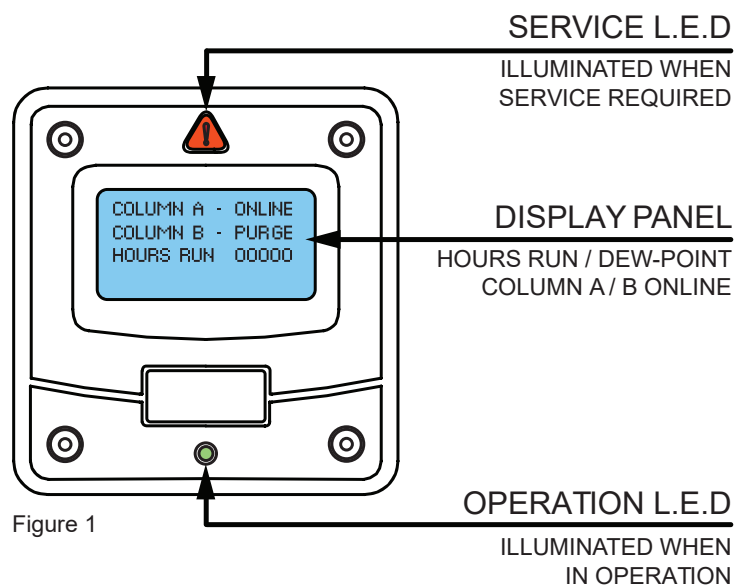




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2.13 monitoring dryer performance

- The dew point is displayed on the display of the control panel. When the pressure dew point displayed is better than -42°C (-44°F) PDP the dryer will switch into energy saving mode and stop cycling, resulting in zero purge, but no interruption in flow. When the dew point degrades to -40°C (-40°F) the dryer will restart cycling ensuring the dew point is maintained at or better than -40°C (-40°F).
- If, during normal operation, the dryer fails to achieve dew point (falls below -30°C (-22°F)) the alarm output will be indicated on the front screen and the remote alarm output will activate.
- The set levels for the ES and dew point alarm are adjustable and can be accessed by carefully removing the front bezel to expose the PLC and adjustment buttons (see Figure1.)
- Hold buttons A & B down for 8 seconds to access the menu shown on page 17 display 8.
- Select the line you want to adjust by using the up down buttons, then press ok. The digits will flash and can be changed again using the up/down buttons.
- When set, press ok to store then move to the next line.
- The screen will exit after 60 seconds or when escape is pressed.



Beware this is only an example as the dew point set-points and alarms are adjustable through the display panel.

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2.14 shutdown procedure

- Close both the inlet and outlet valves ensure the dryer is completely isolated.



The dryer will still be pressurized! In order to depressurize the dryer; ensure the dryer is isolated from the compressed air supply source.

- Cycle the dryer at least twice to ensure the dryer exhausts and is completely depressurized.
- When fully depressurized the 'clicking' of the exhaust valves will be heard but no air exhausted.
- When the dryer is fully depressurized, isolate from the electrical supply.

2





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3.1 maintenance



Maintenance operations should only be carried out by authorized, suitably trained personnel.

- Maintenance operation should only be conducted when the system has been shut down and fully depressurized.
- All connections must be isolated and removed with care, paying particular attention to the areas that become pressurized.
- Do not modify or adjust the control settings.
- Only certified and approved replacement parts should be used.
- Always check all connections for leakage and secure seating.
- Ensure all loose parts are removed or secured to the dryer before operation.

4

3.2 cleaning

Clean the equipment with a damp cloth only and avoid excessive moisture around any electrical connections. If required a mild detergent may be used, however do not use abrasives or solvents as these may cause damage.

