



WENGER®

714 MAIN ST
SABETHA, KS 66534 USA

EQUIPMENT : DRYER
SERIES : VII
MODEL : 1500
SERIAL NUMBER : 12078-1
FUEL : NATURAL GAS
MAXIMUM INPUT : 3,600,000 BTU/HR (900,000 KCAL/H)
INLET FUEL PRESSURE: 2-5 PSIG (0.14-0.35 BAR)
PRESSURE AT BURNER: 10-20 IN WC (25-50 mBAR)
DATE : OCT 2000





POSN	POSITION
PSI	POUNDS PER SQUARE INCH
TYP	TYPICAL

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SHEET 1 OF 4

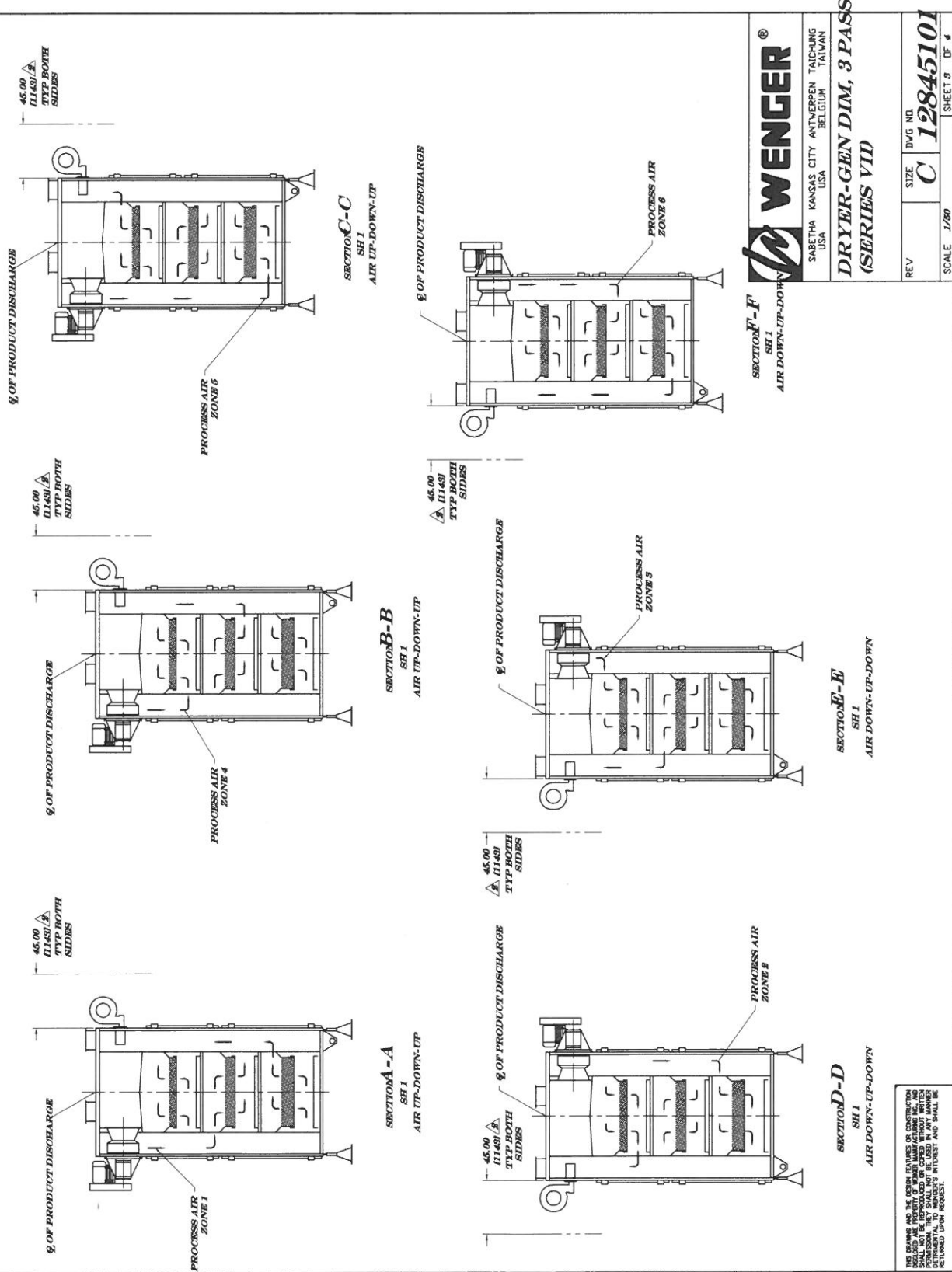
DO NOT SCALE DRAWING
UNSPECIFIED DIMENSIONS
SHOULD BE REQUESTED.



**DRYER-GEN DIM, 3 PASS
(SERIES VID)**

REV	SIZE	DWG NO.
	C	12845101
SCALE 1/80		SHEET 8 OF 4

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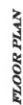
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USA USA TAIWAN

DRYER-GEN DIM, 3 PASS
(SERIES VII)

REV	SIZE	DWG NO	SHEET 9 OF 4
	C	12845101	
SCALE	1/80		

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REV	SIZE	DWG NO.
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REV	SIZE	DWG NO.
	C	12845101

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SYMBOLS LEGEND		
	PRESSURE REGULATING VALVE	 PRESSURE GAUGE
	MOTORIZED VALVE	 NOTE
	SOLENOID VALVE	 CARTOUCHE
	THREADED OR FLANGED UNION	 MAIN GAS LINE
	BUSHING	 VENT LINE
	COCK	 TEE
	REDUCER	 MANUAL BUTTERFLY VALVE
	BALL VALVE	 GAS PRESSURE SWITCH
	STRAINER	

CONVERSION TABLE				
PSIG (LB/IN ²)	INCHES WC	BAR	KPA	MILLIBAR
0.36	10.0	0.025	2.5	25
1.0	27.68	0.07	6.9	69
2.2	60.90	0.15	15	150

LINE SIZING NOMINAL INCH PIPE SIZES	
	
2	1

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KANSAS CITY
USA

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**PLUMBING DIAGRAM-
DRYER, (6 BURNER)**

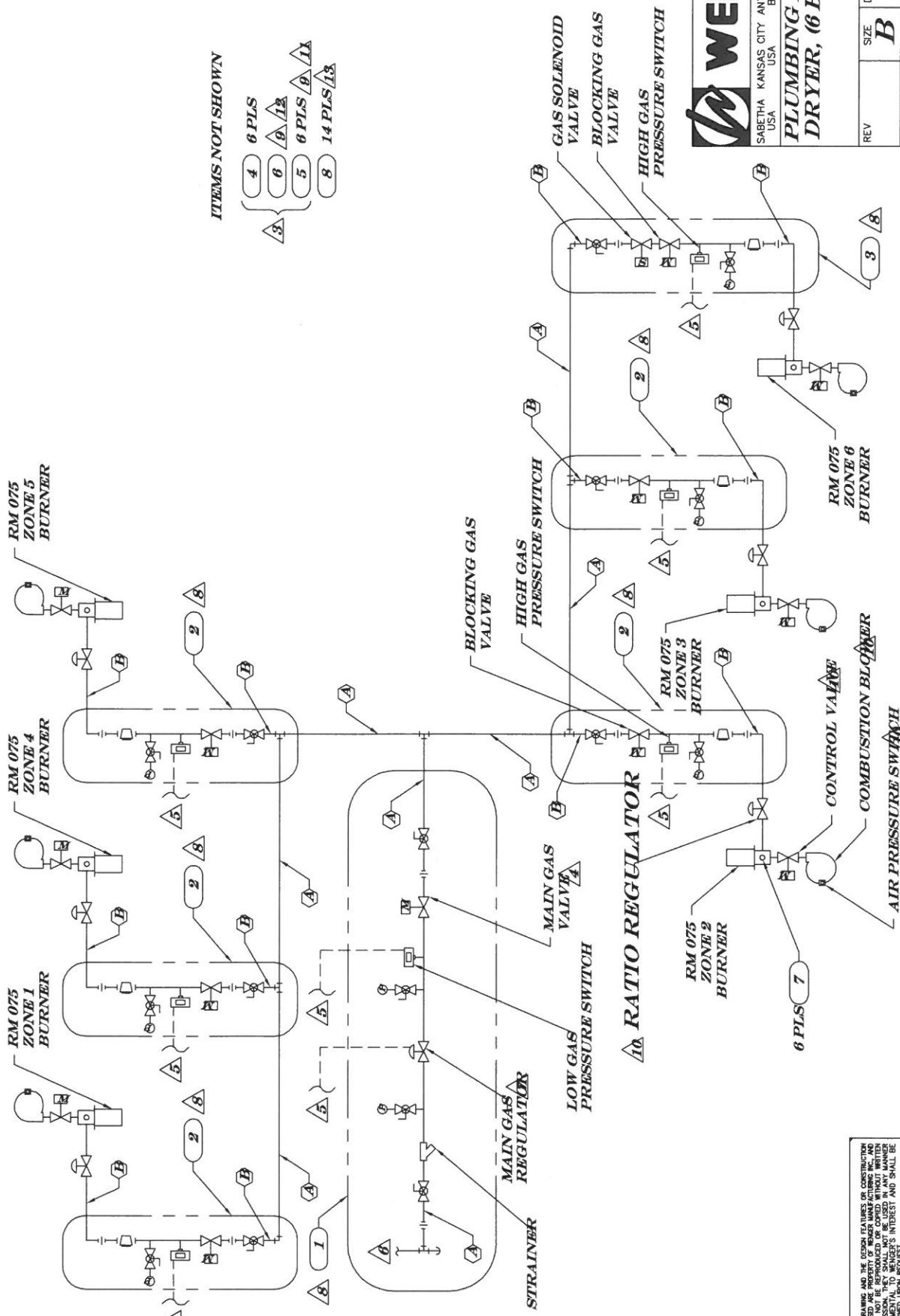
REV

SIZE **B**

DWG NO. **12845102**

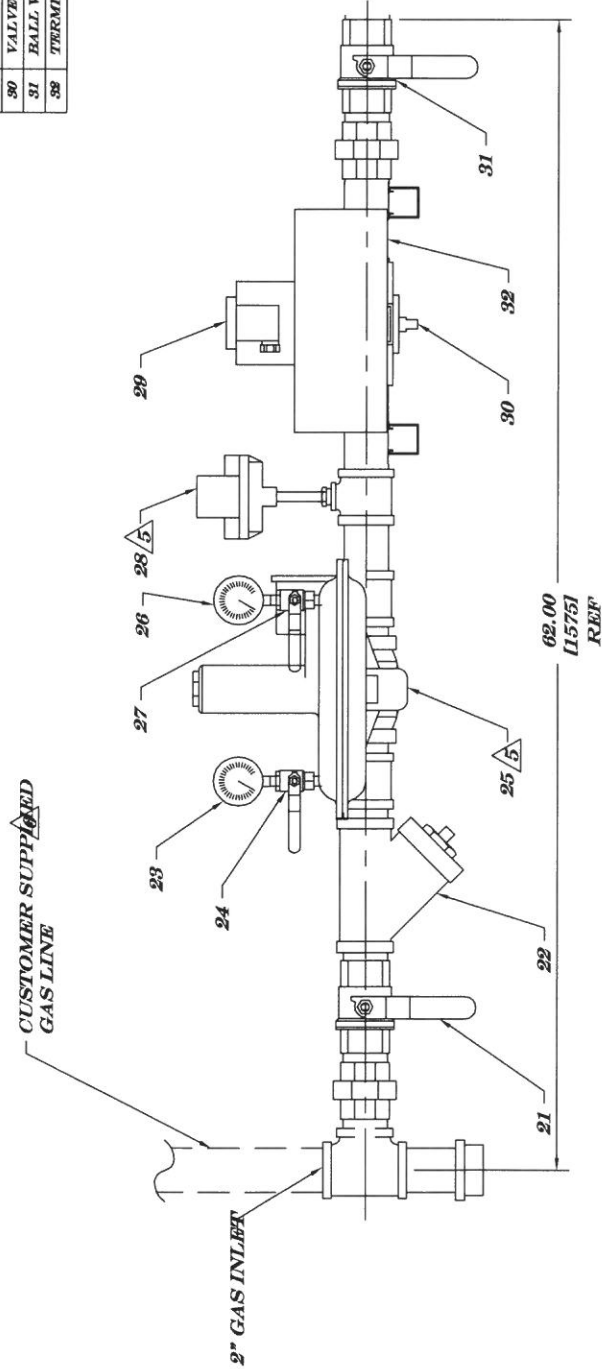
SCALE **NONE**

SHEET **8** OF **5**



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BILL OF MATERIAL			
ITEM	DESCRIPTION	MANUFACTURER	MODEL NO.
21	BALL VALVE	NEO	10358
22	STRAINER	MUELLER	11M CI Y-STR 80 MESH
23	GAUGE, 0-5 PSI	AMETEK	101970
24	BALL VALVE	KDI	46801-1
25	GAS REGULATOR, 18-28" 3/4" INVENSY	24519-9-78B	
26	GAUGE, 0-35" W.C.	AMETEK	101964
27	BALL VALVE	KDI	46801-1
28	SWITCH, LO GAS PRESSURE	ANTUNES	LGP-A 6-24" WC
29	MAIN GAS VALVE	KDI	MYD 030/6
30	VALVE POSITION INDICATOR	KDI	46800-8
31	BALL VALVE	NEO	10358
32	TERMINAL BOX	HOFFMAN	A1810CH



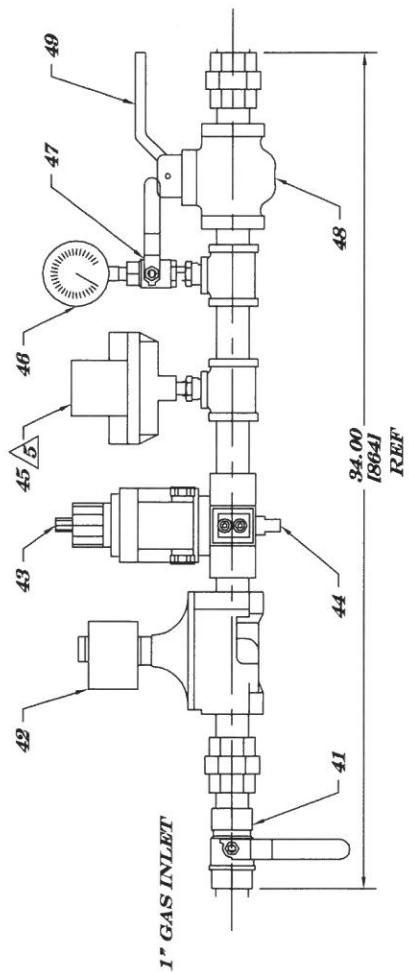
DETAIL SHOWING PREPIPED GAS TRAIN
ITEM 1
SH 3

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USA USA BELGIUM TAIWAN PRC

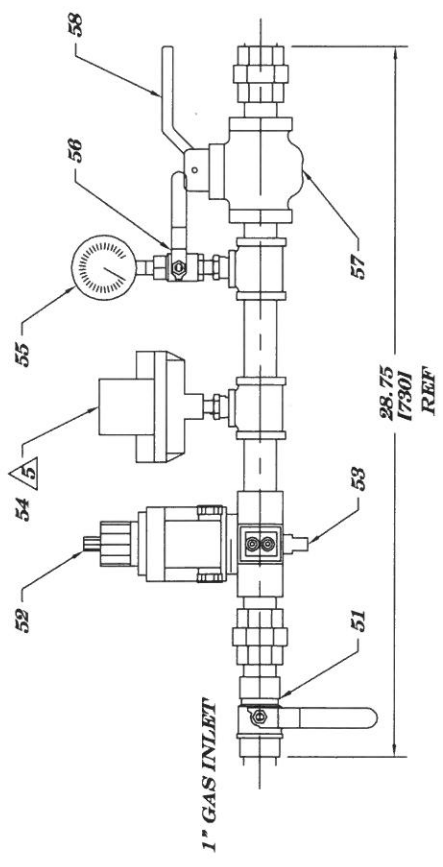
**PLUMBING DIAGRAM-
DRYER, (6 BURNER)**

REV	SIZE	DWG NO.
	B	12845102
SCALE	NON	SHEET 4 OF 5

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DETAIL SHOWING PREPIPED GAS TRAIN
ITEM 3
SH 3



DETAIL SHOWING PREPIPED GAS TRAIN
ITEM 2
SH 3

BILL OF MATERIAL			
ITEM	DESCRIPTION	MANUFACTURER	MODEL NO.
41	BALL VALVE	NEO	10948
42	SOLENOID VALVE	ASCO	JH881450
43	BLOCKING GAS VALVE	KDI	MYDL 210/6
44	VISUAL INDICATOR	KDI	46000-6
45	SWITCH, HIGH GAS PRESSURE	RENTUNES	HGP-A 10-50° W.C.
46	GAUGE, 0-35° W.C.	AMETEK	101064
47	BALL VALVE	KDI	46801-1
48	PLUG VALVE	NEWMAN	900M 1"
49	HANDLE	NEWMAN	68SS

BILL OF MATERIAL			
ITEM	DESCRIPTION	MANUFACTURER	MODEL NO.
51	BALL VALVE	NEO	10948
52	BLOCKING GAS VALVE	KDI	MYDL 210/6
53	VISUAL INDICATOR	KDI	46000-6
54	SWITCH, HIGH GAS PRESSURE	RENTUNES	HGP-A 10-50° W.C.
55	GAUGE, 0-35° W.C.	AMETEK	101064
56	BALL VALVE	KDI	46801-1
57	PLUG VALVE	NEWMAN	900M 1"
58	HANDLE	NEWMAN	68SS


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 USA BELGIUM TAIWAN PRC

**PLUMBING DIAGRAM-
DRYER, (6 BURNER)**

REV B SIZE B DWG NO. 12845102

SCALE NONE SHEET 5 OF 5

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Revisions:

Product Description	Final Size	Protein	Internal Fat	Bulk Density	Moisture Content Wet Basis		Notes	Maximum Capacity
					Into Dryer	Out Of Dryer		
	mm	%	%	lb/ft ³	%	%		lb/hr
Textured Meat Protein (TMP)	5-15	< 26	< 1	24	<50	>20	29	880-1200

Equipment will be designed for following utility specifications:

Water: 4 bar (400 kPa) (60 psig) minimum
 Compressed Air: 7 bar (700 kPa) (100 psig) minimum
 Steam: 8.5-10 bar (850-1000 kPa) (125-150 psig) minimum
 Natural Gas:
 8900 kcal/m³ (1000 Btu/ft³)
 0.25-0.35 bar (25-35 kPa) (3.5-5.0 psig)
 0.6 specific gravity
 Chemical composition similar to 90% CH₄, 5% C₂H₆, 5% N₂
 100% propane, 100% butane, or a mixture of both is acceptable. However, unless otherwise specified, equipment will be designed and built for natural gas.

Equipment will be designed for following electrical specifications:

Motors:
 440-480 Volts
 60 Hertz
 3-Phase
 Starter Signal/Control Voltage used to energize coils on motor starters: 110-120 Vac
 Brand: Wenger to specify
 Motors under 11 kW (15 hp) will be direct start
 Motors 11 kW (15 hp) and larger will be wye start / delta run
 Motor enclosures: TEFC
 Control Panel: IP52 (NEMA 12) unless specified otherwise
 1-Phase Voltage: 110-120 Volt
 Flame Safety and Gas Train Voltage: 110-120 Volt
 Field Device Voltage: 110-120 Volts

Item	Wenger Shop Order Number	Equipment Description	Equipment Code
01.	12845-1	Used TC Dryer	DO/VII/2400/3Z//A/3-Six//TJ/SM/FA/F/NNY/
02.	12845-2	APM Basic for Dryer	
03.		TX85 MAG ST Extruder	TX85/SS4HC/MNA////

WENGER UTILITY REQUIREMENTS

March 29, 2011

Saturated Steam Requirements for Sizing Lines (Connected) (see notes 4 and 19)							
Item	Equipment Description	Item Description	Type	Pressure	Duty		Notes
				psig		lb/hr	
03.	TX85 MAG ST Extruder	Extruder Barrel Heating	3	80	100%	100	Estimated requirement for future HIP
		Extruder Barrel Injection	1	100	100%	210	
		Future HIP	1	30	100%	750	
		Total for Item 03				1060	
		Total For Everything				1060	
Type: 1=process (into product), 2=heating (returnable to boiler), 3=heating (not returnable to boiler), 4=humidity control (into air)							

Saturated Steam Requirements for Estimated Used (Consumed) (see notes 5 and 19)			
Item	Product Description		Notes
		lb/hr	
	Textured Meat Protein (TMP) @ 5-15	125	
	Average for All Products	125	

Water Requirements for Sizing Lines (Connected) (see notes 4, 8 and 20)							
Item	Equipment Description	Item Description	Type	Pressure	Duty		Notes
				psig		lb/hr	
03.	TX85 MAG ST Extruder	Extruder Barrel Cooling	3	60	100%	1100	
		Extruder Barrel Injection	1	60	100%	300	
		Future HIP	1	60	100%	1100	
		Gearbox Cooling	2	60	100%	1100	
		Total for Item 03				3600	
		Total For Everything				3600	
Type: 1=process (into product), 2=cooling (reuseable), 3=heating (not reuseable), 4=closed loop heating and/or cooling							

Water Requirements for Estimated Used (Consumed) (see notes 5, 8 and 20)			
Item	Product Description		Notes
		lb/hr	
	Textured Meat Protein (TMP) @ 5-15	920	
	Average for All Products	920	

Compressed Air Requirements for Sizing Lines (Connected) (see notes 4, 6, 9 and 21)							
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WENGER UTILITY REQUIREMENTS

March 29, 2011

Item	Equipment Description	Item Description	Type	Pressure	Duty		Notes
				psig		cfm	
03.	TX85 MAG ST Extruder	Downspout Bypass	2	80	1%	4.0	
		Head Jacket Plumbing	1	80	100%	0.29	
		Total for Item 03				4.3	
		Total For Everything				4.3	
Type: 1=dry instrument air, 2=lubricated for cylinders, etc.							

Compressed Air Requirements for Estimated Used (Consumed) (see notes 5, 6, 9 and 21)

Item	Product Description		Notes
		cfm	
	Textured Meat Protein (TMP) @ 5-15	0.20	
	Average for All Products	0.20	

Gas Requirements for Sizing Lines (Connected) (see notes 4)

Item	Equipment Description	Item Description	Type	Pressure	Duty		Notes
				psig		cfh	
02.	Used TC Dryer (3 pass DO)	Heating Gas	1	4	100%	2462	
		Total For Everything				2462	
Type: 1=natural, 2=propane, 3=butane, 4=fuel oil, 5=other							

Gas Requirements for Estimated Used (Consumed) (see notes 5)

Item	Product Description		Notes
		cfh	
	Textured Meat Protein (TMP) @ 5-15	1894	
	Average for All Products		

Exhaust Air Requirements for Sizing Lines (Connected) (see notes 25)

Item	Equipment Description	Item Description	Type	Pressure	Duty		Notes
				in wc		cfm	
01.	Used TC Dryer (3 pass DO)	Dryer Exhaust		10	100%	4500	
		Total for Item 01				4500	
		Total For Everything				4500	

Exhaust Air Requirements for Estimated Used (Consumed) (see notes 25)			
Item	Product Description		Notes
		cfm	
	Textured Meat Protein (TMP) @ 5-15	4500	
	Average for All Products	4500	

Electrical Requirements for Sizing (Connected) (see notes 4, 5, 6, 7, 10, 11 and 23)												
Item	Equipment Description	Item Description	Type	Qty	Hp	kW	V	Ø	Hz	Amps	kVA	Notes
01.	Used TC Dryer	Oscillating Spout Sprdr	011	1	0.75	0.56	460	3	60	1	0	14
		Conveyor Drive 1	011	1	1.0	0.75	460	3	60	2	0	
		Conveyor Drive 2	011	1	1.0	0.75	460	3	60	2	0	
		Conveyor Drive 3	011	1	1.0	0.75	460	3	60	2	0	
		Recirculation Fans	011	6	7.5	5.6	460	3	60	11	2	
		Dryer Exhaust Fan	011	1	25	19	460	3	60	40	8	
		Combustion Blower	001	6	1	.75	460	3	60	1.8	1.4	
		Fines Augers	001	3	0.33	0.25	460	3	60	1	0	
		Side Plenum Augers	001	2	0.33	0.25	460	3	60	1	0	
		Total for Item 01		22	81	57				116	99	
02.	APM Basic for Dryer	APM Basic Control Panel	3	1			115	1	60	10	5	
		Total for Item 02		0						10	5	
03.	TX85 MAG ST Extruder	Lube Pump	001	1	1.3	0.98	460	3	60	3	1	14
		Main Drive	011	1	250	188	460	3	60	200	40	
		Knife Drive	011	1	5.0	3.8	460	3	60	8	2	
		Total for Item 03		3	242	182				211	43	
Total For Everything				25	322	240				337	147	
panel type: 1=other, 2=graphical manual control panel, 3=computer control panel, 4=motor control center												
motor type: 000=no motor, 001=AC constant speed motor, 011=AC motor with VFD												
101=reversing AC constant speed motor, 111=reversing AC motor with VFD												
002=DC drive, 022=SCR type DC drive, 003=Electro-mechanical drive, 990=Resistance heating												

Electrical Requirements for Estimated Used (Consumed) (see notes 5, 6, 7, 10, 11 and 23)			
Item	Product Description		Notes
		kW	
	Textured Meat Protein (TMP) @ 5-15	192	
	Average for All Products	192	

Notes:

3/29/2011

01. This information is provided to assist a client in the design of his plant. Since most processes are proprietary and Wenger does not have all the information necessary, Wenger assumes no responsibility for its accuracy or completeness.
02. Product capacities listed are measured after drying and cooling and before application of external coatings, unless noted otherwise.
03. Products listed are generic, and actual capacities may vary, depending on the specific products to be produced. Utilities for sizing (connected) are based on the product with the highest capacity.
04. Sizing (connected) values always include a margin to meet cold startup requirements and generally include excess capacity to meet unforeseen requirements. Values shown should be used for sizing such things as boilers, pipes, wires, etc.
05. Used (consumed) values are what should be required to operate the equipment after running conditions are reached, if the equipment is operated as expected. These are product specific. Values shown may be used for estimating utility costs.
06. Duty cycle is defined as the percentage time of operation during a normal production run.
07. Factor is the ratio of consumed to connected.
08. Water requirements shown do not include that required for cleaning or charging closed loop heating and/or cooling systems.
09. Compressed air requirements shown do not include that required for cleaning.
10. Power factor of all motors is assumed to be 85%.
11. Motor control center (MCC) with starters furnished by client.
13. See proposal for detailed descriptions of equipment.
14. This item is suitable for a wye start, delta run, type starter.
15. Capacity listed does not include coatings.
19. Client to furnish saturated steam at a minimum pressure of 8.7 bar (125 psig). The pressure will be reduced to the value shown.
20. Client to furnish water at a minimum pressure of 4.2 bar (60 psig). The pressure will be reduced to the value shown.
21. Client to furnish compressed air at a minimum pressure of 7.0 bar (100 psig). The pressure will be reduced to the value shown.
23. Amps shown are normal NEMA full load amps at voltage shown. See Parts Manual and vendor instructions for actual full load amps. See appropriate codes for wire and fuse sizing.
25. Exhaust air volumes shown are at actual conditions: adjusted for temperature and elevation.

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GENERAL NOTES:

1. INTERPRET ELECTRICAL SYMBOLS PER SHEET 6.
 2. SINGLE CONDUCTOR CONTROL PANEL WIRE SIZE IS NUMBER 16 AWG(AMERICAN WIRE GAUGE) MULTIPLE STRAND COPPER. MULTIPLE CONDUCTOR, SHIELDED CABLE WIRE IS NUMBER 20 AWG MULTIPLE STRAND COPPER.
 3. CONTROL PANEL AND ALL EQUIPMENT FRAMES MUST BE GROUNDED AS REQUIRED BY LOCAL CODES.
 4. WENGER PROVIDES CONTROL PANEL AND SOME MOTORS. CUSTOMER TO PROVIDE MOTOR STARTERS, OVER CURRENT PROTECTION, DISCONNECT SWITCHES, INTERCONNECTION SWITCHES, INTERCONNECTION WIRING AND CONDUIT.
 5. CONTROL PANEL IS A MODIFIED NEMA 4(MOISTURE TIGHT). CUSTOMER TO MAKE REQUIRED CONDUIT CONNECTIONS.
 6. ITEM NUMBERS CORRESPOND WITH THOSE ON PARTS LIST 31269.
 7. CUSTOMER IS TO FURNISH ADDITIONAL AUXILIARY CONTACTS FOR SOME MOTOR STARTERS. SEE CONTROL SCHEMATIC.
 8. ALL WIRES CONNECTED OR COMMON TO A WIRE THAT IS CONNECTED TO A TERMINAL STRIP ARE NUMBERED ON BOTH ENDS WITH THE TERMINAL BLOCK NUMBER. WIRES THAT ARE NOT COMMON TO A TERMINAL BLOCK ARE NUMBERED ON BOTH ENDS WITH THE NUMBER SPECIFIED ON THE CONTROL SCHEMATIC.
 9. FIELD WIRING, BETWEEN JUNCTION BOXES, CONTROL PANELS, MOTOR CONTROL CENTER, ETC., OF ALL ANALOG SIGNAL WIRES SHOULD BE PLACED IN A SEPARATE CABLEWAY OR CONDUIT FROM AC POWER AND CONTROL WIRING.
 10. WENGER INSTALLATION INSTRUCTIONS PERTAINING TO GROUNDING, SHIELDING, AND CABLE ROUTING SHOWN ON THIS DRAWING (AND THOSE OF COMPONENT SUB-SUPPLIERS) MUST BE FOLLOWED TO ENSURE ADEQUATE EMC PERFORMANCE.
 - 11-20. (NOT USED)
- DELTA NOTES REFERENCED ELSEWHERE ON DRAWING:
21. WIRING SHOWN ASSUMES A REMOTELY GROUNDED NEUTRAL. IF LOCAL CODES REQUIRE ANOTHER SYSTEM, CUSTOMER MUST MAKE MODIFICATION IN FIELD.
 22. CUSTOMER FURNISHED 3 PHASE POWER TO BE 460V/60HZ.
 23. CUSTOMER FURNISHED SINGLE PHASE CONTROL POWER TO BE 120V/60HZ. THIS POWER MAY BE DERIVED FROM 3 PHASE POWER IF PERMITTED BY LOCAL CONDITIONS.
- | | |
|---|-------------------|
| 24-41. (NOT USED) | 24-41. (NOT USED) |
| 42. COMMON GROUND WITH BURNER. | |
| 43. DO NOT MOUNT IGNITION TRANSFORMER DIRECTLY ON TOP OF DRYER. | |
| 44. (NOT USED) | |
| 45. DO NOT ROUTE FLAME DETECTOR LEAD WIRES IN CONDUIT WITH LINE VOLTAGE CIRCUITS OR HIGH VOLTAGE IGNITION TRANSFORMER WIRES. ENCLOSE FLAME DETECTOR LEAD WIRES WITHOUT ARMOR CABLE IN METAL CABLE OR CONDUIT. | |
| 46-47. (NOT USED) | |
| 48. 6000V IGNITION WIRE. | |
| 49. (NOT USED) | |
| 50. NORMALLY CLOSED MOTOR STARTER CONTACTS SHOWN MUST BE "POSITIVE GUIDED" TO MEET EN 954-1 CATEGORY II SAFETY REQUIREMENTS. | |
| 51-94. (NOT USED) | |



WENGER®

DWG NO.
12845103

DWG. TITLE
WIRING DIAGRAM -
DRYER, TRUE TEMP
(S.O.# 12845-2)
(US PET NUTRITION)

REV
NC

SHEET TITLE
NOTES

SHEET

2

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95. USE SHIELDED TWISTED WIRES FOR EXTERNAL CONNECTIONS OF REFERENCE SIGNALS.

96. 4-20mA OUTPUT SIGNAL.

97. DRYER CONVEYORS 2 & 3--SPEED SWITCH HAS BEEN FACTORY SET TO TRIP AT .05 RPM WITH THE SWITCH SETTINGS AS LISTED:

SWITCH	SWITCH SETTING
SWITCH #1	ON
SWITCH #2	ON
ROTARY SWITCH #1	0
ROTARY SWITCH #2	5

98. DRYER CONVEYOR 1--SPEED SWITCH HAS BEEN FACTORY SET TO TRIP AT .12 RPM WITH THE SWITCH SETTINGS AS LISTED:

SWITCH	SWITCH SETTING
SWITCH #1	ON
SWITCH #2	ON
ROTARY SWITCH #1	1
ROTARY SWITCH #2	2

99-131. (NOT USED)

132. HIGH TEMPERATURE LIMIT HAS BEEN FACTORY CALIBRATED FOR AN RTD INPUT. THE PARAMETERS THAT HAVE BEEN CHANGED ARE LISTED BELOW: OTHER PARAMETERS HAVE BEEN LEFT WITH THE DEFAULT SETTINGS. IF ADDITIONAL PROGRAMMING IS REQUIRED, SEE 82692 IN THE VENDOR SECTION OF THE MANUAL.

ENGINEERING MODE
F21 InP = 0012
Unit = 0001 (0000=C, 0001=F)
PGdP = 0000
F51 LPoW = 0000

SV SETTING & MONITOR MODE
SV = 350 (180 FOR C, 350 FOR F)

PARAMETER SETTING MODE
LCK = 1111

133. HONEYWELL RM7898A CONFIGURATION JUMPERS HAVE BEEN FACTORY SET TO THE FOLLOWING:

JUMPER
JR1 "10 SEC." INTACT
JR2 "LOCKOUT" CLIPPED
JR3 "LOCKOUT" CLIPPED



DWG NO.
12845103

DWG. TITLE WIRING DIAGRAM-
DRYER, TRUE TEMP
(S.O. # 12845-2)
(US PET NUTRITION)

REV
NC

SHEET TITLE
NOTES

SHEET
3

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DWG NO.
12845103

DWG. TITLE WIRING DIAGRAM -
DRYER, TRUE TEMP
(S.O.# 12845-2)
(US PET NUTRITION)

REV
NC

SHEET TITLE
NOTES

SHEET
5

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LEGEND

(ABBREVIATIONS)

AH ALARM HORN
BMC BURNER MONITORING CONTROL
CB CIRCUIT BREAKER
CON CONSTANTAN
COND CONDITIONING
CONT TEMPERATURE CONTROLLER
CR CONTROL RELAY
CT CURRENT TRANSFORMER
CU COPPER
CV CONTROL VALVE
DS DISCONNECT SWITCH
F FUSE
FS FLOW SWITCH
GEN TACHOMETER GENERATOR
GND GROUND
INDCR INDICATOR
L PILOT LIGHT (LAMP)
LC LOUVER CONTROLLER
LR LATCHING RELAY
LS LIMIT SWITCH
M MOTOR STARTER
MOT MOTOR
MPR MINUTES PER REVOLUTION
OL OVERLOAD SWITCH IN STARTER
PB PUSHBUTTON
PL ILLUMINATED PUSHBUTTON
POT POTENTIOMETER
R RESISTOR
RPM REVOLUTIONS PER MINUTE
RTD RESISTANCE TEMPERATURE DETECTOR
S SWITCH
SL ILLUMINATED SWITCH
SR SAFETY RELAY
TC THERMOCOUPLE
TD TIME DELAY RELAY
TS TEMPERATURE SWITCH
TT ELAPSED TIME METER (HOURS)
VFD VARIABLE FREQUENCY DRIVE
W WATT
XDCR TRANSDUCER
XFMR TRANSFORMER
XMTR TRANSMITTER

COLOR ABBREVIATIONS

G GREEN
R RED
W WHITE
Y YELLOW

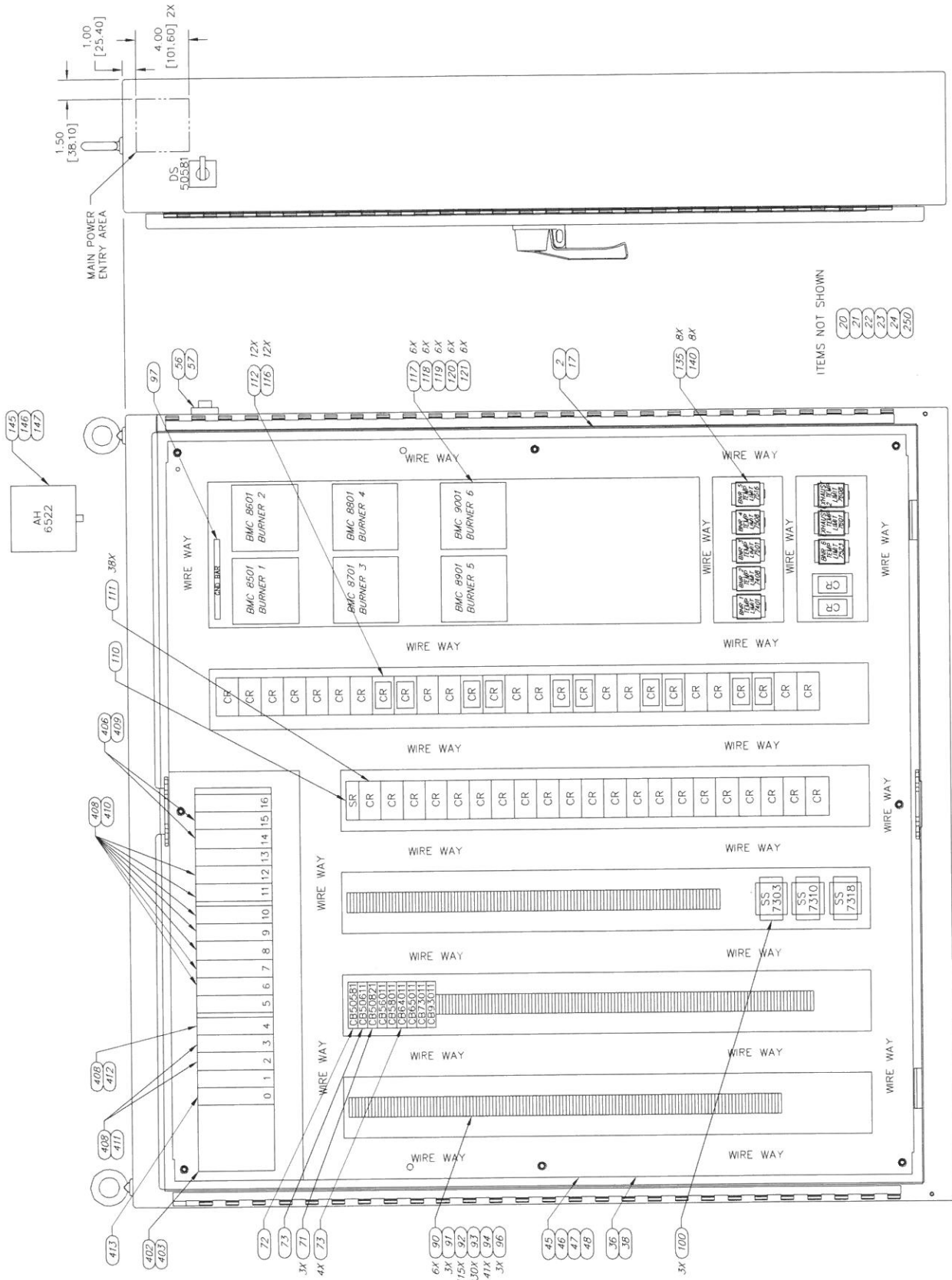
LEGEND

----- DELINEATES INTERCONNECTION WIRING TO BE PROVIDED BY CUSTOMER
_____ WIRING PROVIDED BY WENGER
----- DELINEATES COMPONENTS OR JUNCTION BOXES
○ _____ TERMINAL BLOCK IN CONTROL PANEL
Ⓐ _____ TERMINAL BLOCK IN OPERATOR CONSOLE

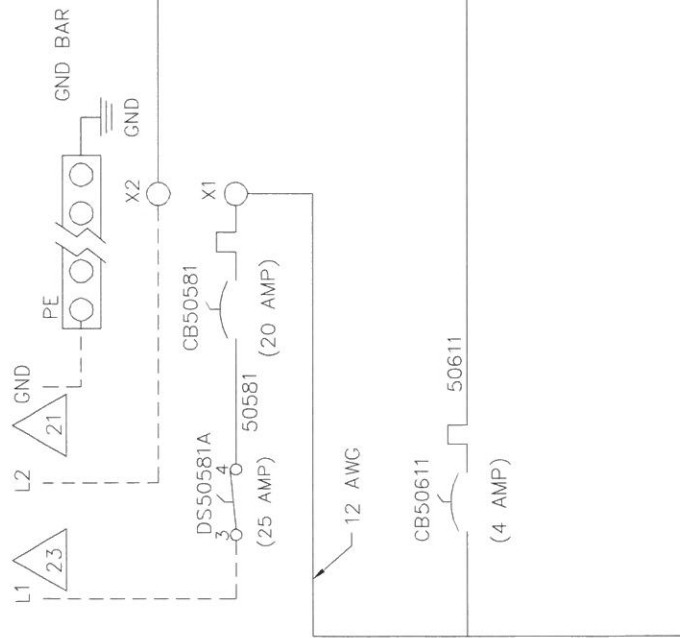
LEGEND

Ⓐ THRU Ⓔ _____ TERMINAL BLOCK IN BURNER JUNCTION BOX
Ⓓ _____ TERMINAL BLOCK IN DRYER JUNCTION BOX
Ⓔ _____ TERMINAL BLOCK IN GAS TRAIN JUNCTION BOX
➤ _____ PLUG/RECEPTACLE JUNCTION
⊙ _____ PILOT LIGHT (LAMP)
⊙ _____ NORMALLY OPEN CONTACT
⊙ _____ NORMALLY CLOSED CONTACT
⊙ _____ NORMALLY OPEN PUSHBUTTON CONTACT
⊙ _____ NORMALLY CLOSED PUSHBUTTON CONTACT
○ _____ RELAY COIL
○ _____ SOLENOID
⊙ _____ DISCONNECT SWITCH
⊙ _____ NORMALLY CLOSED LIMIT SWITCH
⊙ _____ HELD CLOSED LIMIT SWITCH
⊙ _____ CIRCUIT BREAKER
⊙ _____ NORMALLY OPEN TEMPERATURE SWITCH
⊙ _____ NORMALLY OPEN PRESSURE SWITCH
⊙ _____ NORMALLY CLOSED PRESSURE SWITCH
⊙ _____ NORMALLY OPEN LEVEL SWITCH
⊙ _____ MOTOR
⊙ _____ TERMINAL BLOCK IN JUNCTION BOX OR EXTERNAL DEVICE
⊙ _____ GROUND

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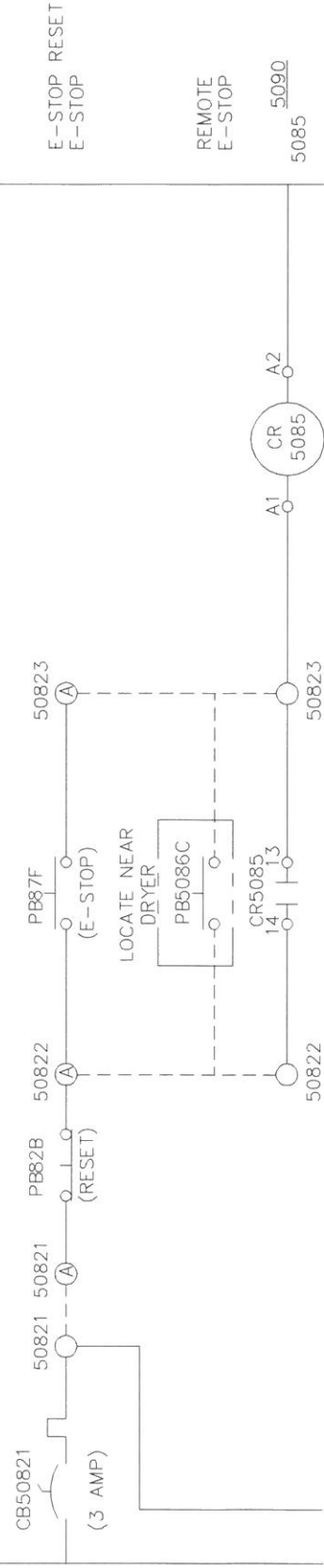
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DWG NO.
12845103

DWG. TITLE WIRING DIAGRAM -
(S.O.# 12845-2) DRYER, TRUE TEMP
(US PET NUTRITION)

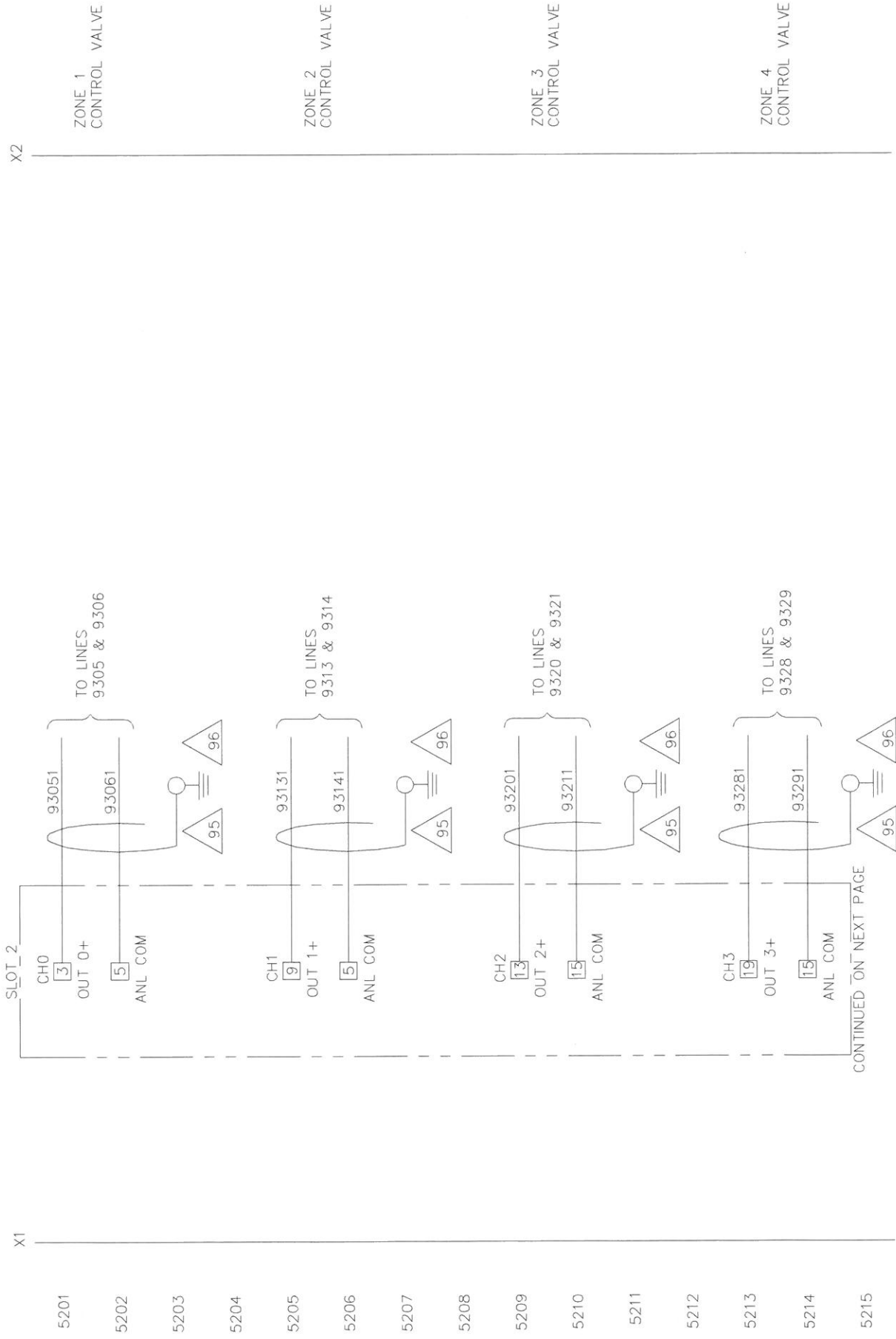
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SHEET TITLE
CONTROL SCHEMATIC

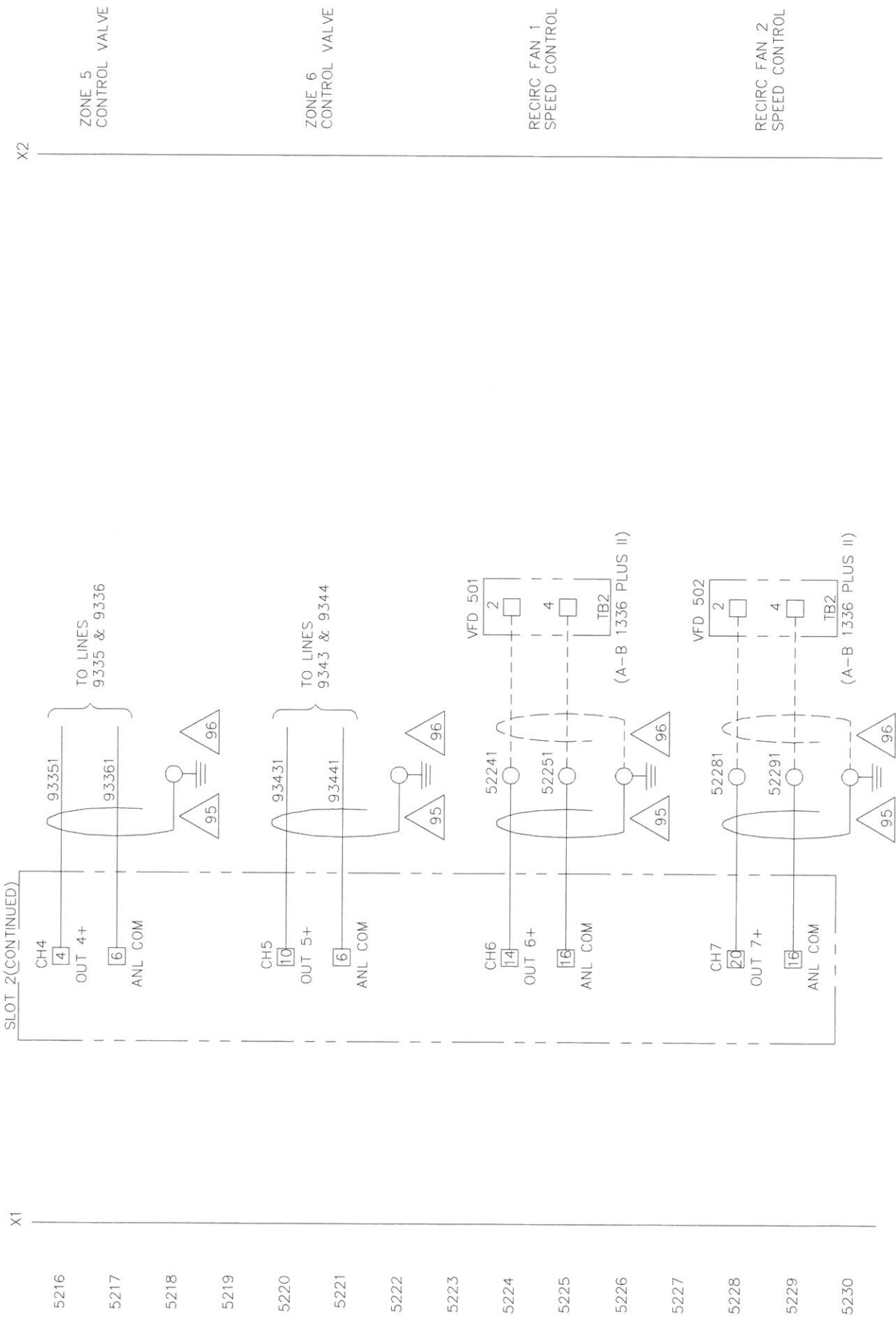
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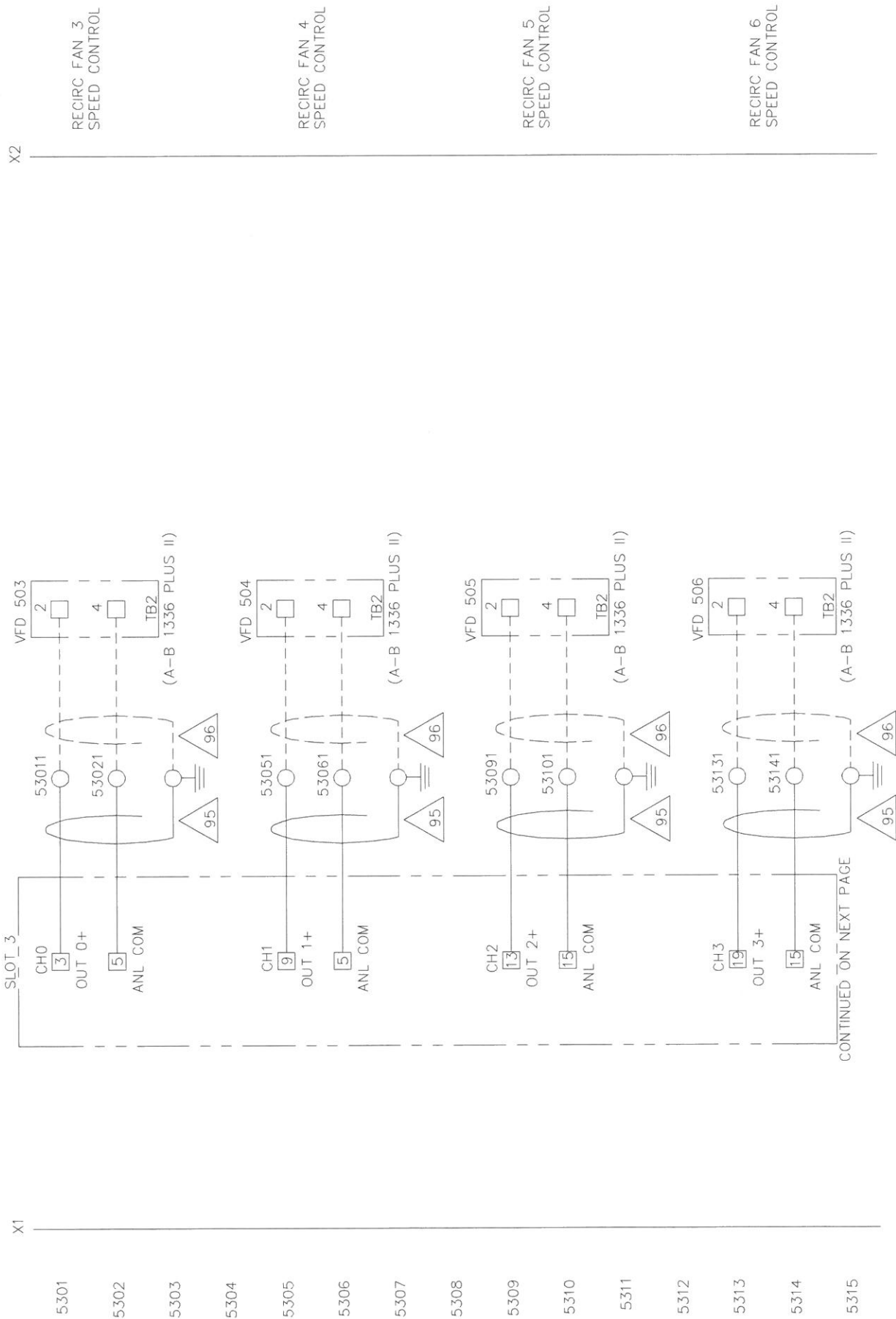
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DWG NO.
12845103