3.3 daily checks

- Check the dryers for any external damage.
(*assess and eliminate any defects found*)
- If the red service light appears, the dryer must be serviced to ensure the best air quality possible.
(*contact the service provider and request a service kit for the product*)
- Remove any loose dust or dirt from the dryer, clean all surfaces that appear to have attracted unwanted contaminants.
- Check the dew point sensor display (if option if fitted). If the dew point is not maintained at $<-30^{\circ}\text{C}$ ($<-22^{\circ}\text{F}$) the reading on the display will alternate with 'DEWPOINT ALARM' every 5 seconds. The no-volt alarm will also activate.
(*contact the service provider and request a service kit for the product*)
- Always check all connections for leakage and secure seating.
- Ensure all loose parts are removed or secured to the dryer before operation.

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3.4 servicing guidelines

- Maintenance operation should only be conducted when the system has been shut down and fully depressurized.
- Isolate the dryer from the compressed air and electrical supply ensuring the system is in a safe condition for maintenance to be carried out on.
- All connections must be removed with care, paying particular attention to the areas that become pressurized.
- All gasket seals removed during maintenance operations must be replaced with new gaskets.
- Only certified and approved replacement parts should be used.
- Do not modify or adjust the control settings.
- Always check all connections and sealing faces for cleanliness and secure seating prior to assembly.
- Ensure all components are re-fitted to the product before operation.
- Always check all connection and sealing faces for any leakage, if any found resolve and check again.
- Ensure the dryer is left operating in a safe working condition after completion of maintenance.

4





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3.5 service schedule and breakdown

service	year 1 (12 months)	year 2 (24 months)	year 3 (36 months)	year 4 (48 months)	year 5 (60 months)	year 6 (72 months)	year 7 (84 months)	year 8 (96 months)
A	✓	✓	✓	✓	✓	✓	✓	✓
B		✓		✓		✓		✓
C				✓				✓
D <small>(ES MODELS ONLY)</small>	✓	✓	✓	✓	✓	✓	✓	✓

4



When contacting your service provider be sure to provide the part number and serial number of your dryer, this can be found on the rating plate located top right hand side of the dryer.

- Service A** - Every 1 year (12 months)
 Replace external exhaust silencers/mufflers
Applicable to all models
- Service B** - Every 2 year (24 months)
 Replace desiccant and top cap filtration
 Replace top manifold gasket seals
Applicable to all models
- Service C** - Every 4 year (48 months)
 Replace exhaust valves
 Replace inlet valves
 Replace outlet valves
 Replace control valves
Applicable to all models
- Service D** - Every 1 year (12 months)
 Calibrate dew point sensor
Applicable to ES models only



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3.6 service kits and spares

model	service A	service B		service C	service D	
		standard -40°C (-40°F)	low dew point -70°C (-94°F)		standard -40°C (-40°F)	low dew point -70°C (-94°F)
301325		CF	CF			
301326		CF	CF			
301327		CF	CF			
301328	CF	CF	CF	CF	CF	CF
301329		CF	CF			
301330		CF	CF			
301331		CF	CF			

kit number	description	kit contents
CF	Replacement BSPT exhaust silencer/muffler element	(x2) Exhaust Silencer/Muffler
CF	Replacement NPT exhaust silencer/muffler element	
CF	Replacement desiccant for 301325	
CF	Replacement desiccant for 301365	
CF	Replacement desiccant for 301325 & 301331	Desiccant & Gasket Seals
CF	Replacement desiccant for 301326 & 301330	
CF	Replacement desiccant for 301327, 301328, 4130 & 301331	
CF	Replacement desiccant for 301367, 301368, 301369 & 301371	
CF	Replacement desiccant cartridges for 301325	
CF	Replacement desiccant cartridges for 301365	Desiccant Cartridges & Gasket Seals
CF	Replacement desiccant cartridges for 301326 & 301330	