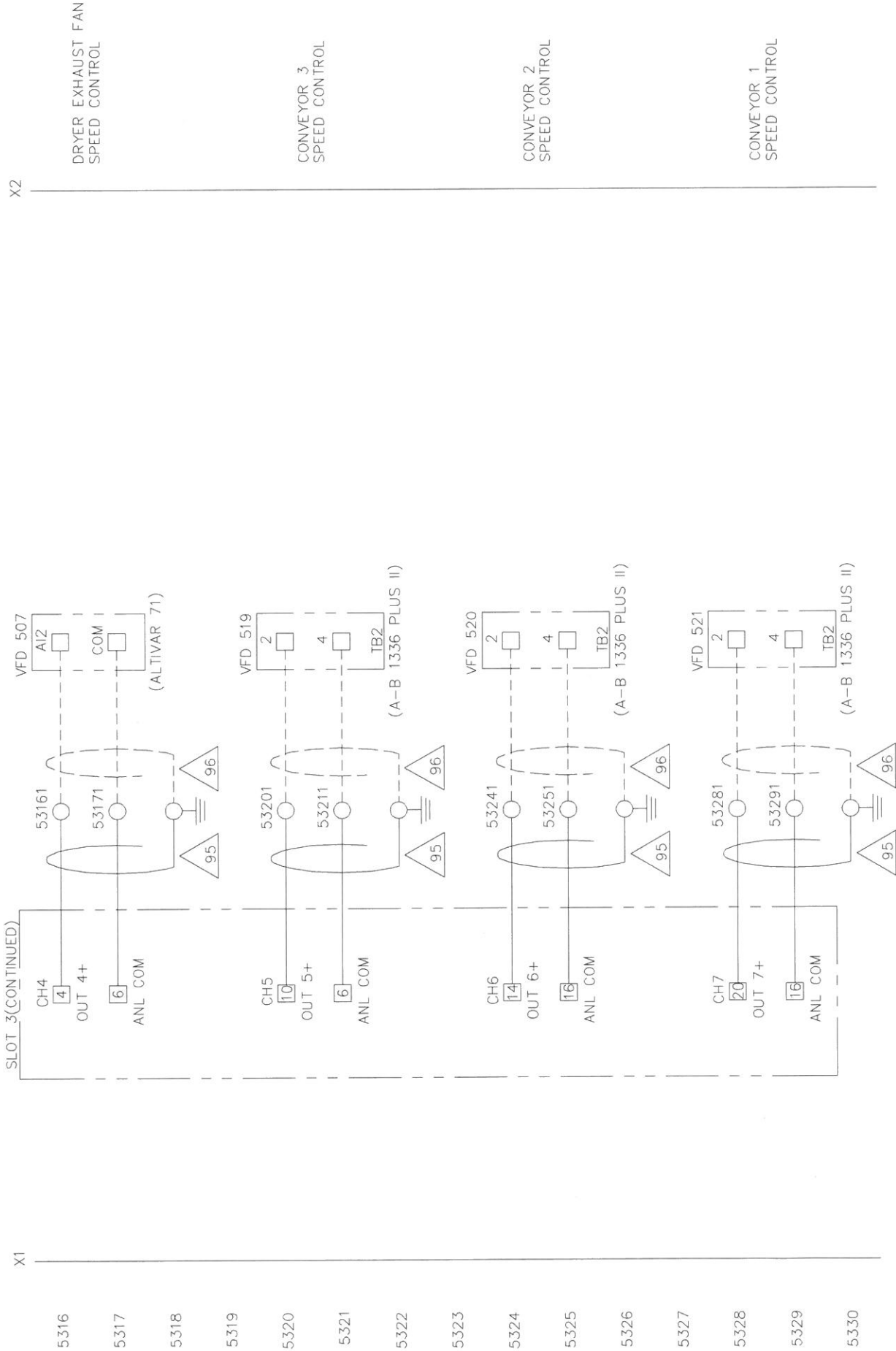
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DRYER, TRUE TEMP
(S.O # 12845-2)
(US PET NUTRITION)

REV
NC

SHEET TITLE
CONTROL SCHEMATIC

SHEET
16

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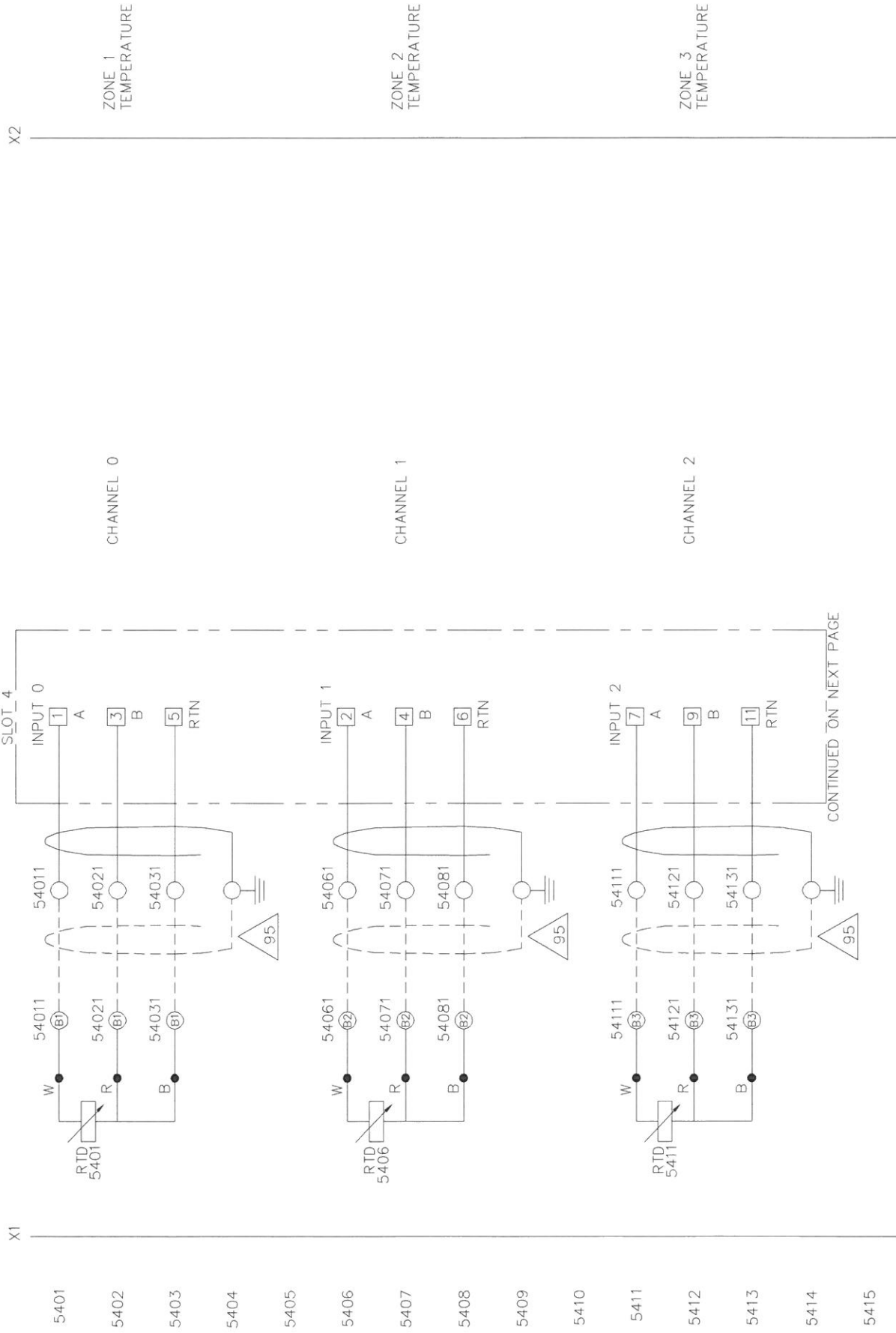
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DRYER, TRUE TEMP
(S.O.# 12845-2)
(US PET NUTRITION)

REV
NC

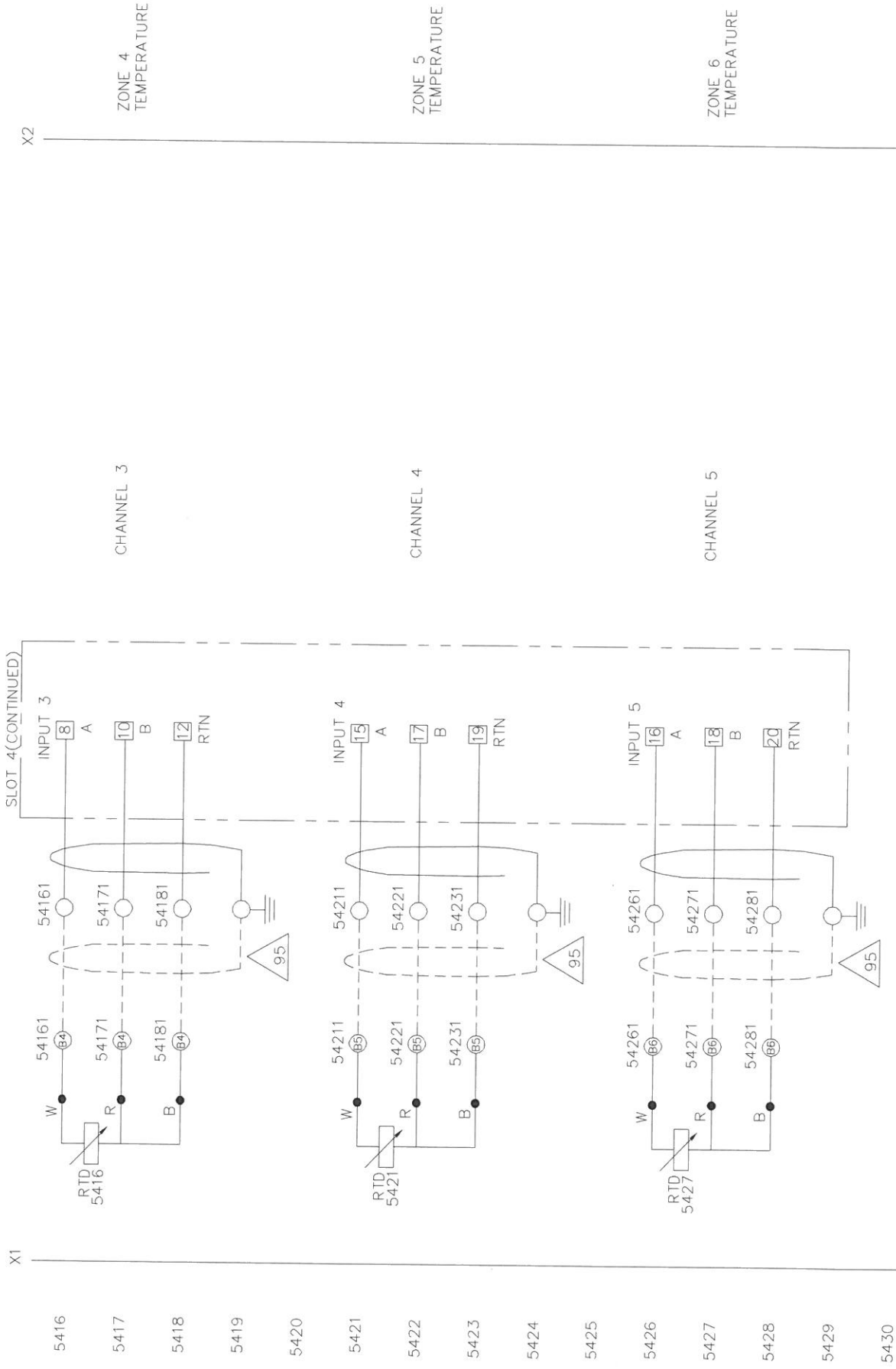
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CONTROL SCHEMATIC

SHEET
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DWG NO.
12845103

DWG. TITLE WIRING DIAGRAM-
DRYER, TRUE TEMP
(S.O.# 12845-2) (ION)
(US PET NUTRITION)

REV
NC

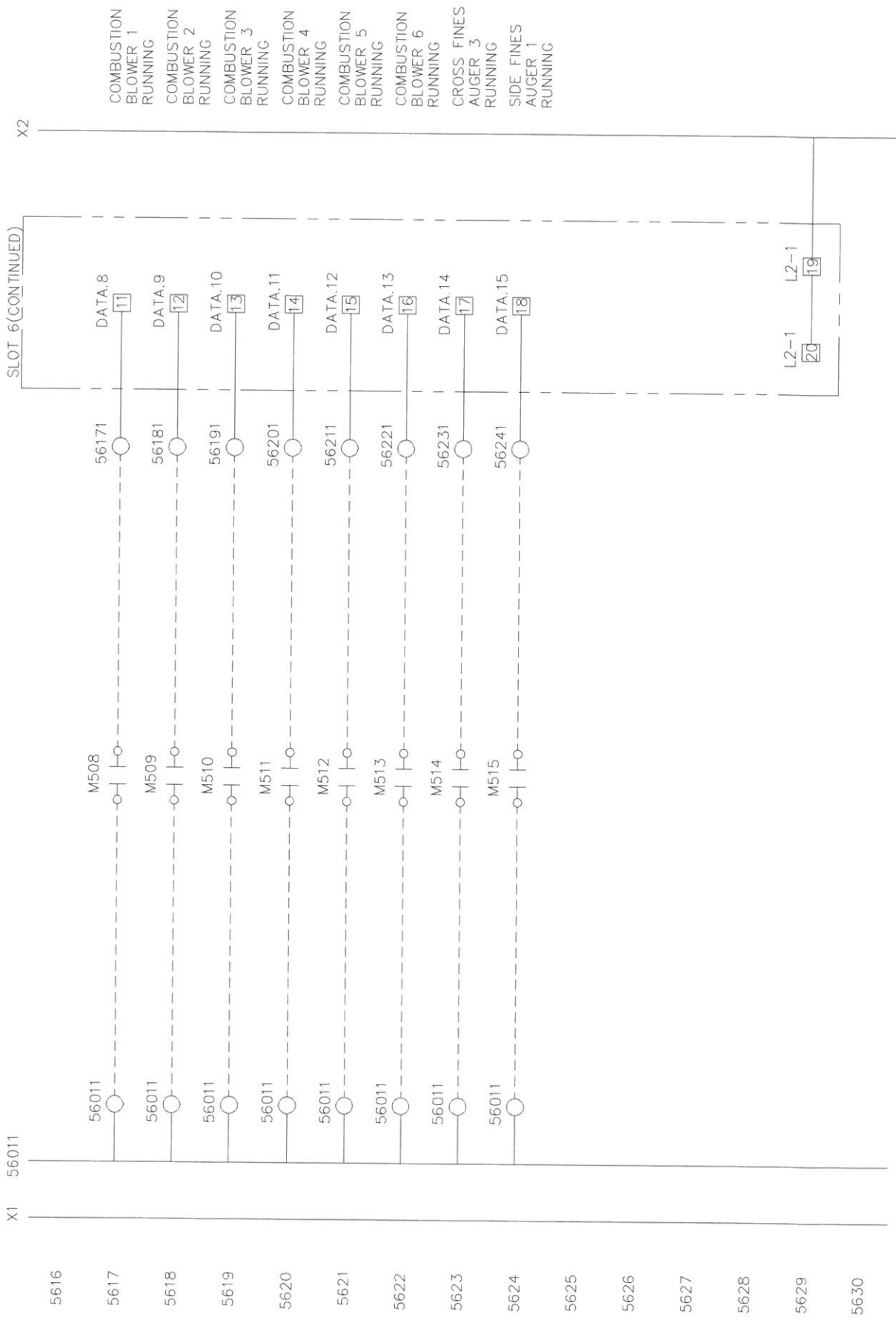
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CONTROL SCHEMATIC

SHEET
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X1
CB56011
56011
(3 AMP)



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12845103

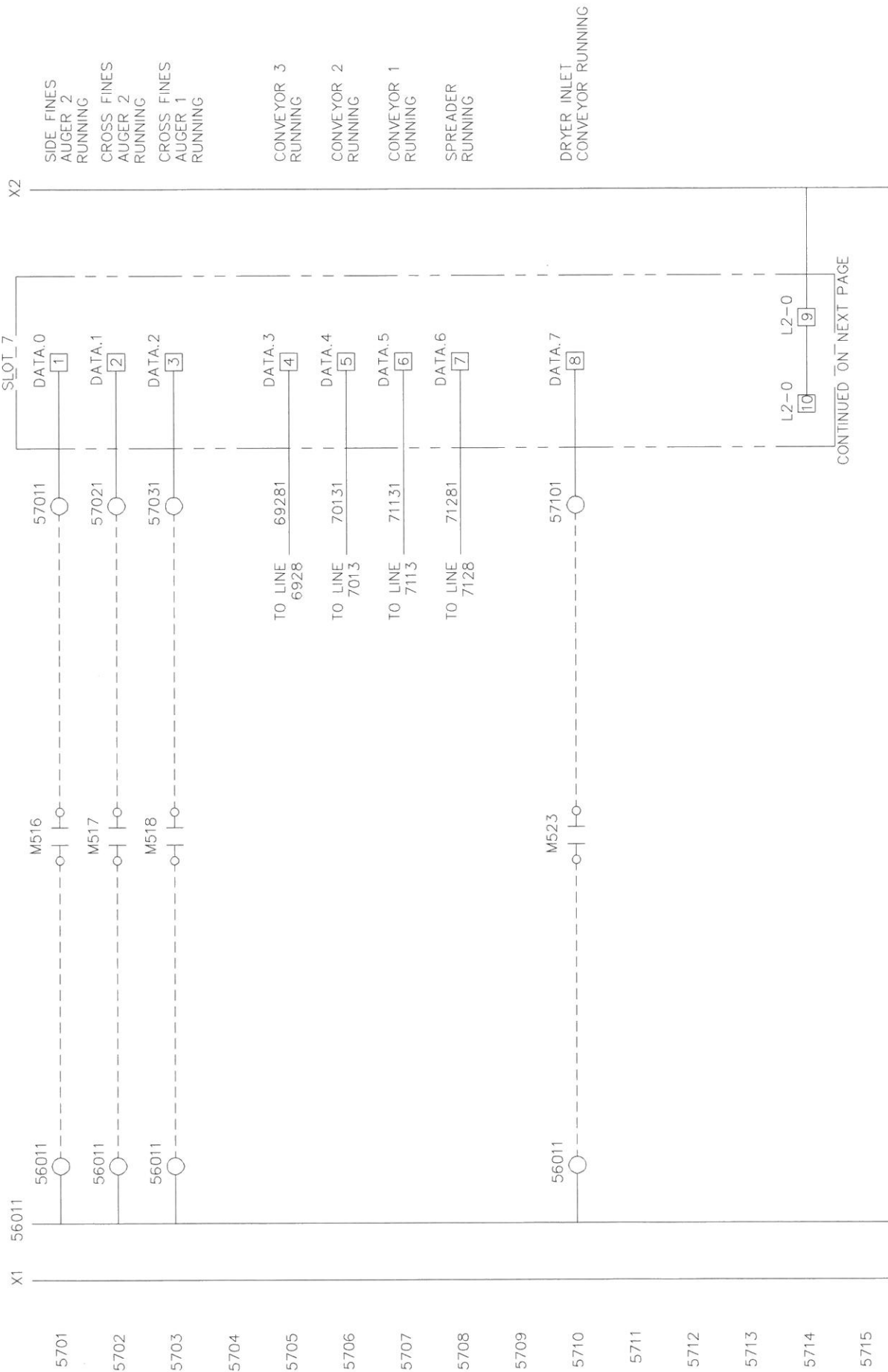
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DRYER, TRUE TEMP
(S.O.# 12845-2)
(US PET NUTRITION)

REV
NC

SHEET TITLE
CONTROL SCHEMATIC

SHEET
21

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12845103

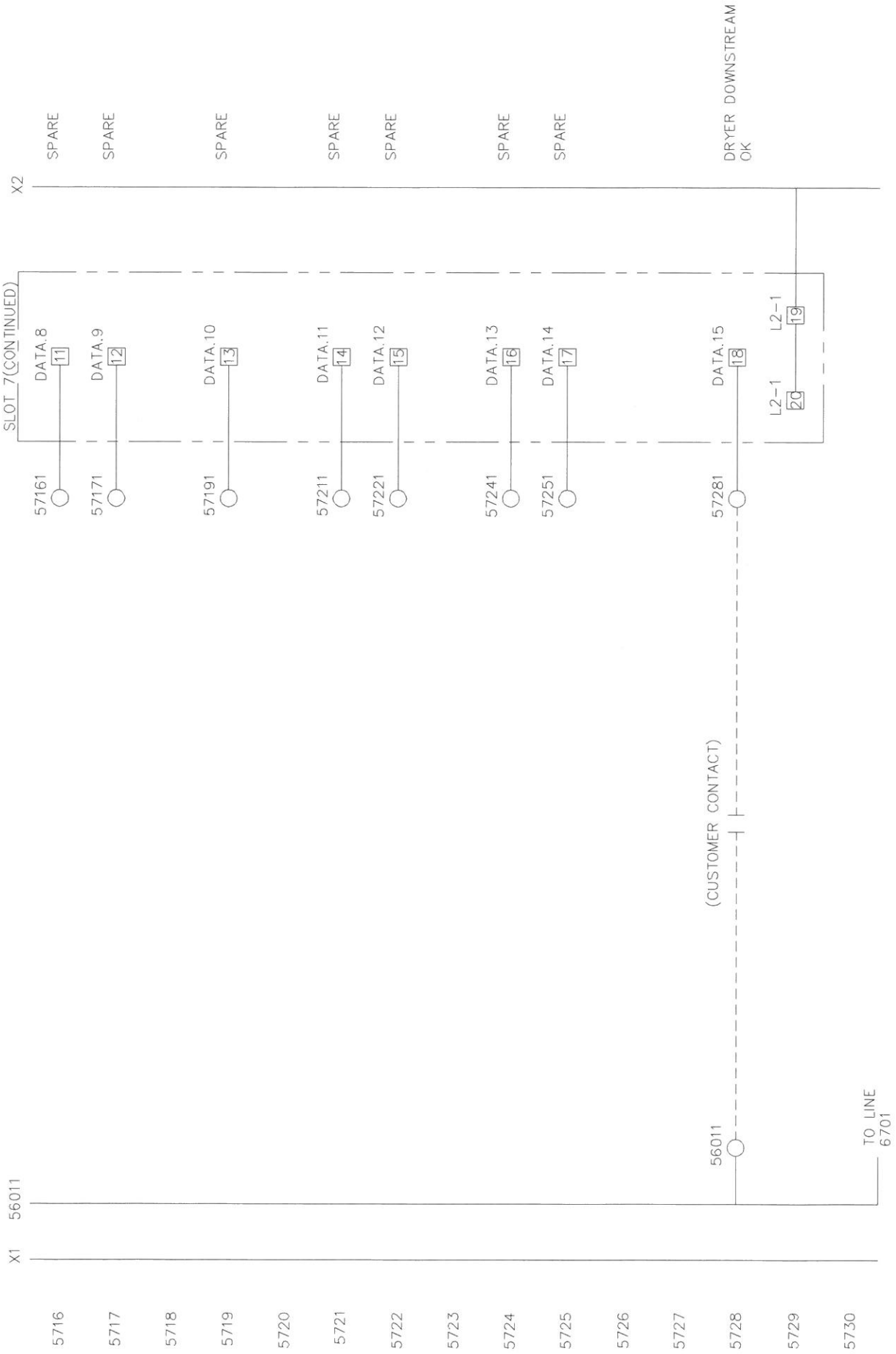
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DRYER, TRUE TEMP
(S.O.# 12845-2)
(US PET NUTRITION)

REV
NC

SHEET TITLE
CONTROL SCHEMATIC

SHEET
22

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DWG NO.
12845103

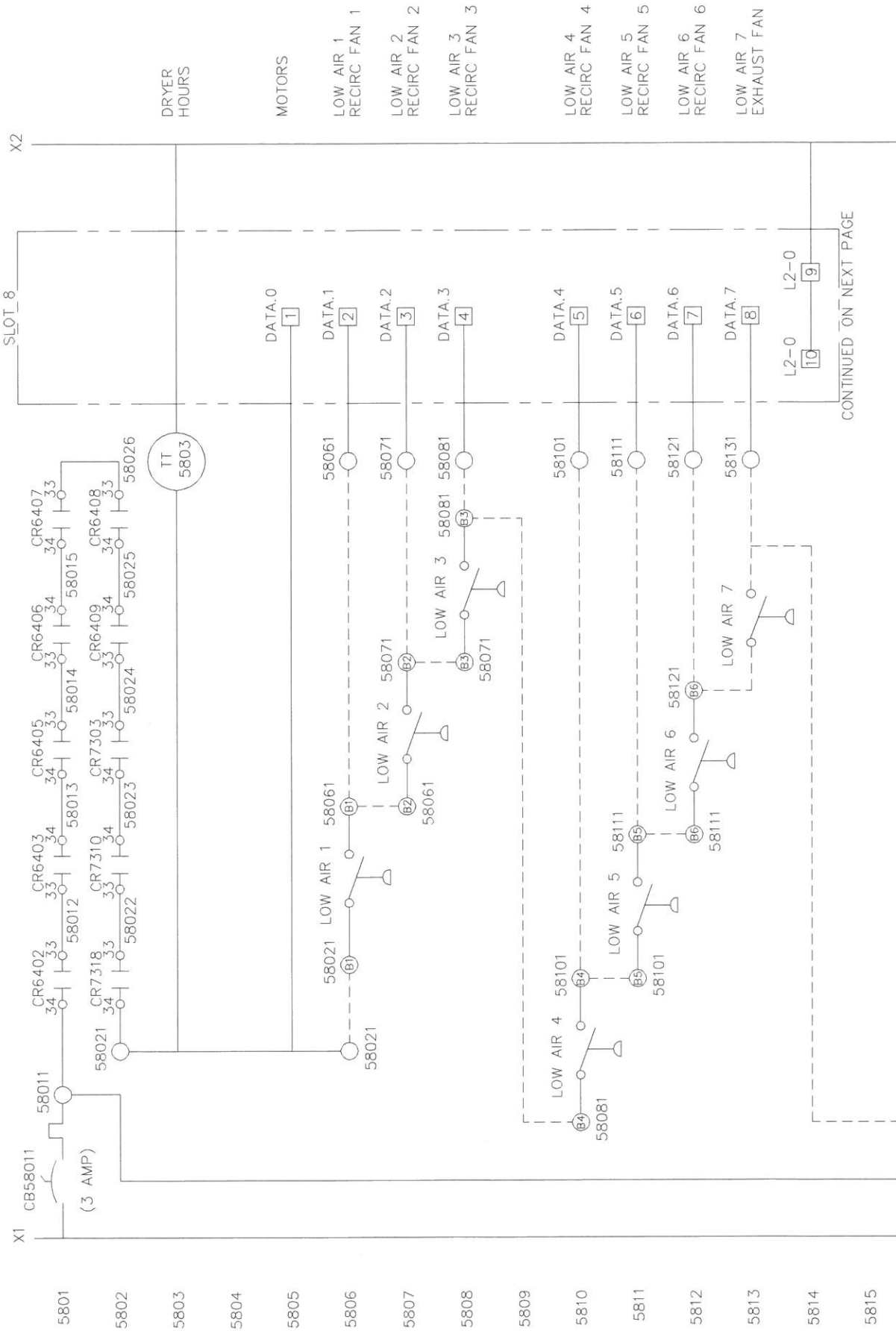
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DRYER, TRUE TEMP
(S.O. # 12845-2)
(US PET NUTRITION)

REV
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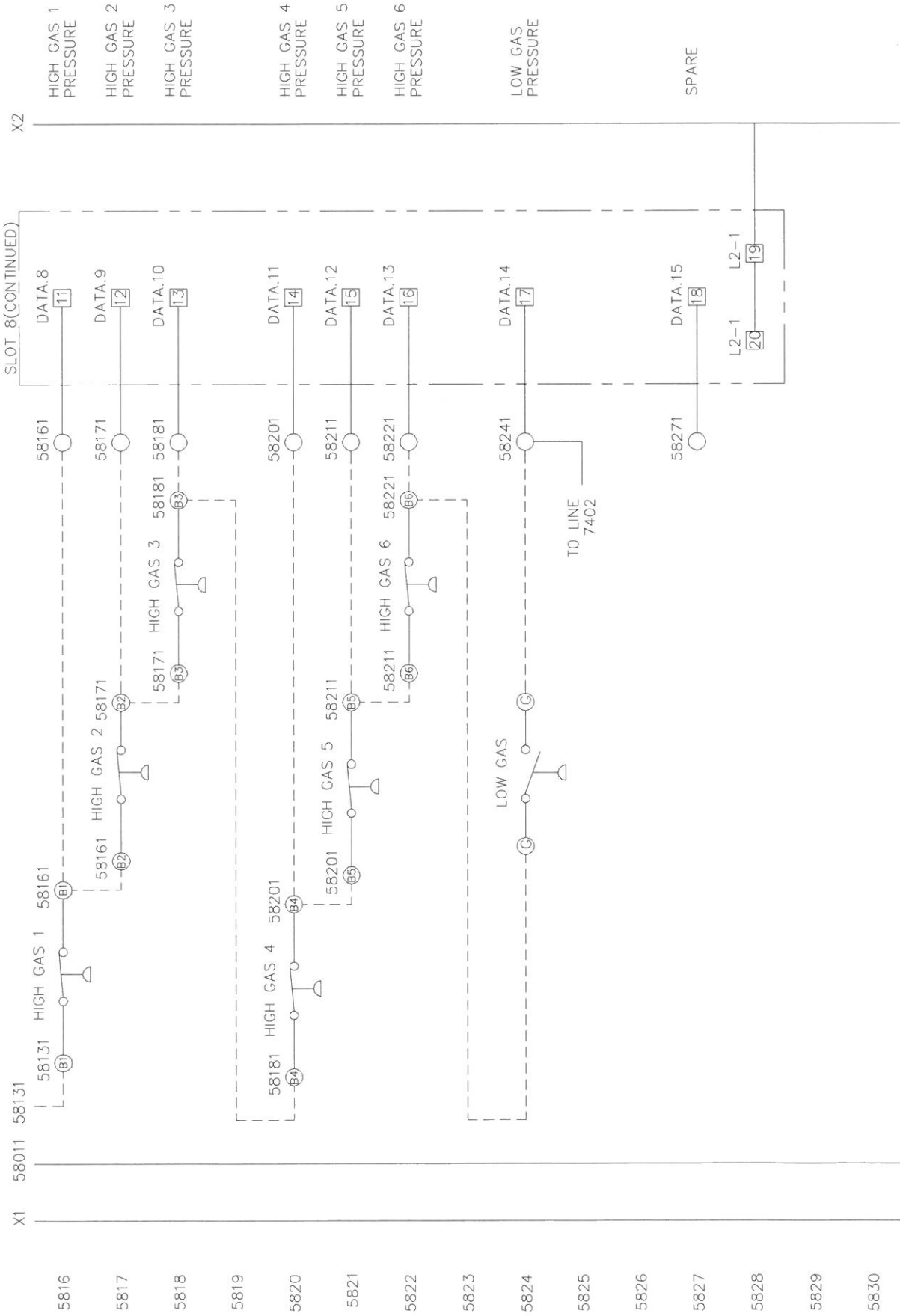
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CONTROL SCHEMATIC

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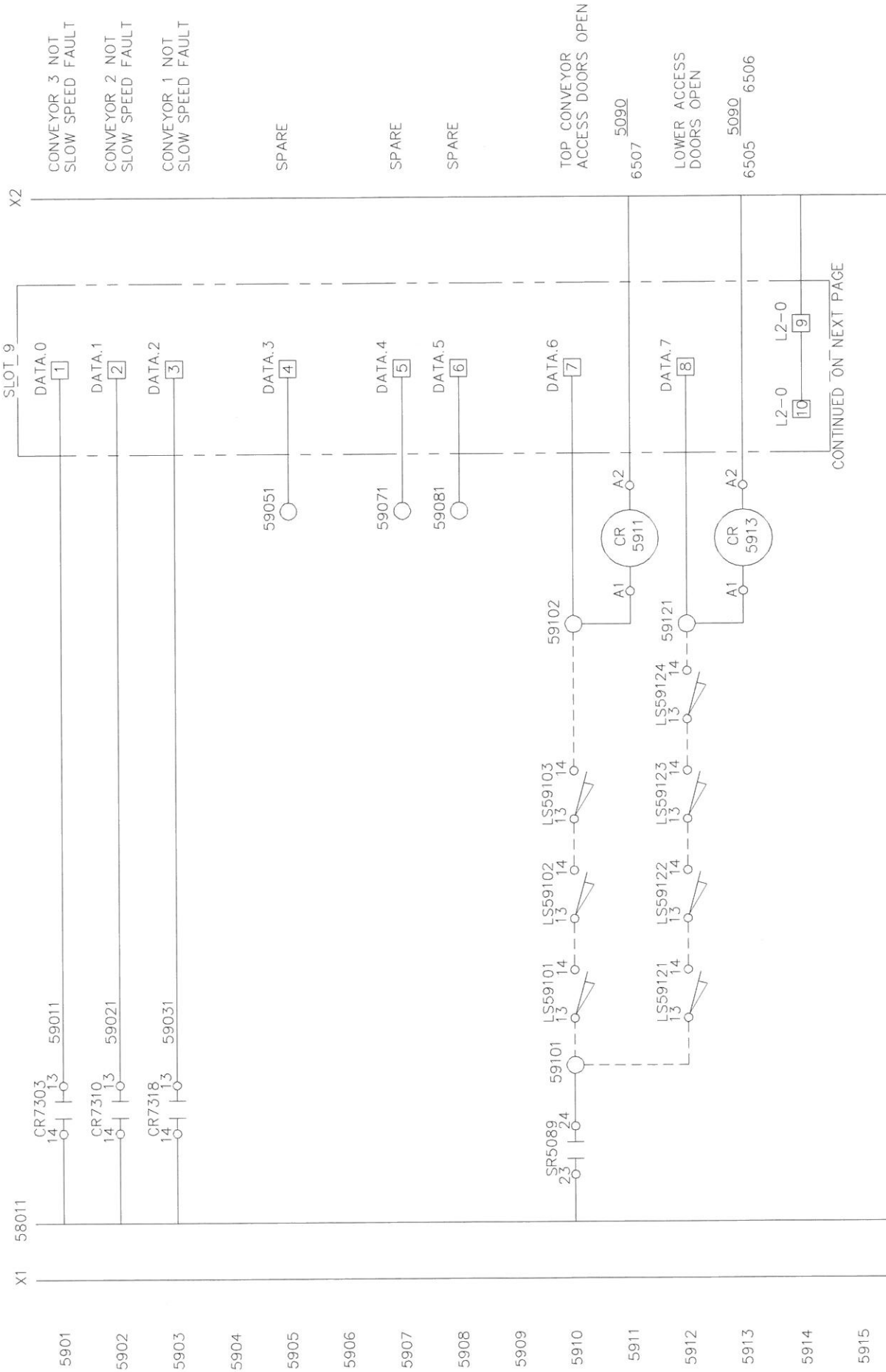
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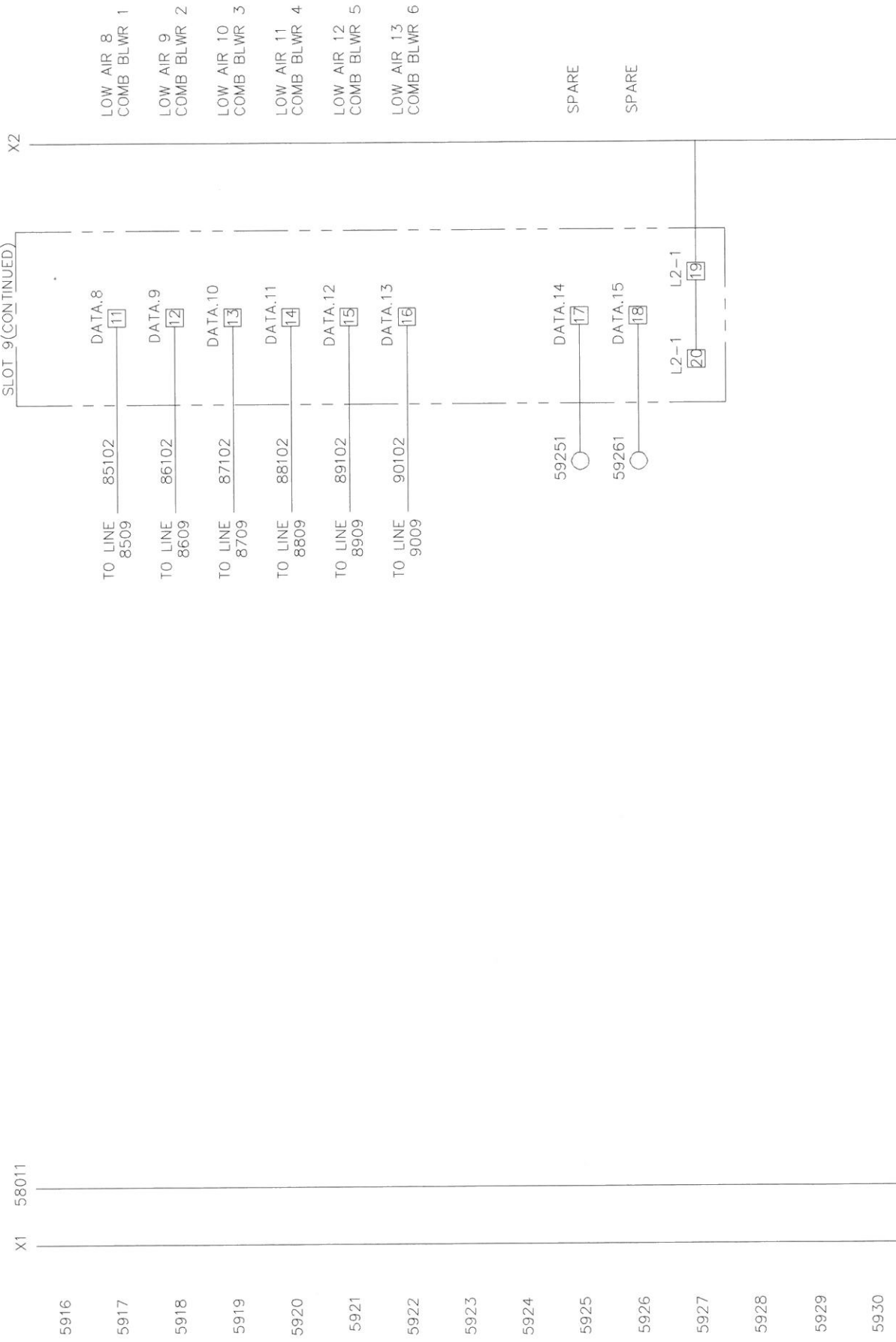
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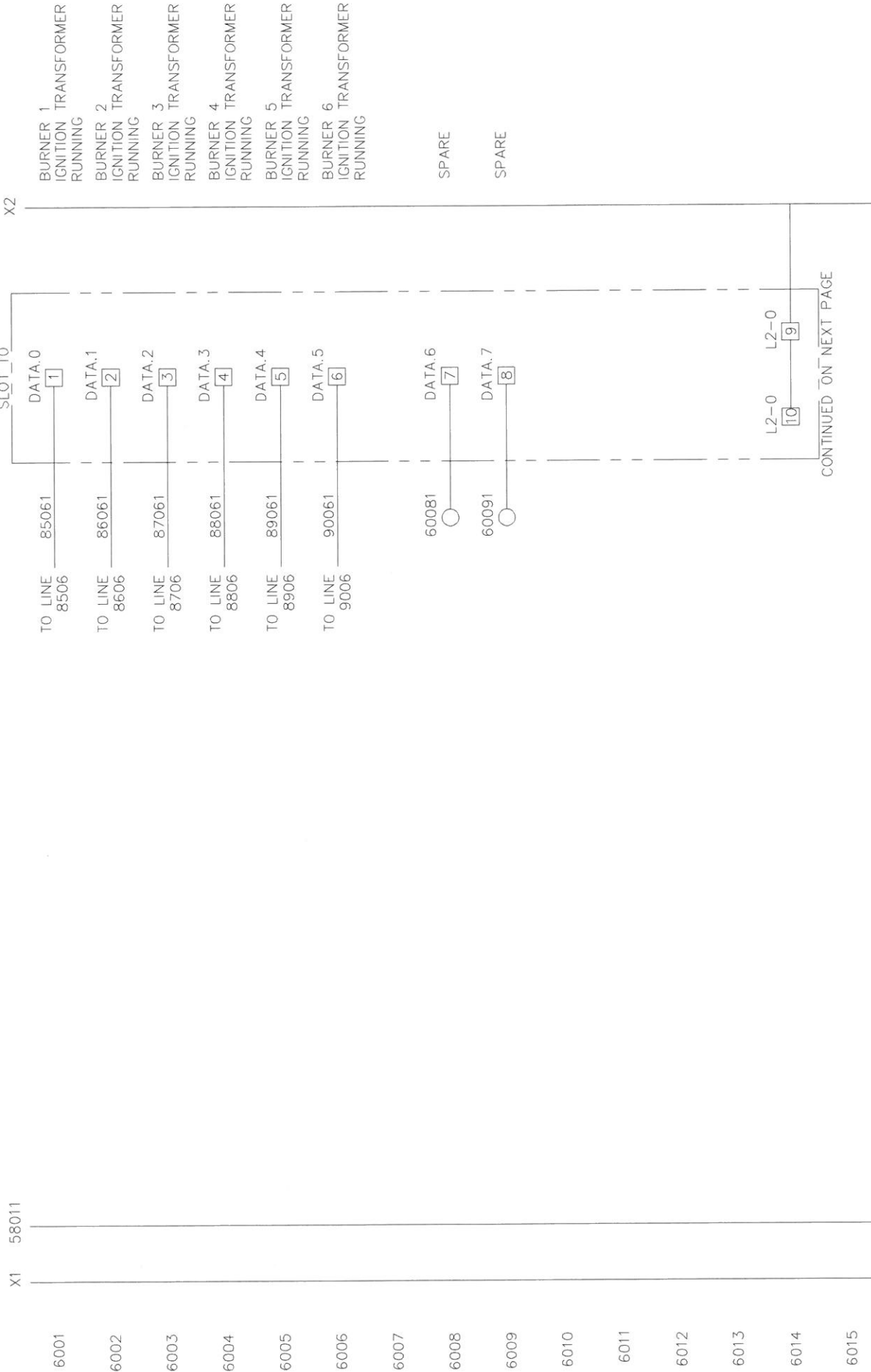
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X1 58011

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SLOT 10(CONTINUED)

DATA.8

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85091

TO LINE 8510

DATA.9

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86091

TO LINE 8610

DATA.10

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87091

TO LINE 8710

DATA.11

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88091

TO LINE 8810

DATA.12

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89091

TO LINE 8910

DATA.13

16

90091

TO LINE 9010

DATA.14

17

60241

DATA.15

18

60251

L2-1 L2-1

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X2

BURNER 1
ON

BURNER 2
ON

BURNER 3
ON

BURNER 4
ON

BURNER 5
ON

BURNER 6
ON

SPARE

SPARE



DWG NO.
12845103

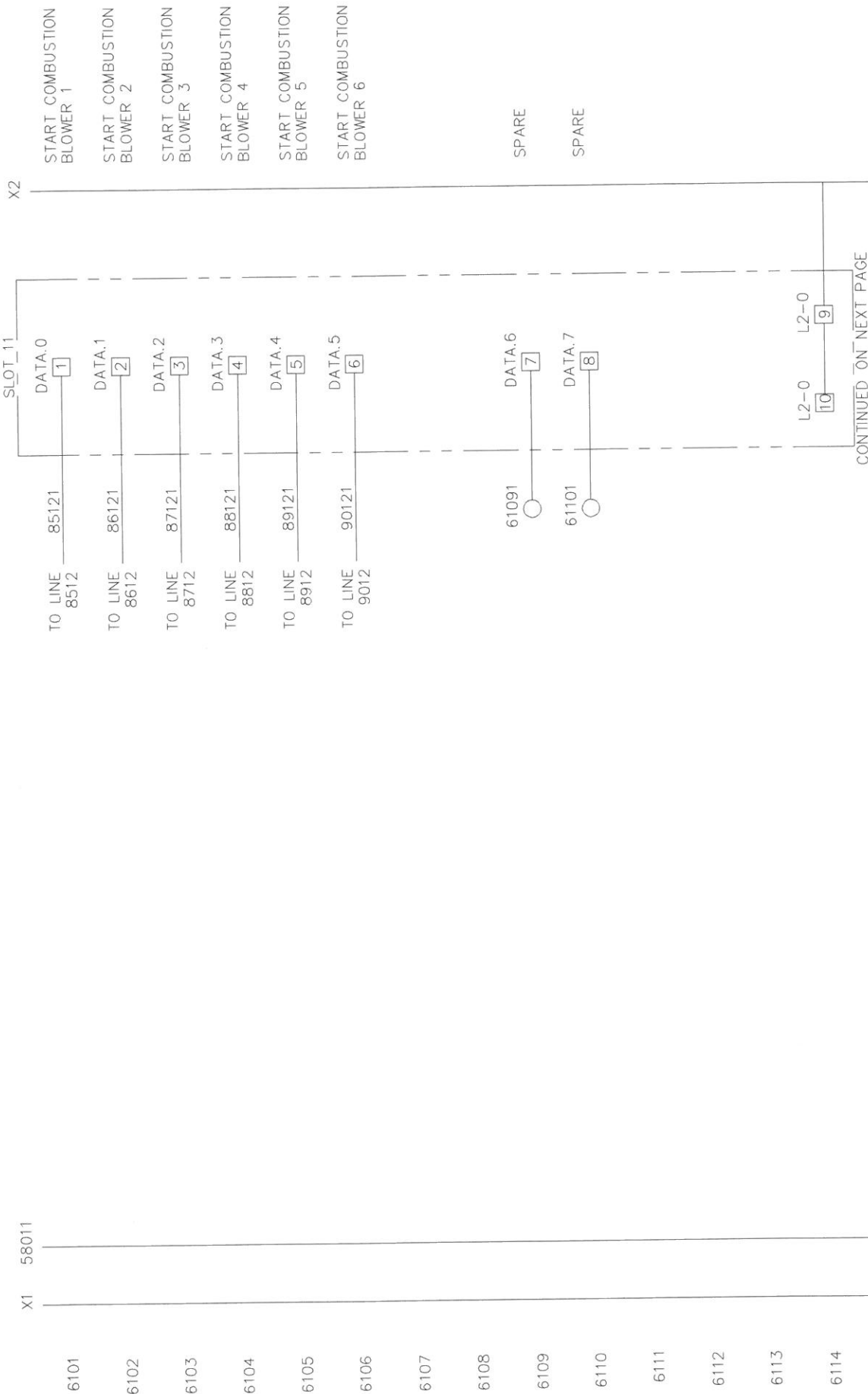
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DRYER, TRUE TEMP
(S.O.# 12845-2)
(US PET NUTRITION)

REV
NC

SHEET TITLE
CONTROL SCHEMATIC

SHEET
29

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DWG NO.
12845103

DWG. TITLE WIRING DIAGRAM -
DRYER, TRUE TEMP
(S.O.# 12845-2) (ON)

REV
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SHEET TITLE
CONTROL SCHEMATIC

SHEET
30

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X1 58011

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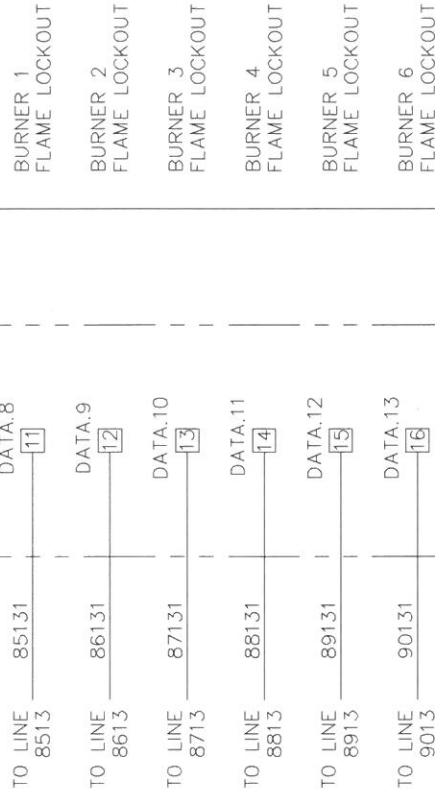
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SLOT 11 (CONTINUED)



SPARE

SPARE



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DWG NO.
12845103

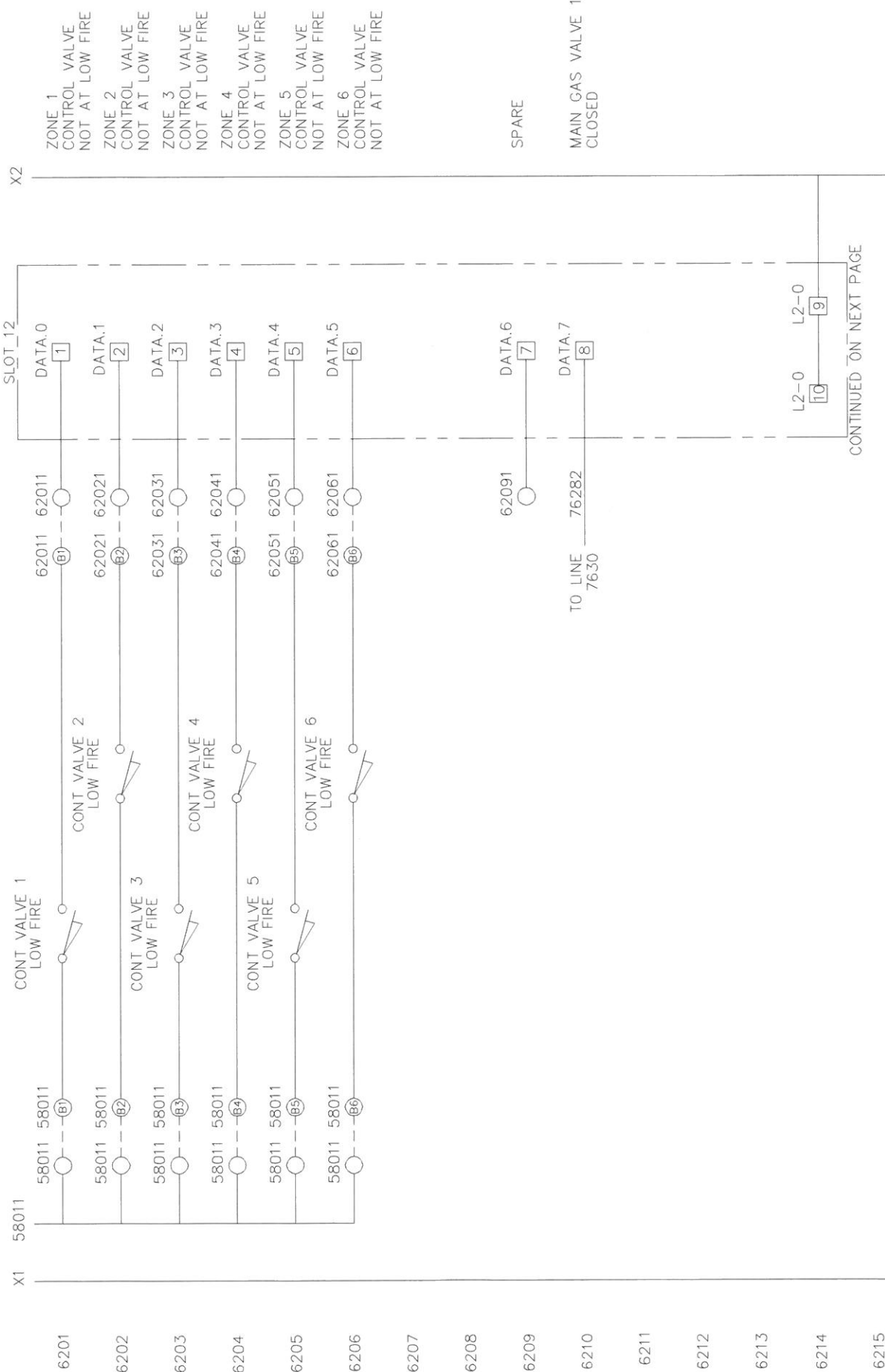
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(S.O.# 12845-2)
(US PET NUTRITION)