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kit number	description	kit contents
CF	Replacement desiccant cartridges for 301366 & 301370	
CF	Replacement desiccant cartridges for 301367, 301368, 301369 & 301371	Desiccant Cartridges & Gasket Seals
CF	Replacement desiccant cartridges for 301367, 301368, 301369 & 301371	
CF	Replacement pilot valves (24V DC) normally closed operation	
CF	Replacement pilot valves (110V AC) normally closed operation	
CF	Replacement pilot valves (240V AC) normally closed operation	(x2) pilot valves & coils
CF	Replacement pilot valves (24V DC) normally open operation	
CF	Replacement pilot valves (110V AC) normally open operation	
CF	Replacement pilot valves (240V AC) normally open operation	
CF	Replacement exhaust valves	(x2) Internal Exhaust Valves
CF	Replacement inlet valves	(x2) Internal Inlet Valves
CF	Replacement outlet valves	(x2) Internal Outlet Valves
CF	Replacement valve overhaul kit (normally closed & 24V DC Coils)	(2x) Exhaust Valves (2x) Inlet Valves (x2) Outlet Valves (x2) 24V DC Pilot Valves
CF	Replacement valve overhaul kit (normally closed & 110V AC Coils)	(2x) Exhaust Valves (2x) Inlet Valves (x2) Outlet Valves (x2) 110V AC Pilot Valves
CF	Replacement valve overhaul kit (normally closed & 240V AC Coils)	(2x) Exhaust Valves (2x) Inlet Valves (x2) Outlet Valves (x2) 240V AC Pilot Valves
CF	Replacement valve overhaul kit (normally open & 24V DC Coils)	(2x) Exhaust Valves (2x) Inlet Valves (x2) Outlet Valves (x2) 24V DC Pilot Valves
CF	Replacement valve overhaul kit (normally open & 110V AC Coils)	(2x) Exhaust Valves (2x) Inlet Valves (x2) Outlet Valves (x2) 110V AC Pilot Valves

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desiccant air dryers



kit number	description	kit contents
CF	Replacement valve overhaul kit (normally open & 240V AC Coils)	(2x) Exhaust Valves (2x) Inlet Valves (x2) Outlet Valves (x2) 240V AC Pilot Valves
CF	Dew point sensor calibration for standard -40°C (-40°F) sensors	(x1) Calibration
CF	Dew point sensor calibration for standard -70°C (-94°F) sensors	
CF	Energy Saving Upgrade Kit	(x1) Dew point Sensor (x1) Sensor Lead

4





desiccant air dryers

4.1 service record

part number	serial number
--------------------	----------------------

installed by	installation date
---------------------	--------------------------

service interval	hours run (if applicable)	date	serviced by		comments / observations
			print	sign	