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SHEET TITLE
CONTROL SCHEMATIC

SHEET
31

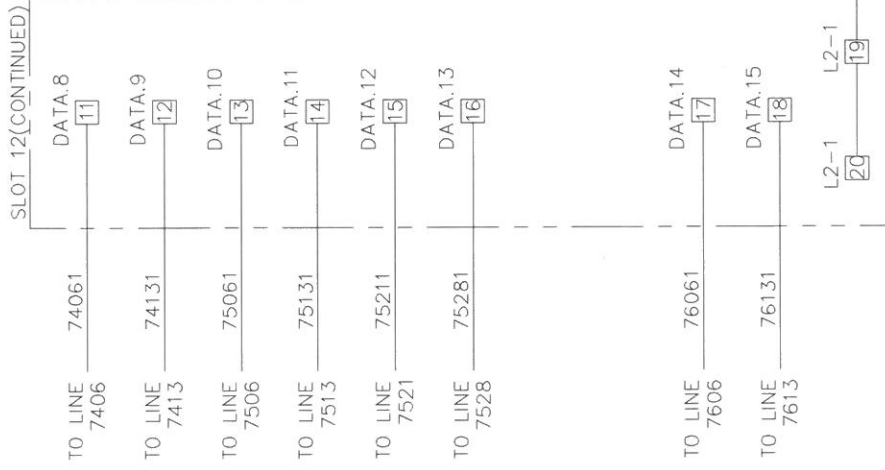
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X1

X2



ZONE 1
HIGH TEMP LIMIT

ZONE 2
HIGH TEMP LIMIT

ZONE 3
HIGH TEMP LIMIT

ZONE 4
HIGH TEMP LIMIT

ZONE 5
HIGH TEMP LIMIT

ZONE 6
HIGH TEMP LIMIT

EXHAUST 1 HIGH
TEMP LIMIT

EXHAUST 2 HIGH
TEMP LIMIT

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DWG NO.
12845103

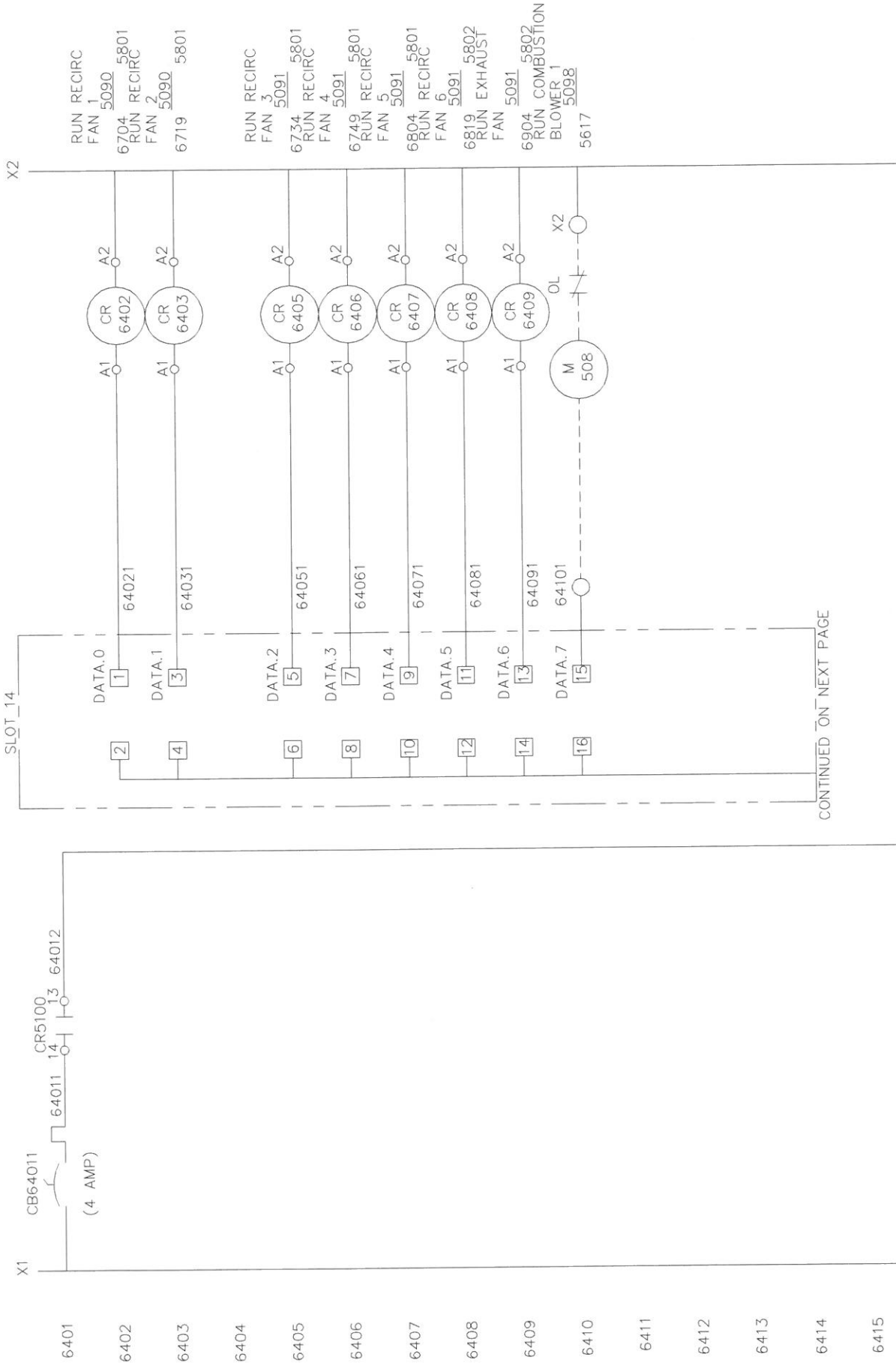
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DRYER, TRUE TEMP
(S.O.# 12845-2)
(US PET NUTRITION)

REV
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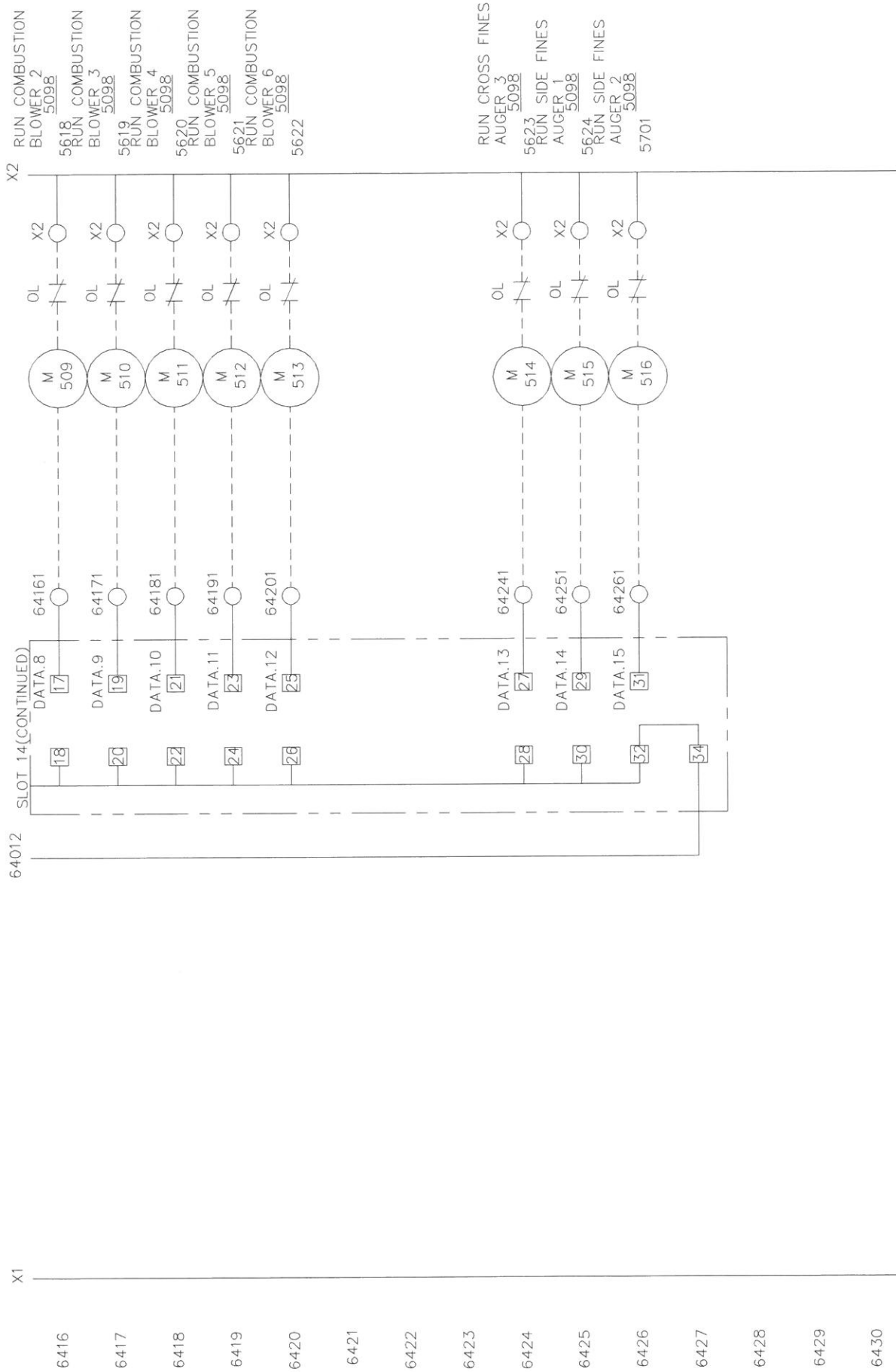
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CONTROL SCHEMATIC

SHEET
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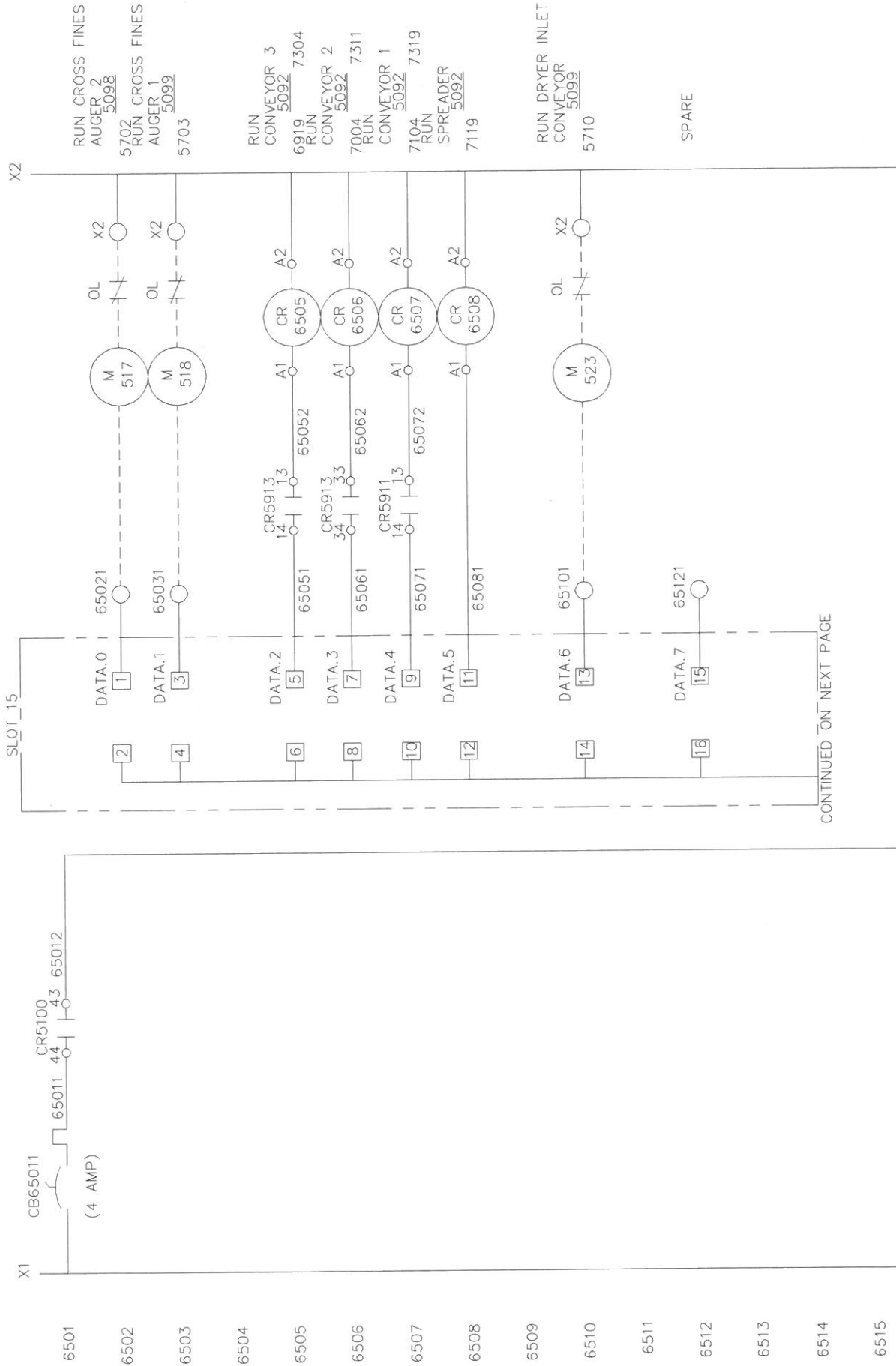
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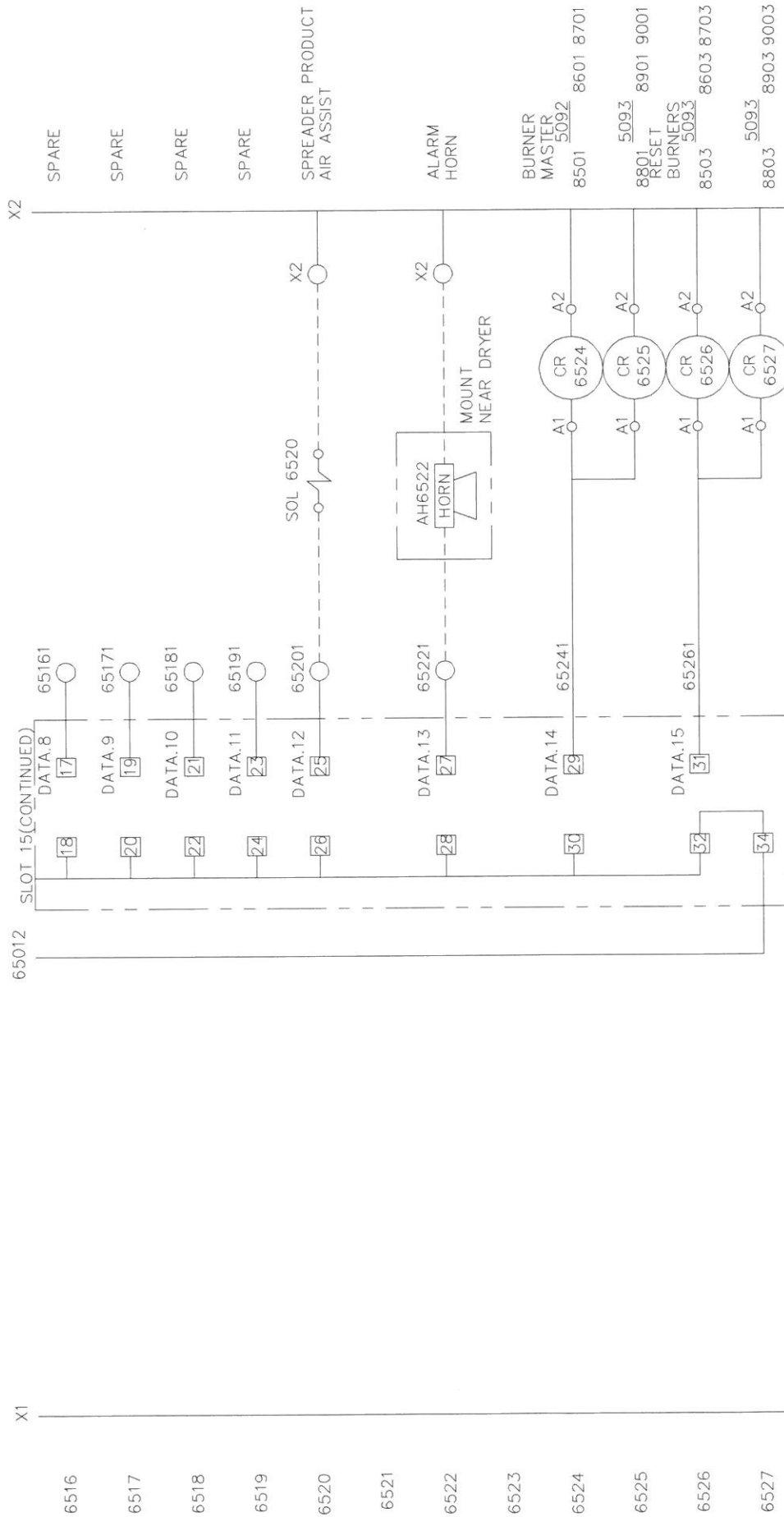
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TO LINE 7301

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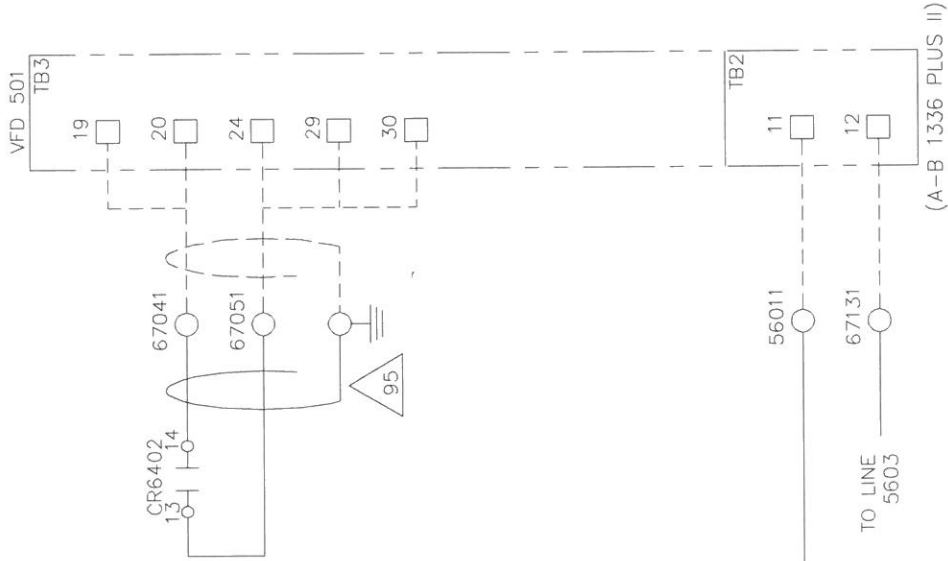
RECIRC FANS--CHANGE THE FOLLOWING FUNCTIONS TO THE VALUES SHOWN. ALL OTHER FUNCTIONS ARE TO REMAIN WITH THE FACTORY SETTINGS FOR ALLEN-BRADLEY 1336 PLUS II, VFD.

DESCRIPTION	UNITS	MOTOR
INPUT MODE	CODE	2 WIRE
FREQ. SELECT 1	CODE	ANALOG IN 0
MIN. FREQ.	Hz	30
MAX. FREQ.	Hz	60
OVERLOAD AMPS	AMPS	11
MOTOR NP RPM	RPM	1750
MOTOR NP HERTZ	Hz	60
MOTOR NP VOLTS	VOLTS	480
MOTOR NP AMPS	AMPS	11
DIRECTION MASK	CODE	00000001
START MASK	CODE	00000001
JOG MASK	CODE	20
ANALOG IN 0 LO	%	60
BASE FREQ.	Hz	480
BASE VOLTAGE	VOLTS	

SET JUMPER J8 TO 0-20wA (0-20wA OR POT) POSITION. (J8 IS INPUT 0)
SET JUMPER J13 TO POT (POT OR 0-20wA) POSITION. (J13 IS INPUT 1)

X2

RECIRC
FAN 1



WENGER®

DWG NO.
12845103

DWG. TITLE WIRING DIAGRAM -
DRYER, TRUE TEMP
(S.O.# 12845-2)
(US PET NUTRITION)

REV
NC

SHEET TITLE
CONTROL SCHEMATIC

SHEET
38

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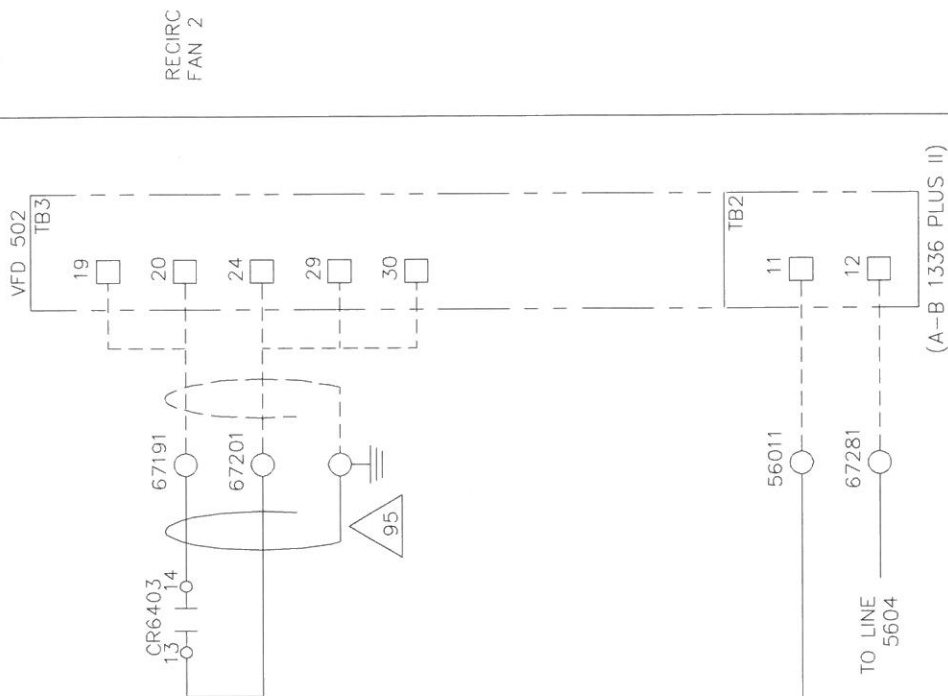
56011

RECIRC FANS--CHANGE THE FOLLOWING FUNCTIONS TO THE VALUES SHOWN. ALL OTHER FUNCTIONS ARE TO REMAIN WITH THE FACTORY SETTINGS FOR ALLEN-BRADLEY 1336 PLUS II, VFD.

DESCRIPTION	UNITS	MOTOR
INPUT MODE	CODE	2 WIRE
FREQ. SELECT 1	CODE	ANALOG IN 0
MIN. FREQ.	Hz	30
MAX. FREQ.	Hz	60
OVERLOAD AMPS	AMPS	11
MOTOR NP RPM	RPM	1750
MOTOR NP HERTZ	Hz	60
MOTOR NP VOLTS	VOLTS	480
MOTOR NP AMPS	AMPS	11
DIRECTION MASK	CODE	00000001
START MASK	CODE	00000001
JOG MASK	CODE	00000001
ANALOG IN 0 LO	%	20
BASE FREQ.	Hz	60
BASE VOLTAGE	VOLTS	480

SET JUMPER J8 TO 0-20mA (0-20mA OR POT) POSITION. (J8 IS INPUT 0)
SET JUMPER J13 TO POT (POT OR 0-20mA) POSITION. (J13 IS INPUT 1)

X2



RECIRC
FAN 2

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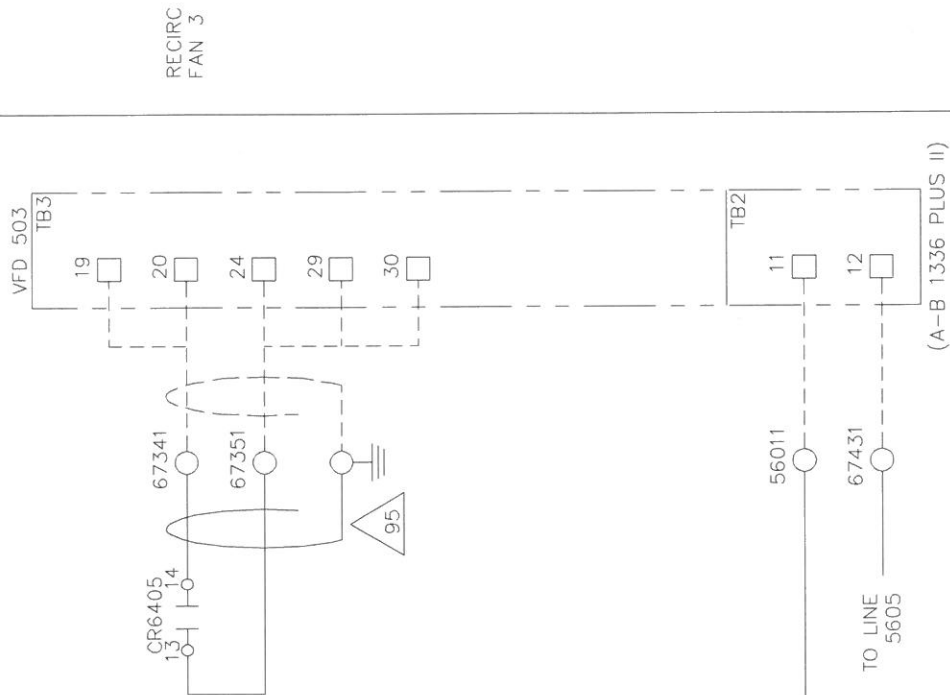
56011

RECIRC FANS--CHANGE THE FOLLOWING FUNCTIONS TO THE VALUES SHOWN. ALL OTHER FUNCTIONS ARE TO REMAIN WITH THE FACTORY SETTINGS FOR ALLEN-BRADLEY 1336 PLUS II, VFD.

DESCRIPTION	UNITS	MOTOR
INPUT MODE	CODE	2 WIRE
FREQ. SELECT 1	CODE	ANALOG IN 0
MIN. FREQ.	Hz	30
MAX. FREQ.	Hz	60
OVERLOAD AMPS	AMPS	11
MOTOR NP RPM	RPM	1750
MOTOR NP HERTZ	Hz	60
MOTOR NP VOLTS	VOLTS	480
MOTOR NP AMPS	AMPS	11
DIRECTION MASK	CODE	00000001
START MASK	CODE	00000001
JOG MASK	CODE	00000001
ANALOG IN 0 LO	%	20
BASE FREQ.	Hz	60
BASE VOLTAGE	VOLTS	480

SET JUMPER J8 TO 0-20mA (0-20mA OR POT) POSITION. (J8 IS INPUT 0)
SET JUMPER J13 TO POT (POT OR 0-20mA) POSITION. (J13 IS INPUT 1)

X2



RECIRC
FAN 3



WENGER®

DWG NO.
12845103

DWG. TITLE WIRING DIAGRAM-
DRYER, TRUE TEMP
(S.O.# 12845-2)
(US PET NUTRITION)

REV
NC

SHEET TITLE
CONTROL SCHEMATIC

SHEET
40

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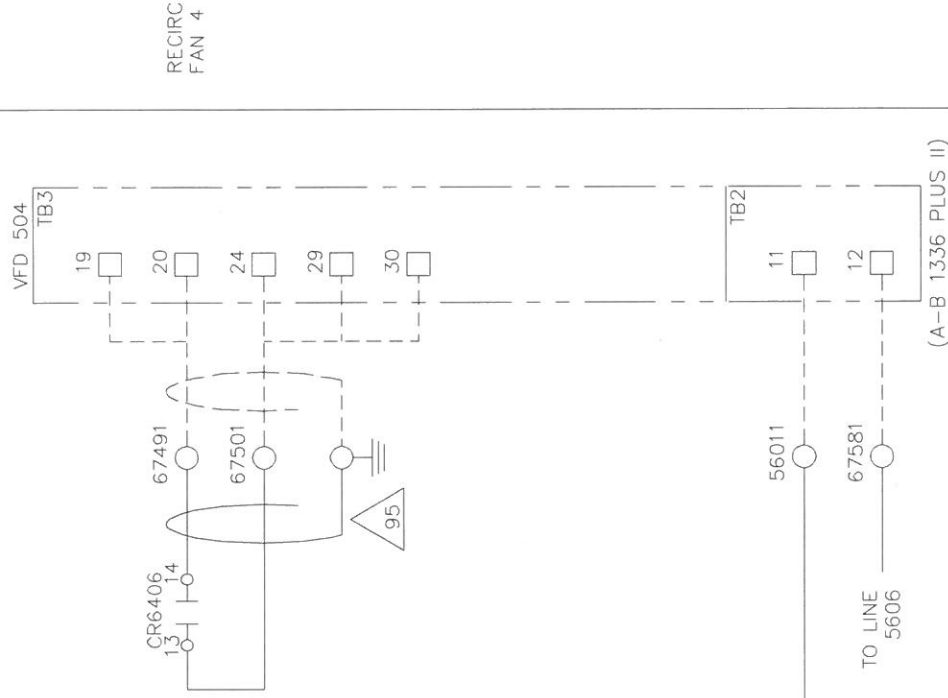
56011

X2

RECIRC FANS--CHANGE THE FOLLOWING FUNCTIONS TO THE VALUES SHOWN. ALL OTHER FUNCTIONS ARE TO REMAIN WITH THE FACTORY SETTINGS FOR ALLEN-BRADLEY 1336 PLUS II, VFD.

DESCRIPTION	UNITS	MOTOR
INPUT MODE	CODE	2 WIRE
FREQ. SELECT 1	CODE	ANALOG IN 0
MIN. FREQ.	Hz	30
MAX. FREQ.	Hz	60
OVERLOAD AMPS	AMPS	11
MOTOR NP RPM	RPM	1750
MOTOR NP HERTZ	Hz	60
MOTOR NP VOLTS	VOLTS	480
MOTOR NP AMPS	AMPS	11
DIRECTION MASK	CODE	00000001
START MASK	CODE	00000001
JOG MASK	CODE	00000001
ANALOG IN 0 LO	%	20
BASE FREQ.	Hz	60
BASE VOLTAGE	VOLTS	480

SET JUMPER J8 TO 0-20mA (0-20mA OR POT) POSITION. (J8 IS INPUT 0)
SET JUMPER J13 TO POT (POT OR 0-20mA) POSITION. (J13 IS INPUT 1)



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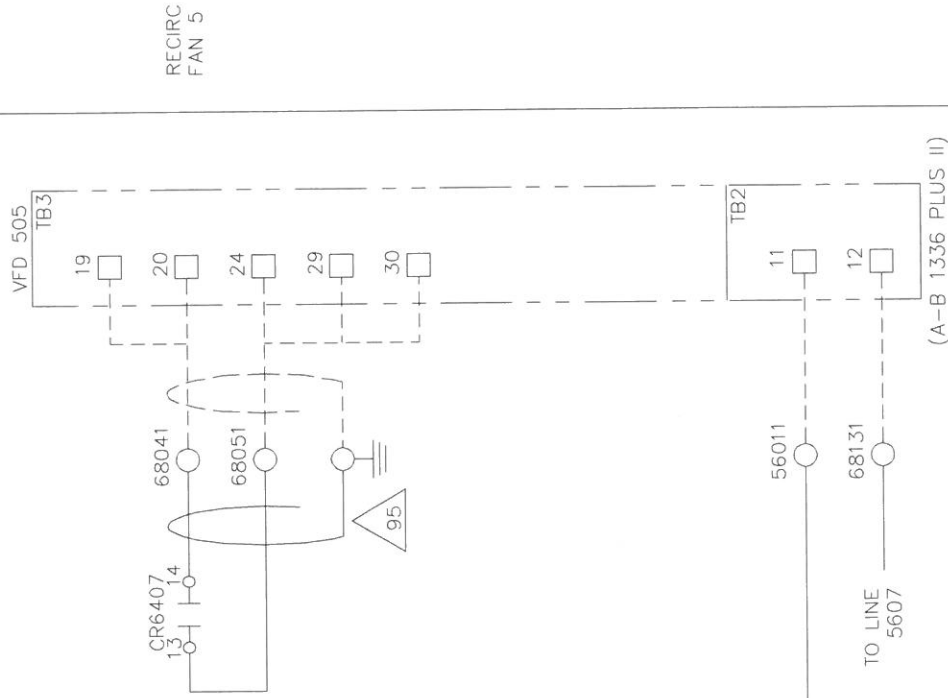
56011

RECIRC FANS--CHANGE THE FOLLOWING FUNCTIONS TO THE VALUES SHOWN. ALL OTHER FUNCTIONS ARE TO REMAIN WITH THE FACTORY SETTINGS FOR ALLEN-BRADLEY 1336 PLUS II, VFD.

DESCRIPTION	UNITS	MOTOR
INPUT MODE	CODE	2 WIRE
FREQ. SELECT 1	CODE	ANALOG IN 0
MIN. FREQ.	Hz	30
MAX. FREQ.	Hz	60
OVERLOAD AMPS	AMPS	11
MOTOR NP RPM	RPM	1750
MOTOR NP HERTZ	Hz	60
MOTOR NP VOLTS	VOLTS	480
MOTOR NP AMPS	AMPS	11
DIRECTION MASK	CODE	00000001
START MASK	CODE	00000001
JOG MASK	CODE	00000001
ANALOG IN 0 LO	%	20
BASE FREQ.	Hz	60
BASE VOLTAGE	VOLTS	480

SET JUMPER J8 TO 0-20mA (0-20mA OR POT) POSITION. (J8 IS INPUT 0)
SET JUMPER J13 TO POT (POT OR 0-20mA) POSITION. (J13 IS INPUT 1)

X2



RECIRC
FAN 5

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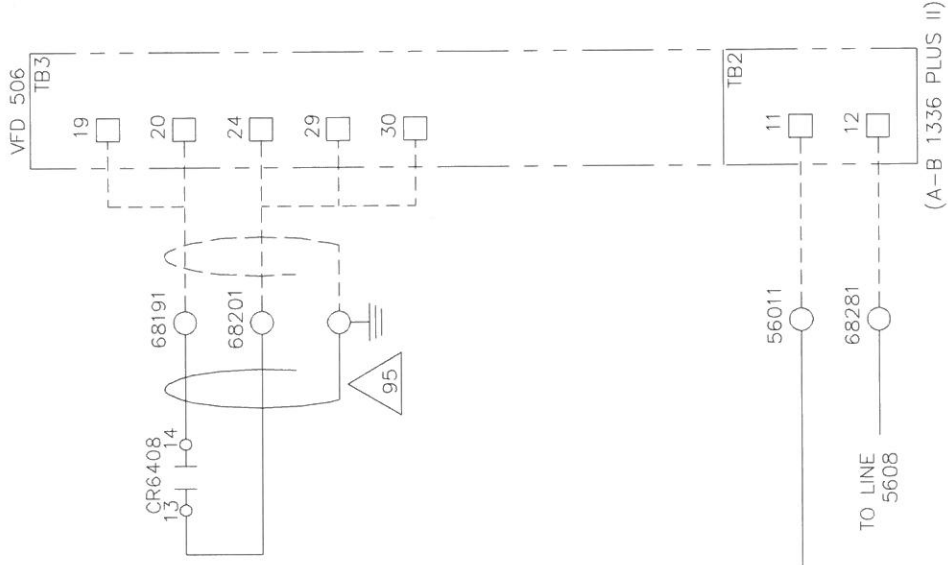
X2

RECIRC FANS--CHANGE THE FOLLOWING FUNCTIONS TO THE VALUES SHOWN. ALL OTHER FUNCTIONS ARE TO REMAIN WITH THE FACTORY SETTINGS FOR ALLEN-BRADLEY 1336 PLUS II, VFD.

DESCRIPTION	UNITS	MOTOR
INPUT MODE	CODE	2 WIRE
FREQ. SELECT 1	CODE	ANALOG IN 0
MIN. FREQ.	Hz	30
MAX. FREQ.	Hz	60
OVERLOAD AMPS	AMPS	11
MOTOR NP RPM	RPM	1750
MOTOR NP HERTZ	Hz	60
MOTOR NP VOLTS	VOLTS	480
MOTOR NP AMPS	AMPS	11
DIRECTION MASK	CODE	00000001
START MASK	CODE	00000001
JOG MASK	CODE	00000001
ANALOG IN 0 LO	%	20
BASE FREQ.	Hz	60
BASE VOLTAGE	VOLTS	480

SET JUMPER J8 TO 0-20mA (0-20mA OR POT) POSITION. (J8 IS INPUT 0)
 SET JUMPER J13 TO POT (POT OR 0-20mA) POSITION. (J13 IS INPUT 1)

RECIRC
FAN 6



56011

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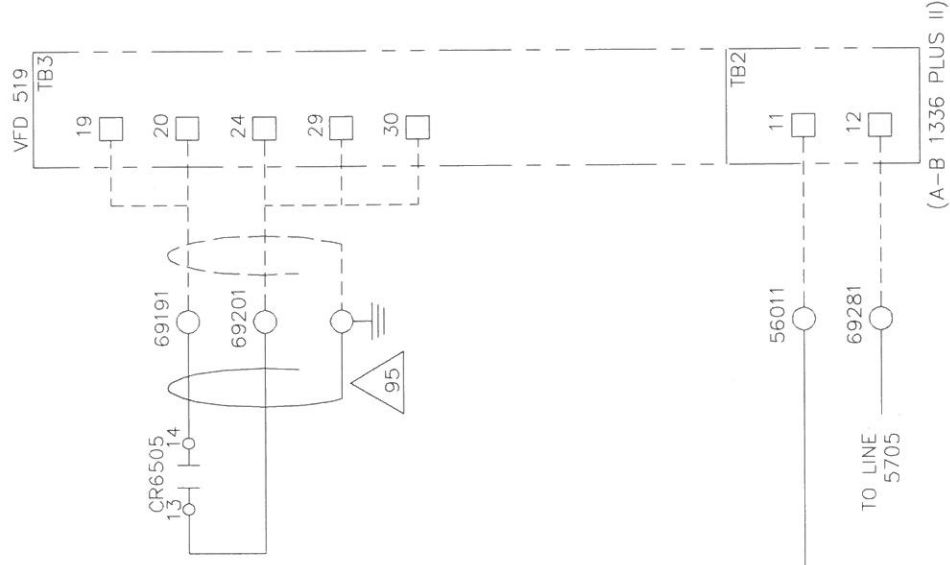
CONVEYORS--CHANGE THE FOLLOWING FUNCTIONS TO THE VALUES SHOWN. ALL OTHER FUNCTIONS ARE TO REMAIN WITH THE FACTORY SETTINGS FOR ALLEN-BRADLEY 1336 PLUS II, VFD.

DESCRIPTION	UNITS	MOTOR
INPUT MODE	CODE	2 WIRE
FREQ. SELECT 1	CODE	ANALOG IN 0 (J8)
MIN. FREQ.	Hz	15
MAX. FREQ.	Hz	120
OVERLOAD AMPS	AMPS	1.8
MOTOR NP RPM	RPM	1750
MOTOR NP HERTZ	Hz	60
MOTOR NP VOLTS	VOLTS	480
MOTOR NP AMPS	AMPS	1.8
DIRECTION MASK	CODE	00000001
START MASK	CODE	00000001
JOG MASK	CODE	00000001
ANALOG IN 0 LO	%	20
BASE FREQ.	Hz	60
BASE VOLTAGE	VOLTS	480

SET JUMPER J8 TO 0-20mA (0-20mA OR POT) POSITION. (J8 IS INPUT 0)
SET JUMPER J13 TO POT (POT OR 0-20mA) POSITION. (J13 IS INPUT 1)

X2

CONVEYOR 3



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56011

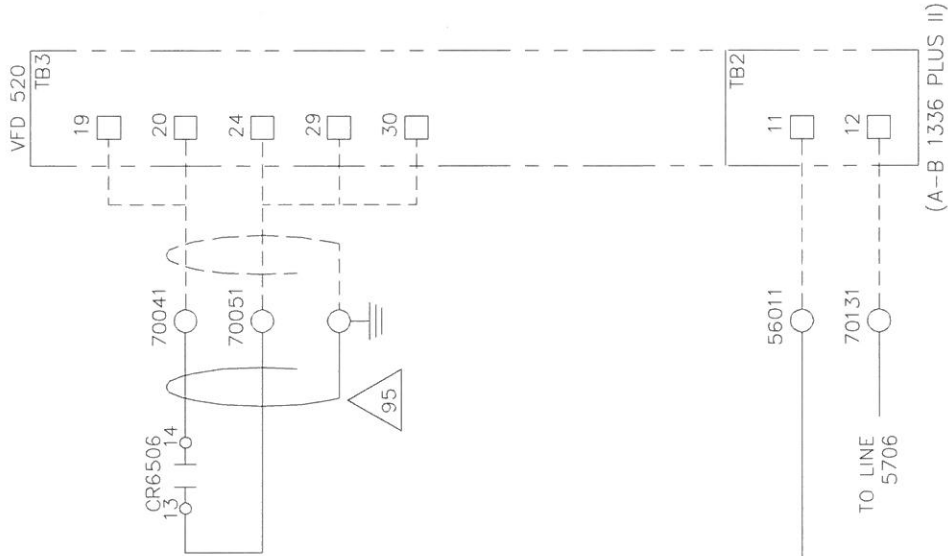
CONVEYORS--CHANG THE FOLLOWING FUNCTIONS TO THE VALUES SHOWN. ALL OTHER FUNCTIONS ARE TO REMAIN WITH THE FACTORY SETTINGS FOR ALLEN-BRADLEY 1336 PLUS II, VFD.

DESCRIPTION	UNITS	MOTOR
INPUT MODE	CODE	2 WIRE
FREQ. SELECT 1	CODE	ANALOG IN 0 (J8)
MIN. FREQ.	HZ	15
MAX. FREQ.	HZ	120
OVERLOAD AMPS	AMPS	1.8
MOTOR NP RPM	RPM	1750
MOTOR NP HERTZ	HZ	60
MOTOR NP VOLTS	VOLTS	480
MOTOR NP AMPS	AMPS	1.8
DIRECTION MASK	CODE	00000001
START MASK	CODE	00000001
JOG MASK	CODE	00000001
ANALOG IN 0 LO	%	20
BASE FREQ.	HZ	60
BASE VOLTAGE	VOLTS	480

SET JUMPER J8 TO 0-20mA (0-20mA OR POT) POSITION. (J8 IS INPUT 0)
SET JUMPER J13 TO POT (POT OR 0-20mA) POSITION. (J13 IS INPUT 1)

X2

CONVEYOR 2



WENGER®

DWG NO.
12845103

DWG. TITLE WIRING DIAGRAM -
DRYER, TRUE TEMP
(S.O.# 12845-2)
(US PET NUTRITION)

REV
NC

SHEET TITLE
CONTROL SCHEMATIC

SHEET
46

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56011

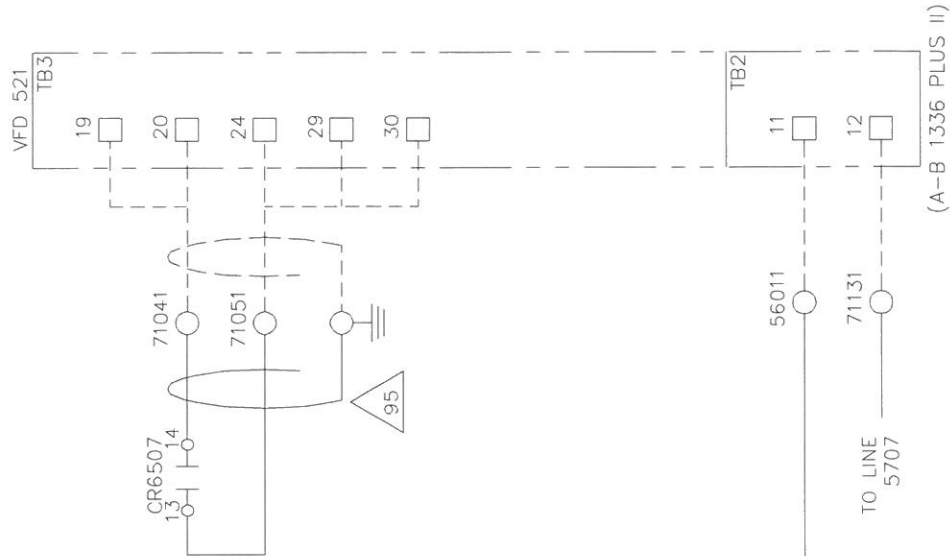
X2

CONVEYORS--CHANGE THE FOLLOWING FUNCTIONS TO THE VALUES SHOWN. ALL OTHER FUNCTIONS ARE TO REMAIN WITH THE FACTORY SETTINGS FOR ALLEN-BRADLEY 1336 PLUS II, VFD.

DESCRIPTION	UNITS	MOTOR
INPUT MODE	CODE	2 WIRE
FREQ. SELECT 1	CODE	ANALOG IN 0 (J8)
MIN. FREQ.	HZ	15
MAX. FREQ.	HZ	120
OVERLOAD AMPS	AMPS	1.8
MOTOR NP RPM	RPM	1750
MOTOR NP HERTZ	HZ	60
MOTOR NP VOLTS	VOLTS	480
MOTOR NP AMPS	AMPS	1.8
DIRECTION MASK	CODE	00000001
START MASK	CODE	00000001
JOG MASK	CODE	00000001
ANALOG IN 0 LO	%	20
BASE FREQ.	HZ	60
BASE VOLTAGE	VOLTS	480

SET JUMPER J8 TO 0-20mA (0-20mA OR POT) POSITION. (J8 IS INPUT 0)
SET JUMPER J13 TO POT (POT OR 0-20mA) POSITION. (J13 IS INPUT 1)

CONVEYOR 1



7101

7102

7103

7104

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7106

7107

7108

7109

7110

7111

7112

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7114

7115

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ALTIVAR 71, VARIABLE FREQUENCY DRIVE
PARAMETERS HAVE BEEN PROGRAMMED WITH THE FOLLOWING VALUES.
OTHER PARAMETERS HAVE BEEN LEFT WITH THE DEFAULT VALUES.

PARAMETER	SETTING	UNITS
ACCESS LEVEL	EXPERT	
DRIVE MENU		
SIMPLY START		
2/3 WIRE CONTROL		
MACRO CONFIGURATION		
STD MOTOR FREQ.	60	HZ
RATED MOTOR POWER	.75	HP
RATED MOTOR VOLT.	460	VOLTS
RATED MOTOR CURRENT	1.4	AMPS
RATED MOTOR FREQ.	60	HZ
RATED MOTOR SPEED	1750	RPM
MAX. FREQUENCY	120.0	HZ
AUTO TUNING	YES	
MOTOR THERMAL CURRENT	1.4	AMPS
ACCELERATION	6.5	SEC
DECELERATION	2.5	SEC
LOW SPEED	6.0	HZ
HIGH SPEED	120.0	HZ

INPUTS/OUTPUTS CFG.
REFERENCE TEMPLATE

A12 CONFIGURATION
A12 TYPE

A12 MIN. VALUE
A12 MAX. VALUE

R1 CONFIGURATION
R1 ASSIGNMENT

A01 CONFIGURATION
A01 ASSIGNMENT

A01 TYPE
A01 MIN. OUTPUT

A01 MAX. OUTPUT
COMMAND

REF. 1 CHANNEL
APPLICATION FUNCT.

STOP CONFIGURATION
TYPE OF STOP

FAULT MANAGEMENT
CATCH ON THE FLY

OUTPUT PHASE LOSS
FREE WHEEL

YES
NO

AI1

MOTOR FREQ.
VOLTAGE

0.0
10.0

DRIVE RUNNING
VOLTAGE

0.0
10.0

STANDARD
VOLTAGE

0.0
10.0

AI1
AI1+

AI1-
COM

R1A
R1C

TO LINE
5708

71281
7128

(ALTIVAR 71)

X2

7116

7117

7118

7119

7120

7121

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7123

7124

7125

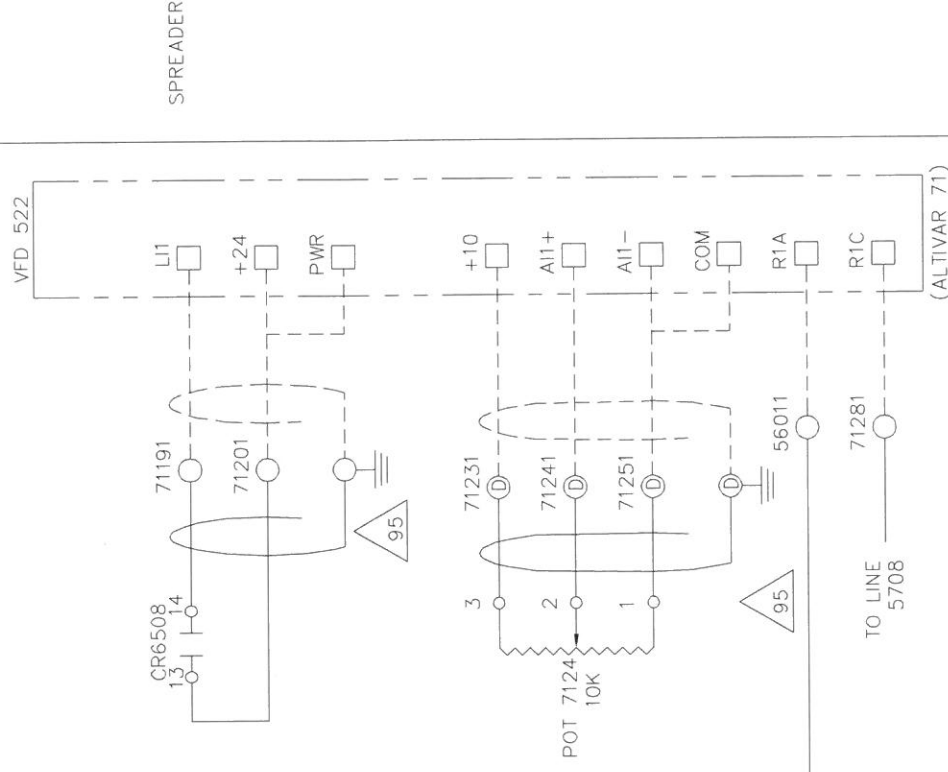
7126

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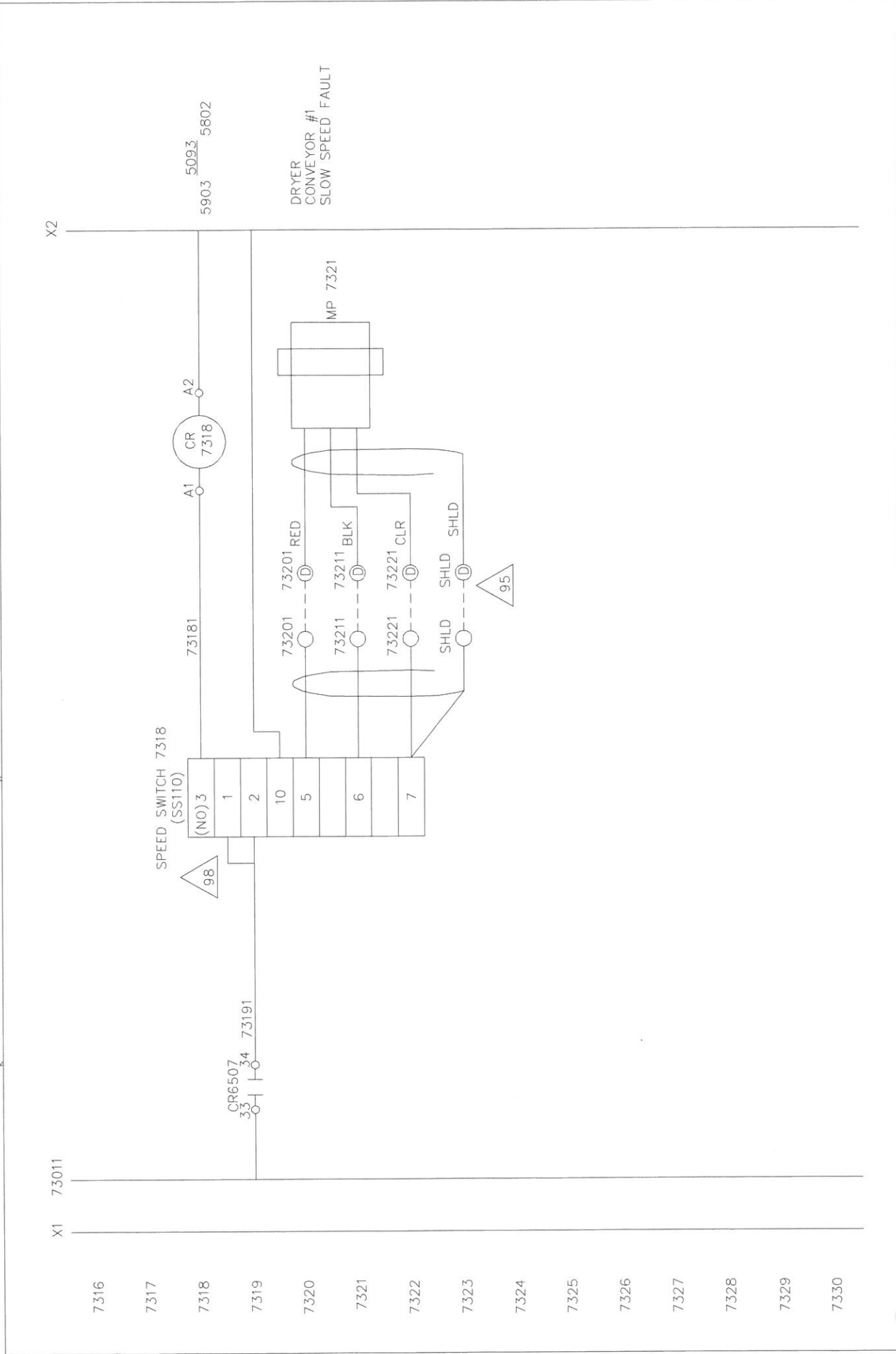
DRYER CONVEYOR #3 SLOW SPEED FAULT