year 1

year 2

year 3

year 4

year 5

year 6

year 7

year 8

year 9

year 10

year 11

year 12

5



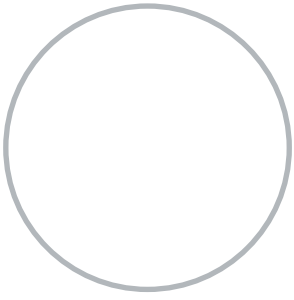
desiccant air dryers



4.2 trouble shooting

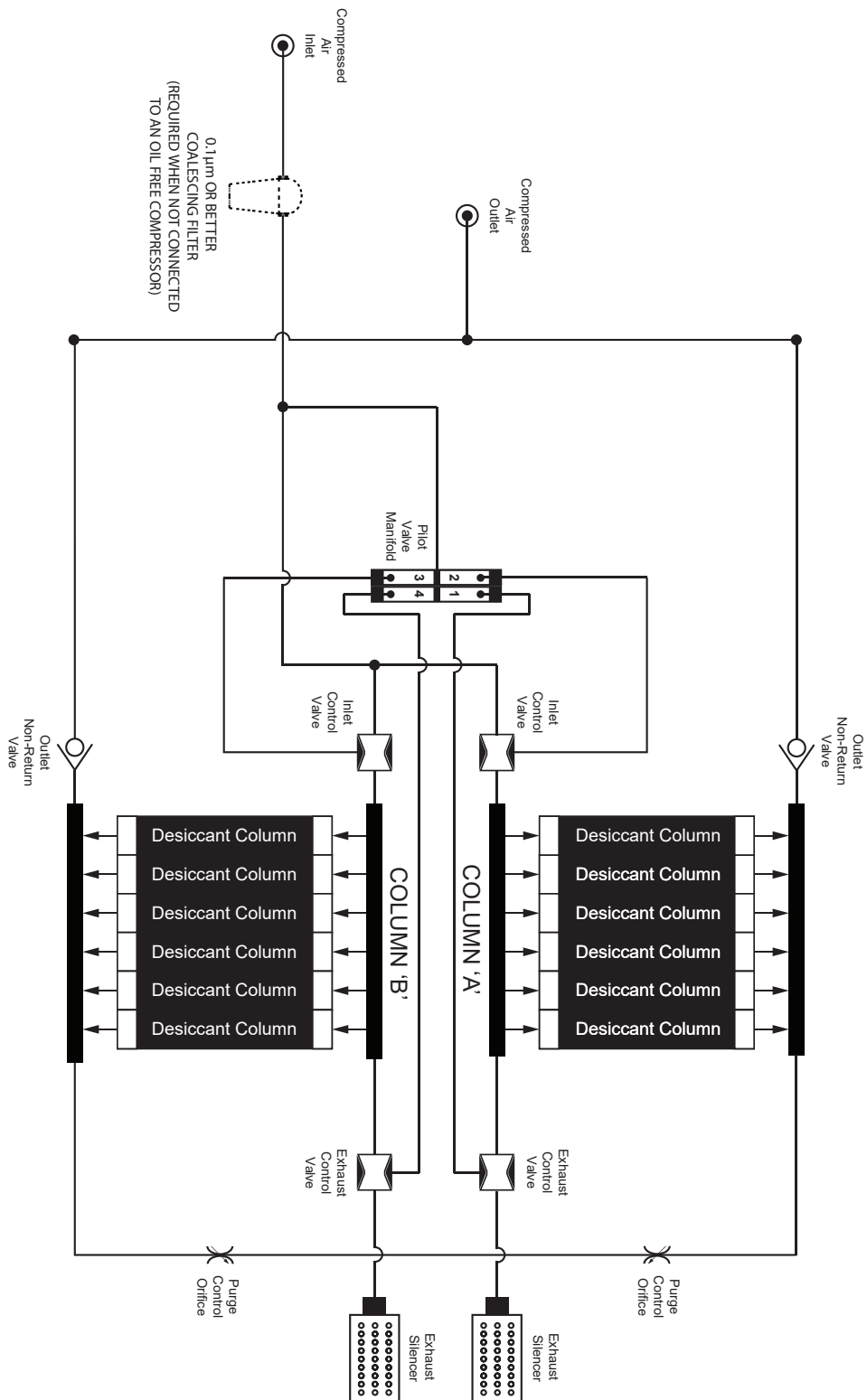
problem	problem caused	solution
Poor dew point performance	Insufficient inlet pressure	Inlet pressure should be a minimum of 4barg (58psig) if not then adjust inlet pressure settings.
	Electrical fault	Ensure the power is on and the dryer front panel is illuminated; check the dryer is cycling correctly
	Moist or contaminated desiccant	Eliminate the cause of contamination, replace desiccant cartridges (do not re-use).
	Excessive inlet air temperature	Check against the technical specification
	Insufficient purge air	Purge incorrectly adjusted, consult the service personnel to adjust settings (factory pre-set).
	Exhaust silencer blocked	Replace exhaust silencer/muffler element.
Failure of dryer to cycle	Controller not functioning correctly	ensure the controller is powered up, check the on screen column status to ensure it is powering the solenoid valves during operation
	Insufficient inlet pressure	Inlet pressure should be a minimum of 4barg (58psig) if not then adjust inlet pressure settings.
	Controller not illuminated	Check power supply to the dryer, check fuse and replace.
	Failure to de-pressurize when cycling	Solenoid valve not functioning correctly; if there is power to the coil, replace valve.
	Outlet flow stops	Check inlet air supply
	Failure to initialize dryer	Switch off and restart dryer. Ensure dryer is pressurized before powering up to allow the dryer to initialize before operation.
	Erratic air flow from exhaust	Faulty or damaged valves, carry out service