5901 5093 5802

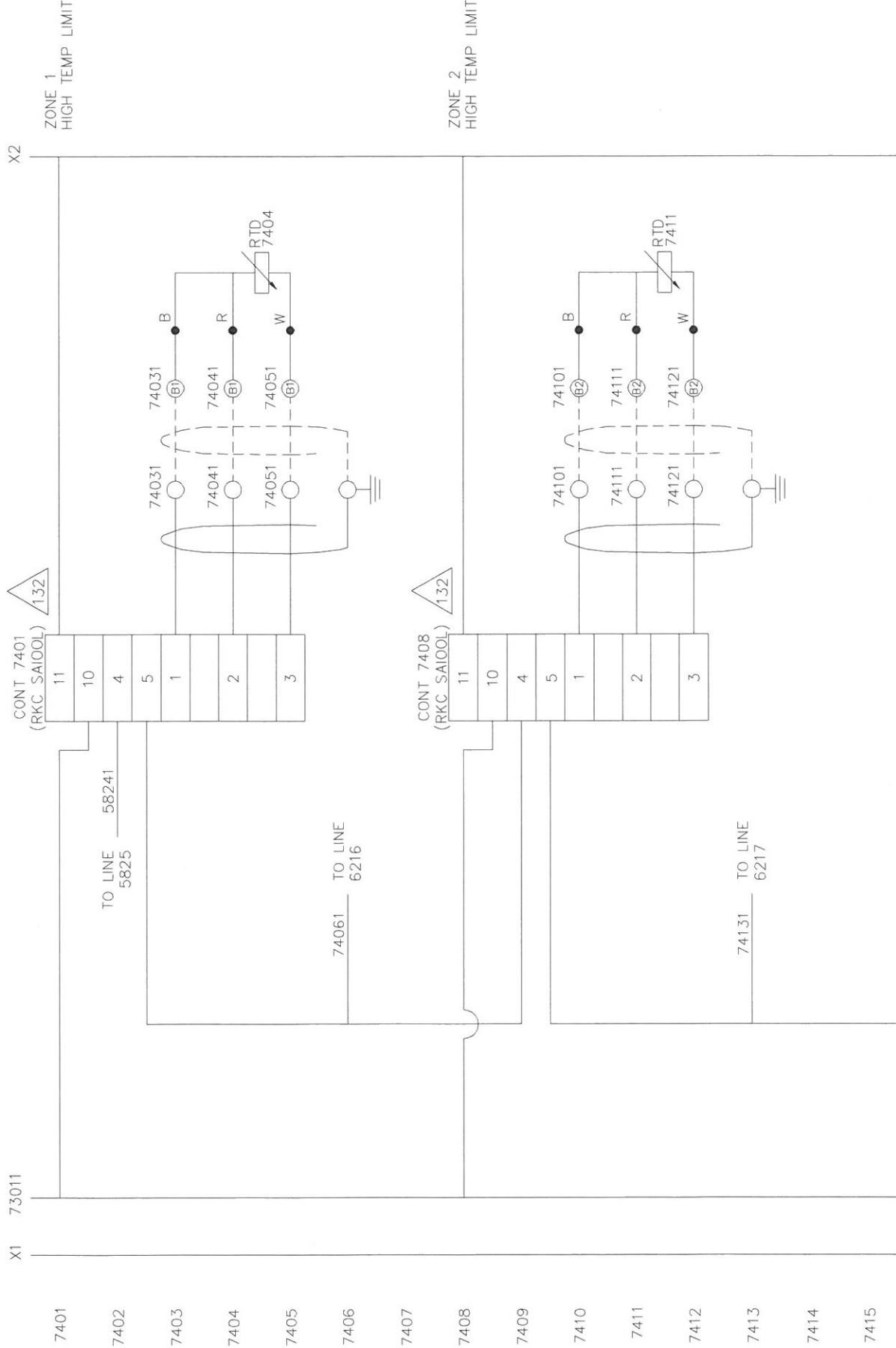
5902 5093 5802

DRYER CONVEYOR #2 SLOW SPEED FAULT

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DWG NO.
12845103

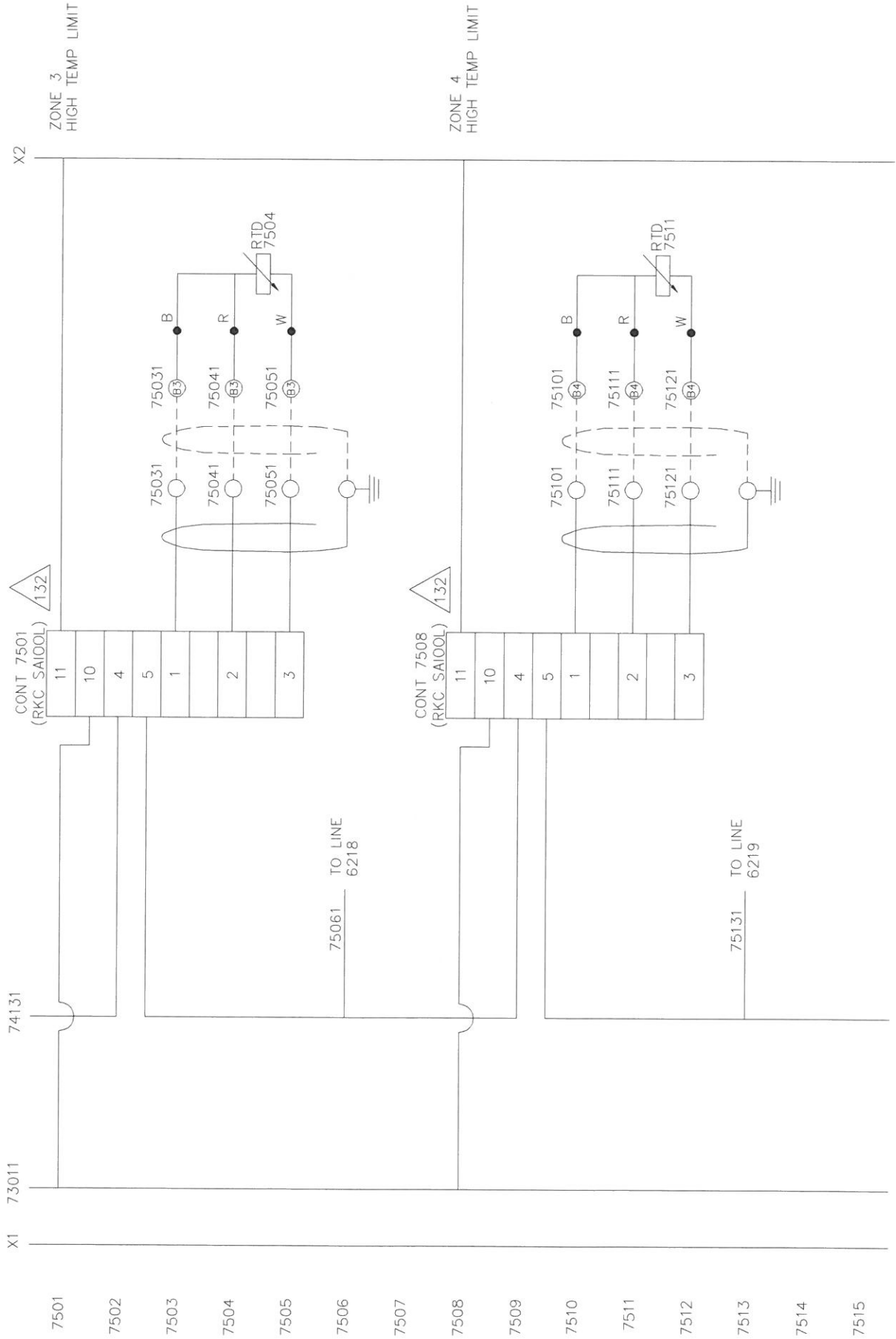
DWG. TITLE
WIRING DIAGRAM -
DRYER, TRUE TEMP
(S.O.# 12845-2) (ON)

REV
NC

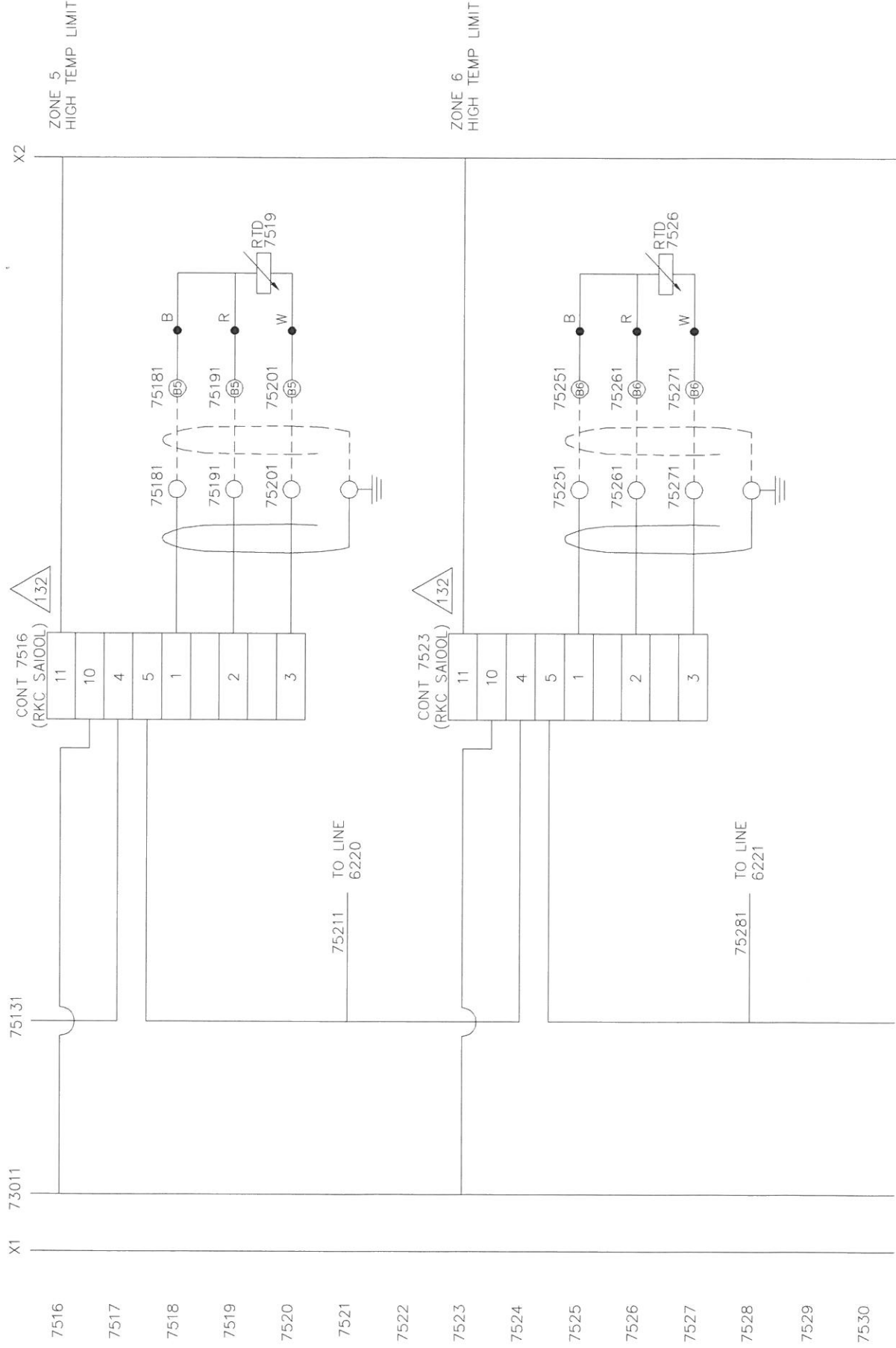
SHEET TITLE
CONTROL SCHEMATIC

SHEET
51

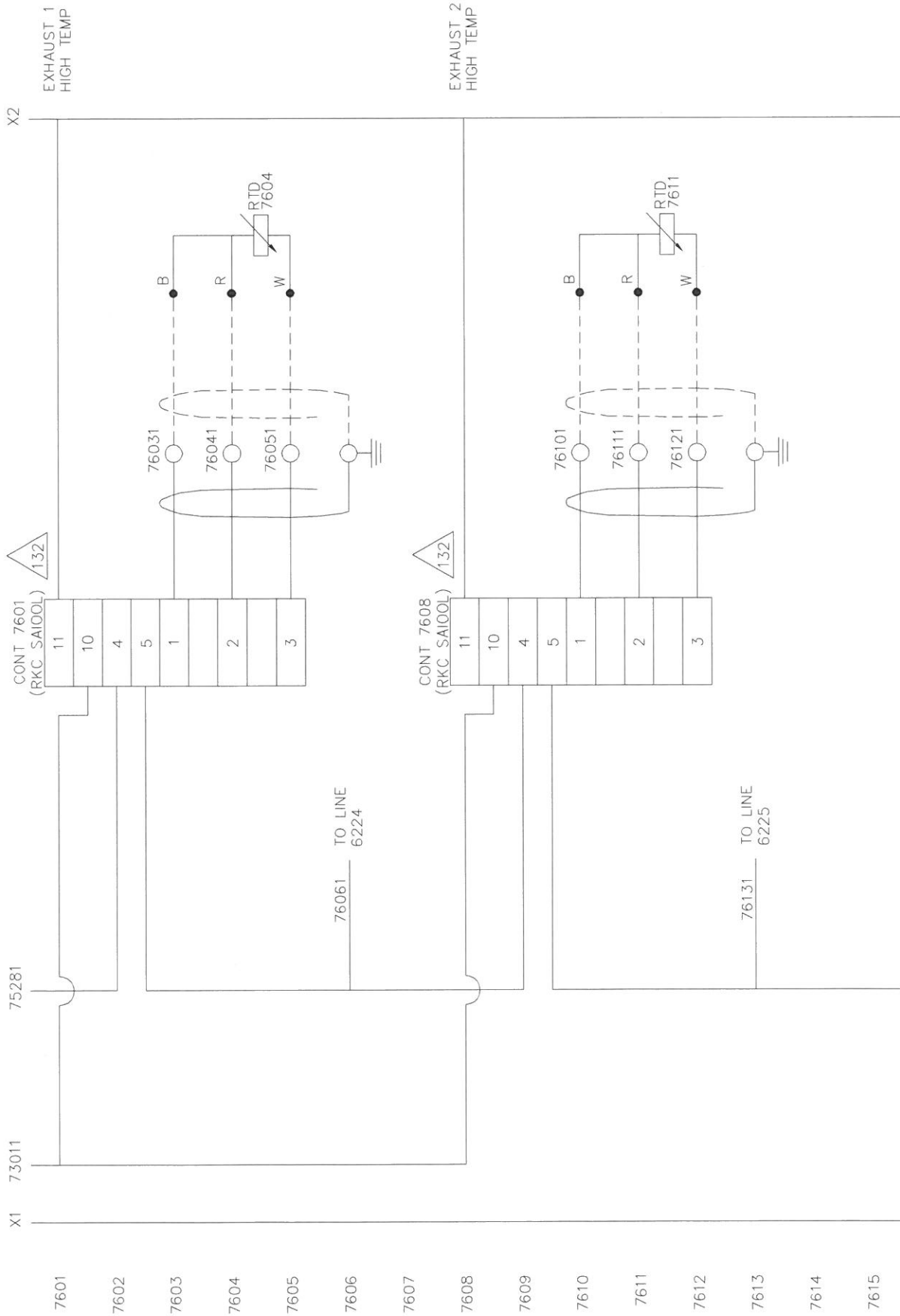
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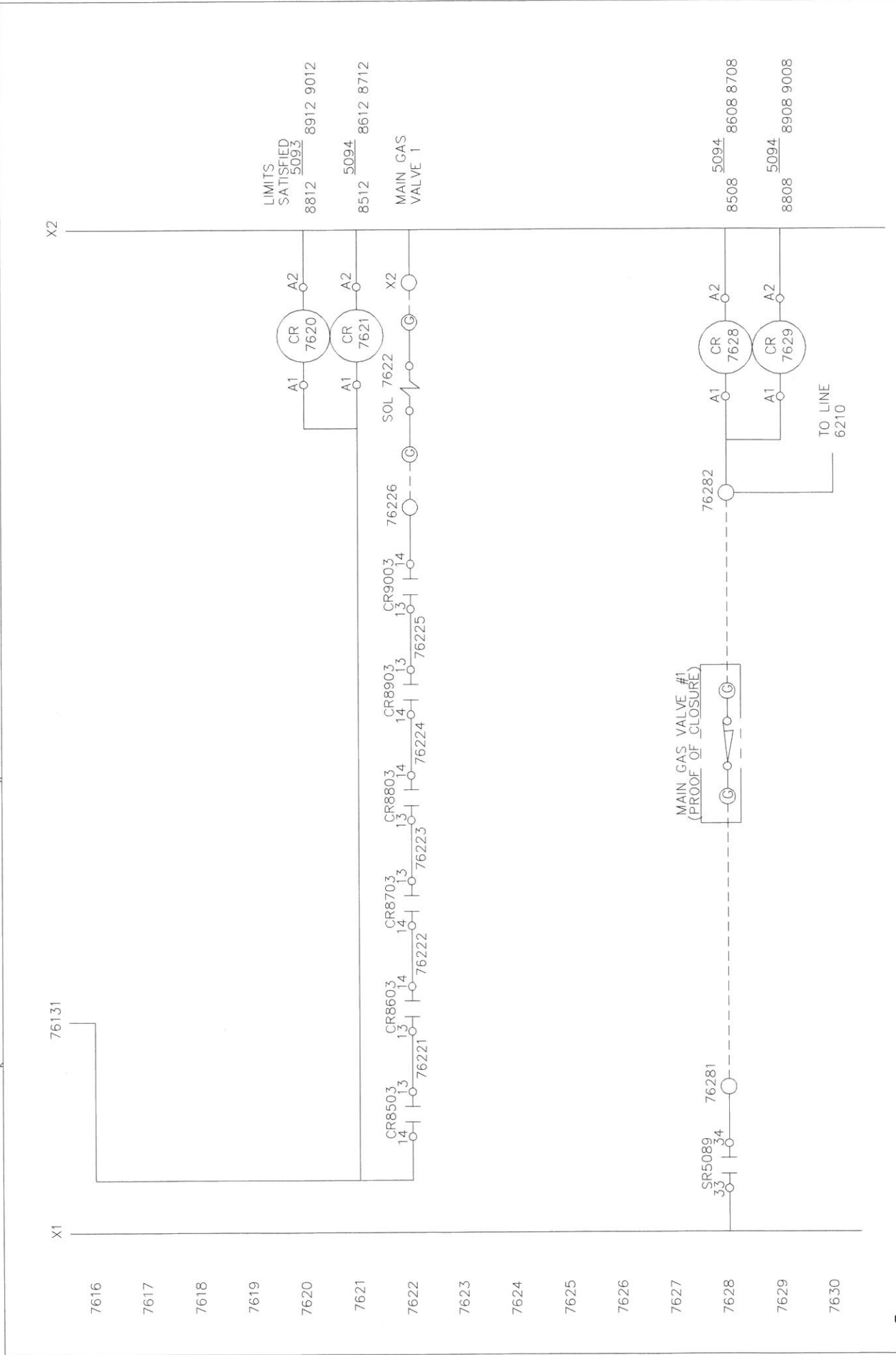


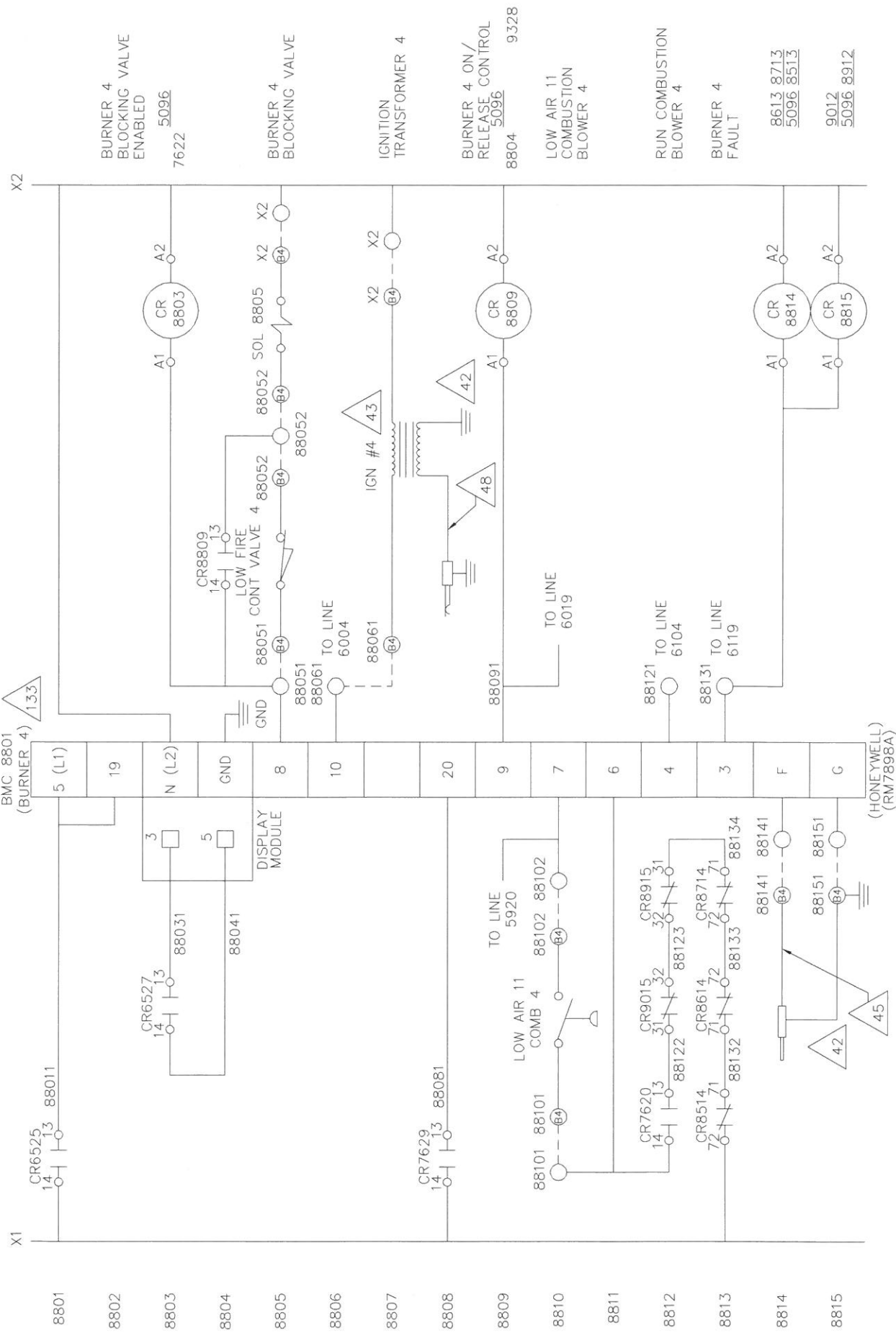
Diagram 1: Burner 1 Control Circuit. This schematic illustrates the electrical control system for Burner 1. It shows the connection between the burner's control terminals (X1, X2) and the main power supply (L1, L2, GND). Key components include the Burner 1 Enabled signal (7622), Burner 1 Blocking Valve (5094), Ignition Transformer 1 (5094), Burner 1 On/Release Control (5094), Low Air 8 Combustion Blower 1 (9305), Run Combustion Blower 1 (8813), Burner 1 Fault (8613), and Burner 1 (8913). The diagram also shows the connection to the Honeywell (RM7898A) gas valve (45) and the Honeywell (RM7898A) gas valve (45). The circuit includes various relays (CR8503, CR8509, CR8514, CR8515) and solenoids (SOL 8505) that manage the flow of gas and the operation of the burner and blower.

Diagram 1: Wiring diagram for the engine control system, showing the connection of the engine control unit (ECU) to the engine components. The ECU is connected to the engine control unit (ECU) via a series of relays and switches. The diagram includes the following components and connections:

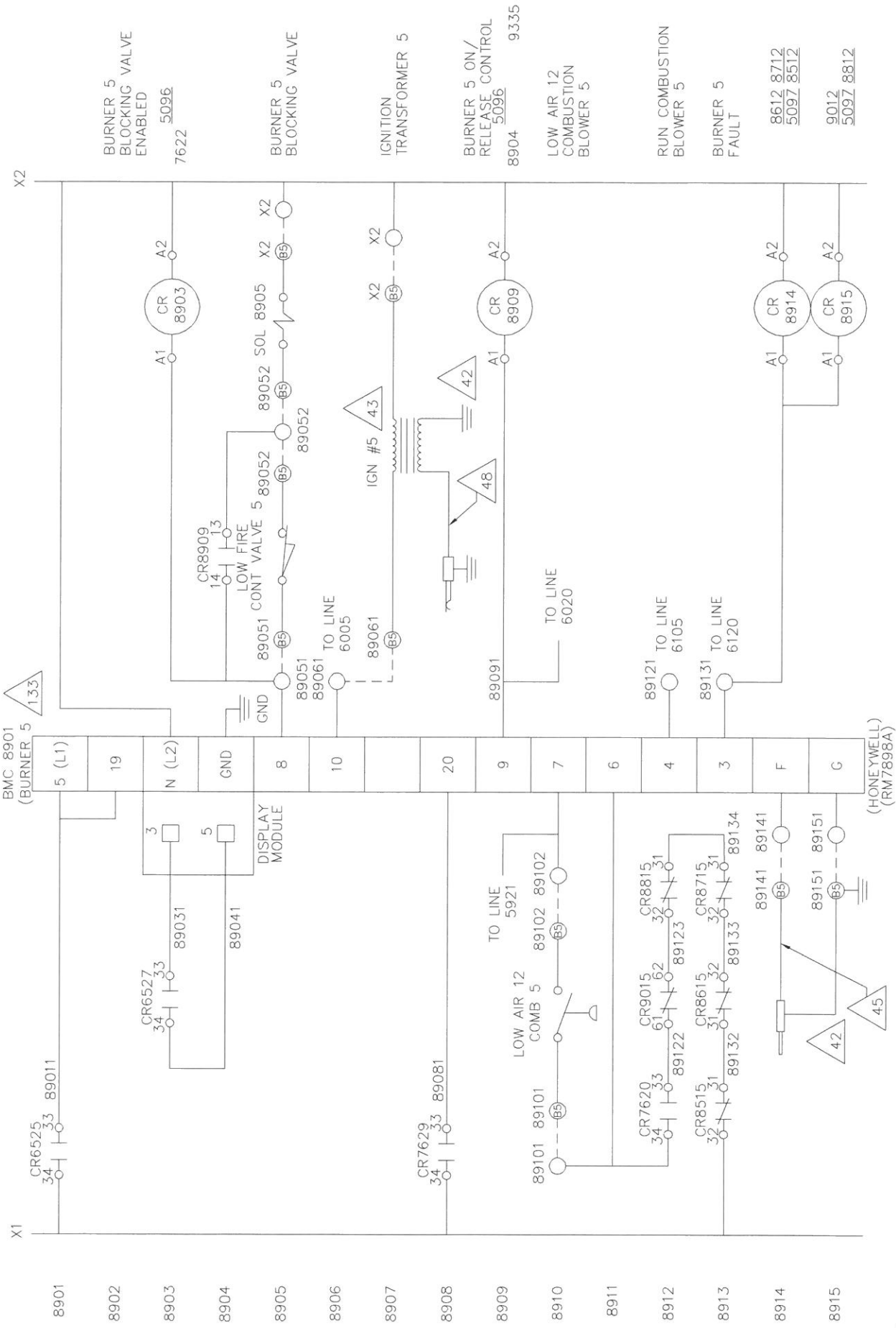
- ECU (Engine Control Unit):** The central control unit, connected to the engine control unit (ECU) via a series of relays and switches.
- Engine Control Unit (ECU):** The central control unit, connected to the engine control unit (ECU) via a series of relays and switches.
- Engine Components:** The engine control unit (ECU) is connected to the engine control unit (ECU) via a series of relays and switches.
- Wiring Diagram:** The diagram shows the connection of the engine control unit (ECU) to the engine control unit (ECU) via a series of relays and switches.