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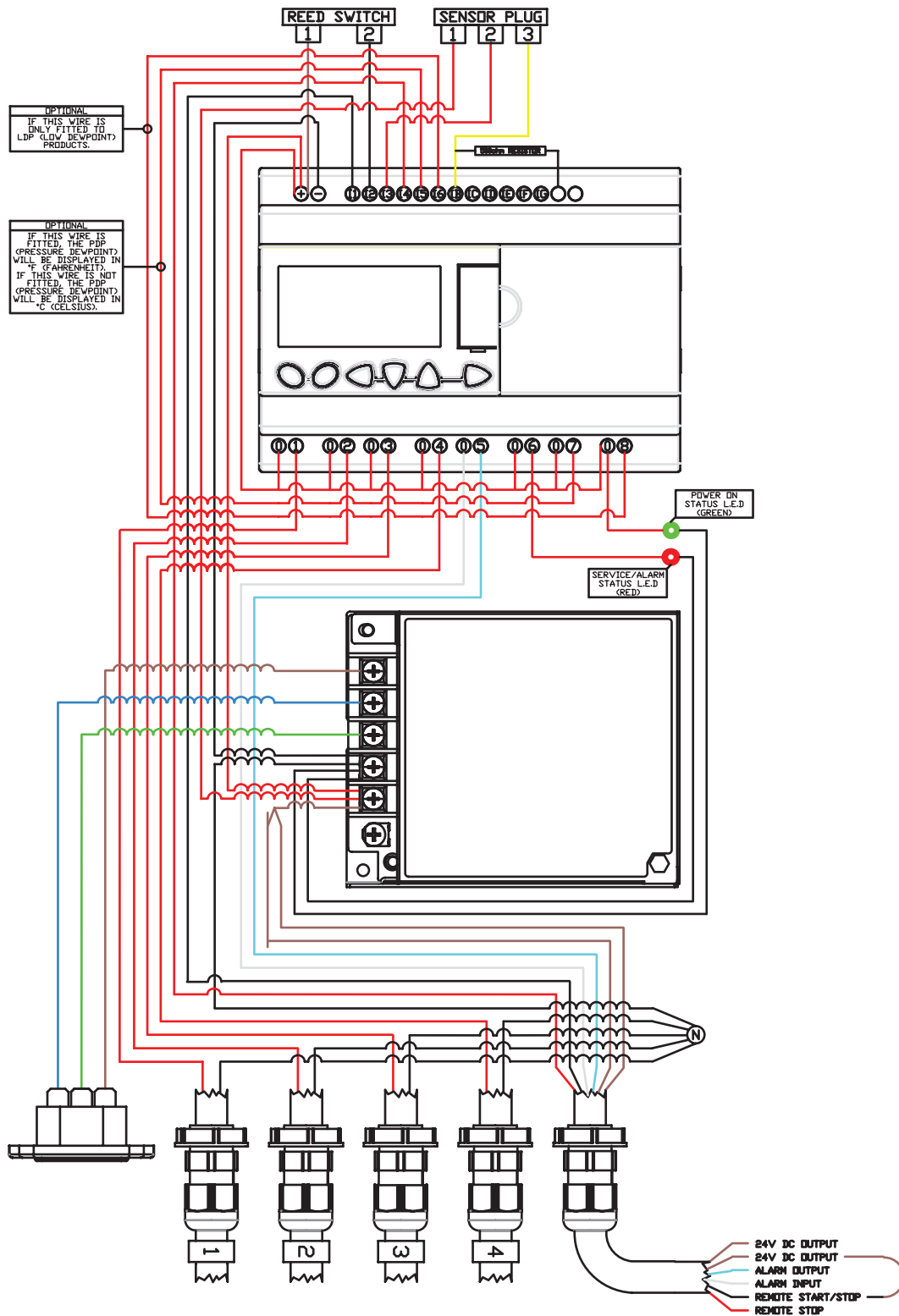
4.3 process and instrumentation diagram



desiccant air dryers



4.4 wiring diagram







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