Diagram 1: Wiring diagram for the burner control system, showing the connection between the burner control unit (X1) and the burner control unit (X2). The diagram includes components such as the burner control unit (X1), burner control unit (X2), burner control unit (X3), burner control unit (X4), burner control unit (X5), burner control unit (X6), burner control unit (X7), burner control unit (X8), burner control unit (X9), burner control unit (X10), burner control unit (X11), burner control unit (X12), burner control unit (X13), burner control unit (X14), burner control unit (X15), burner control unit (X16), burner control unit (X17), burner control unit (X18), burner control unit (X19), burner control unit (X20), burner control unit (X21), burner control unit (X22), burner control unit (X23), burner control unit (X24), burner control unit (X25), burner control unit (X26), burner control unit (X27), burner control unit (X28), burner control unit (X29), burner control unit (X30), burner control unit (X31), burner control unit (X32), burner control unit (X33), burner control unit (X34), burner control unit (X35), burner control unit (X36), burner control unit (X37), burner control unit (X38), burner control unit (X39), burner control unit (X40), burner control unit (X41), burner control unit (X42), burner control unit (X43), burner control unit (X44), burner control unit (X45), burner control unit (X46), burner control unit (X47), burner control unit (X48), burner control unit (X49), burner control unit (X50), burner control unit (X51), burner control unit (X52), burner control unit (X53), burner control unit (X54), burner control unit (X55), burner control unit (X56), burner control unit (X57), burner control unit (X58), burner control unit (X59), burner control unit (X60), burner control unit (X61), burner control unit (X62), burner control unit (X63), burner control unit (X64), burner control unit (X65), burner control unit (X66), burner control unit (X67), burner control unit (X68), burner control unit (X69), burner control unit (X70), burner control unit (X71), burner control unit (X72), burner control unit (X73), burner control unit (X74), burner control unit (X75), burner control unit (X76), burner control unit (X77), burner control unit (X78), burner control unit (X79), burner control unit (X80), burner control unit (X81), burner control unit (X82), burner control unit (X83), burner control unit (X84), burner control unit (X85), burner control unit (X86), burner control unit (X87), burner control unit (X88), burner control unit (X89), burner control unit (X90), burner control unit (X91), burner control unit (X92), burner control unit (X93), burner control unit (X94), burner control unit (X95), burner control unit (X96), burner control unit (X97), burner control unit (X98), burner control unit (X99), burner control unit (X100).

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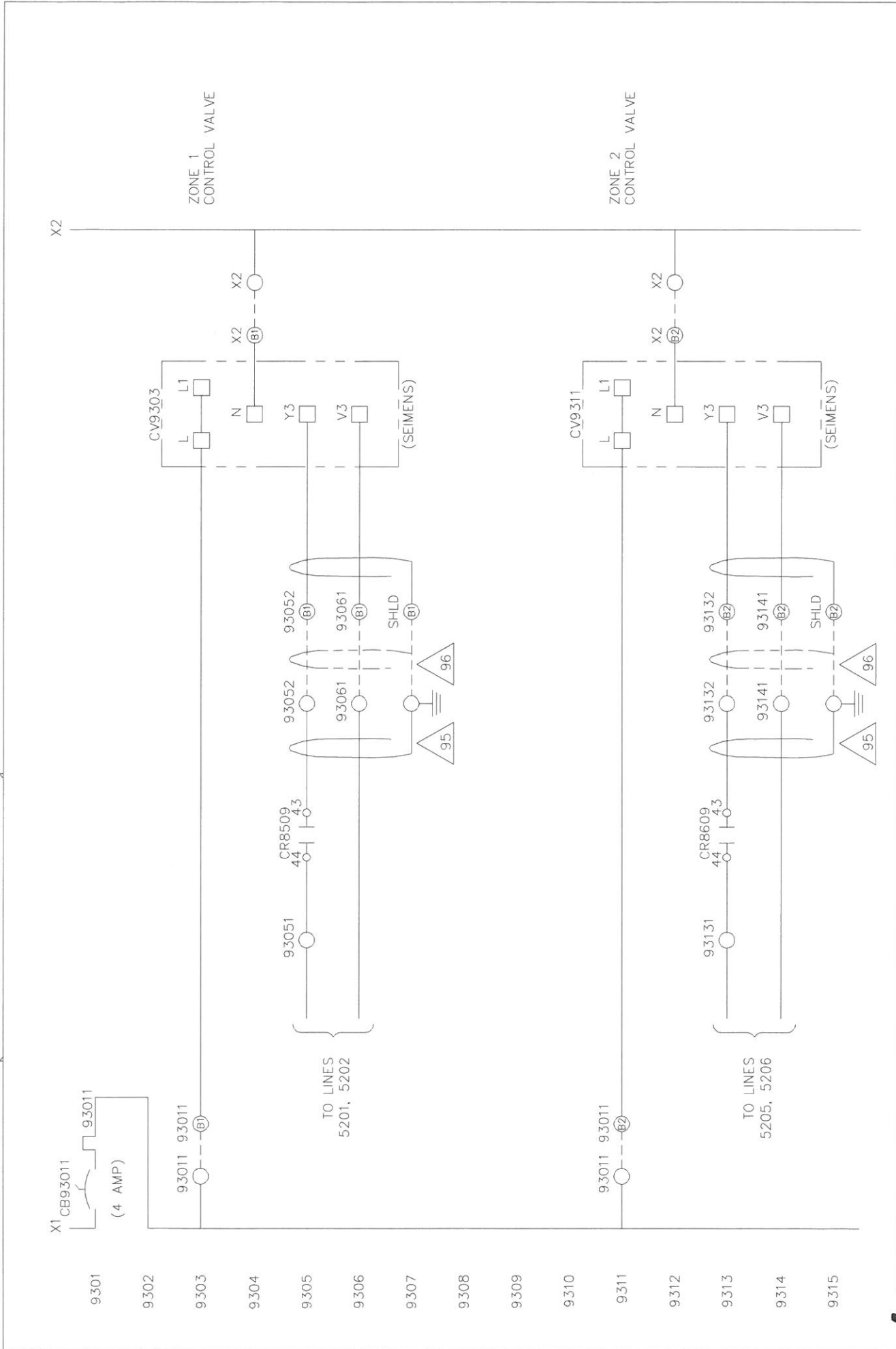


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[illegible]

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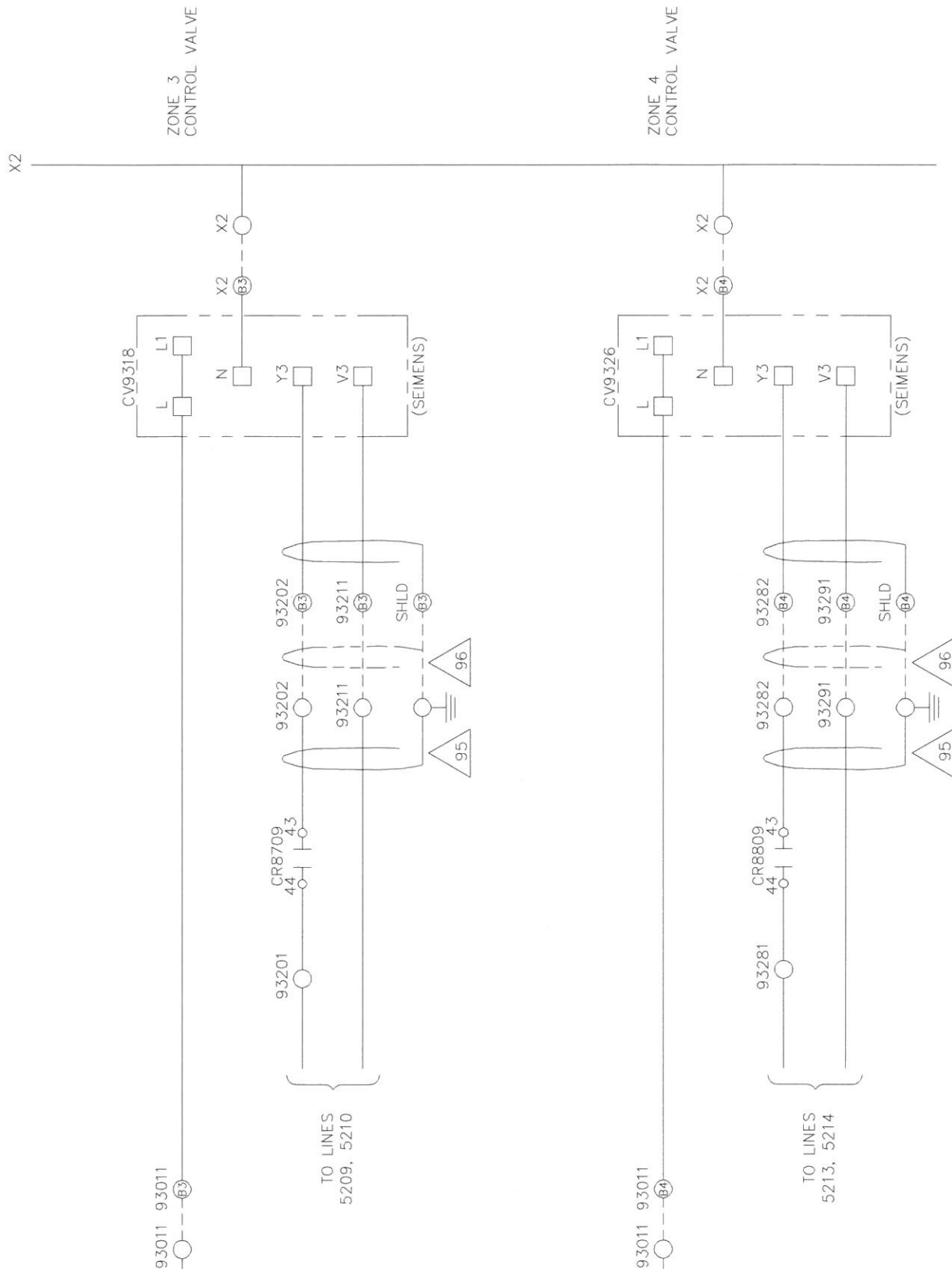
9626

9327

9328

0620

0220



ZONE 3
CONTROL VALVE

ZONE 4
CONTROL VALVE

TO LINES
5209. 5210

TO LINES
5213 5214

93011

9331

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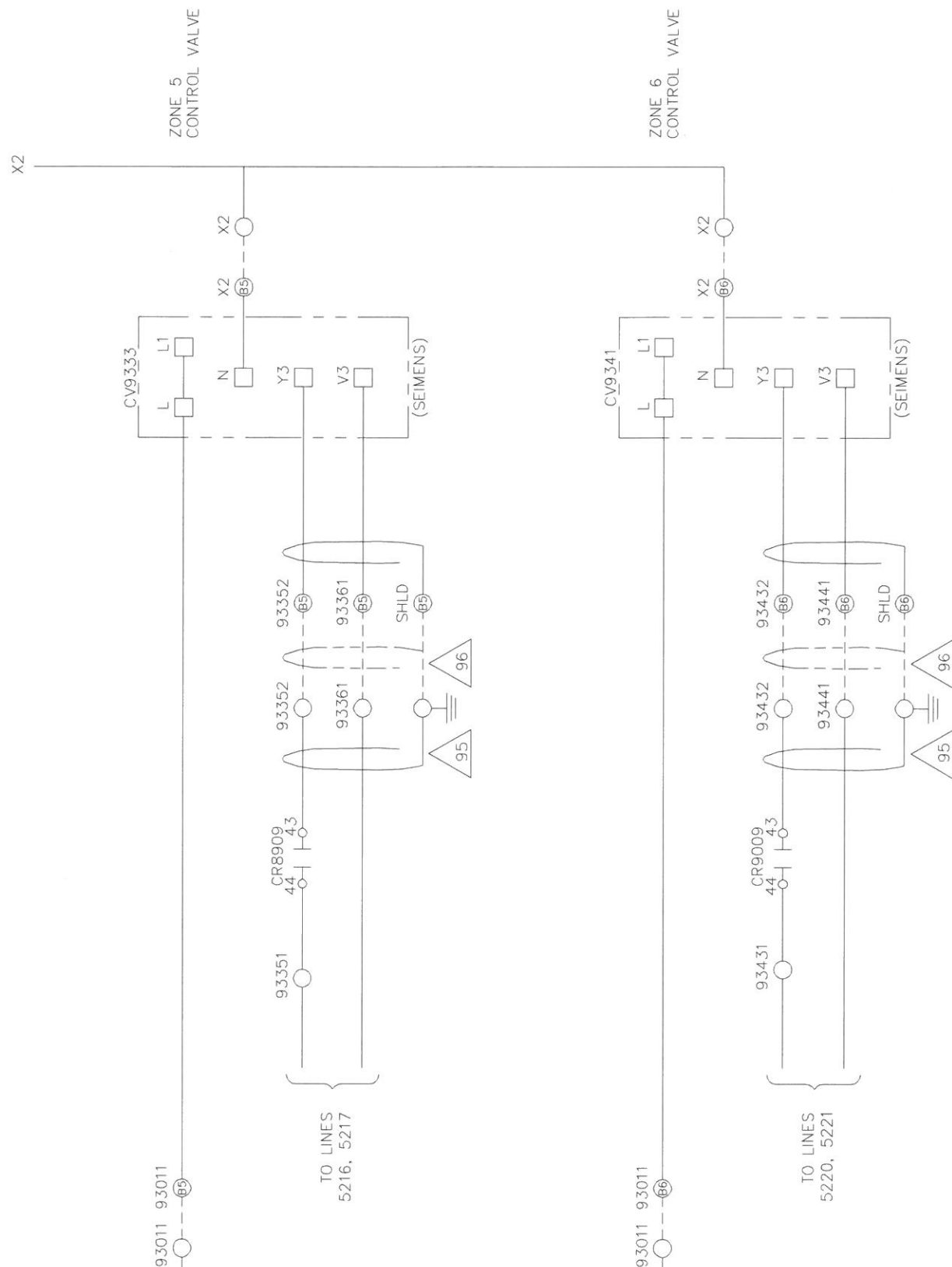
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9.344

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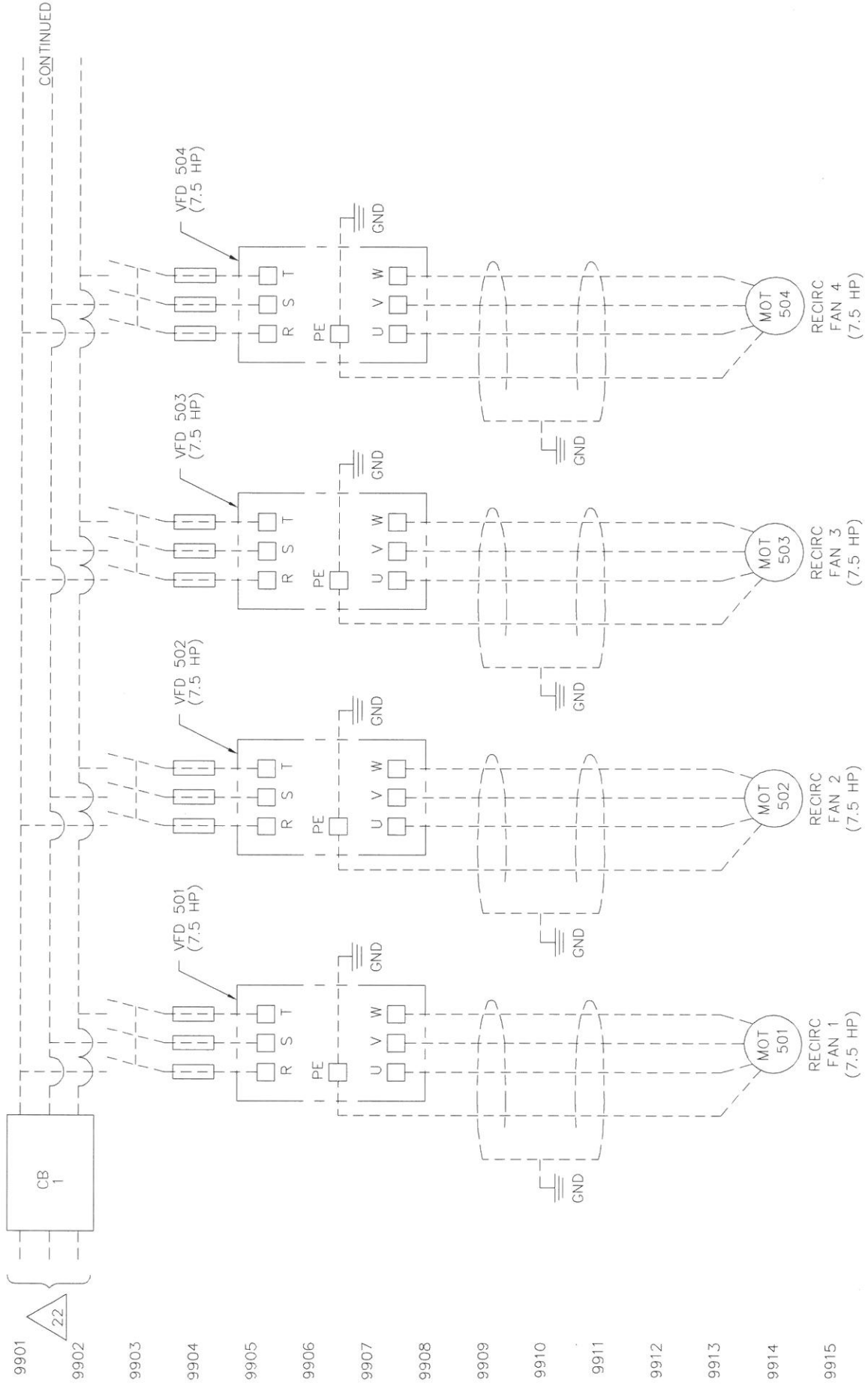
ZONE 5
CONTROL VALVE

ZONE 6
CONTROL VALVE

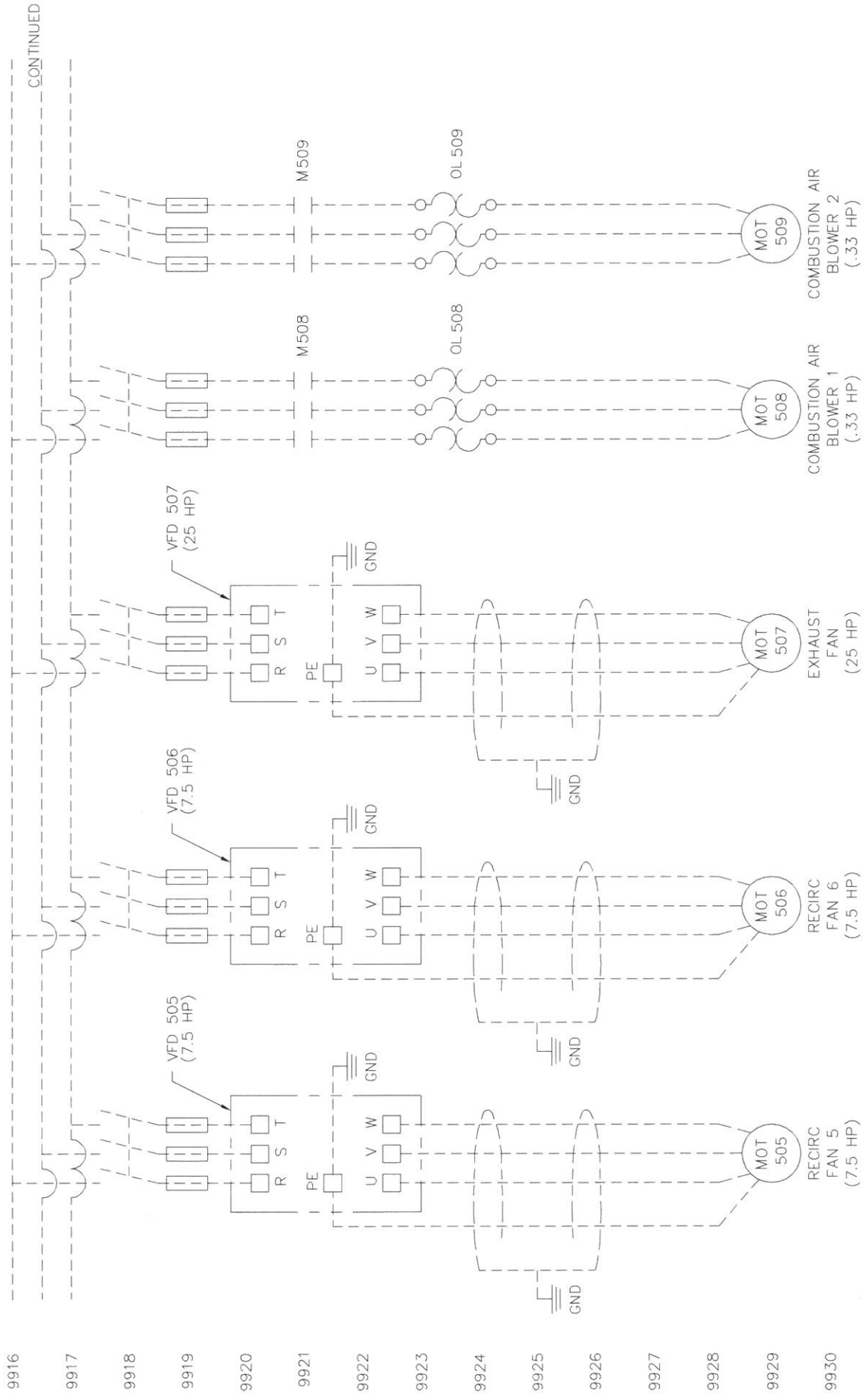
TO LINES
5216. 5217

TO LINES
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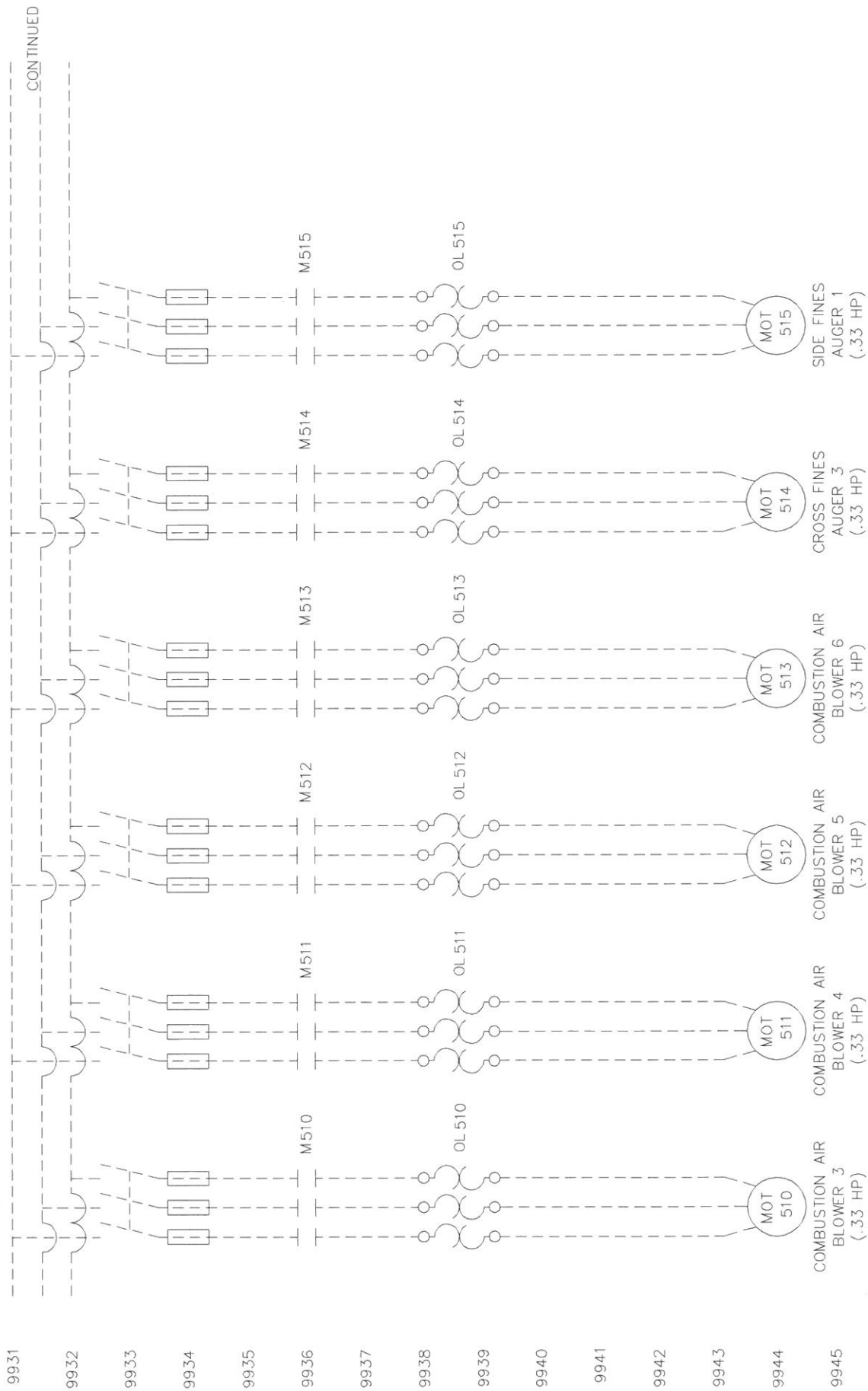
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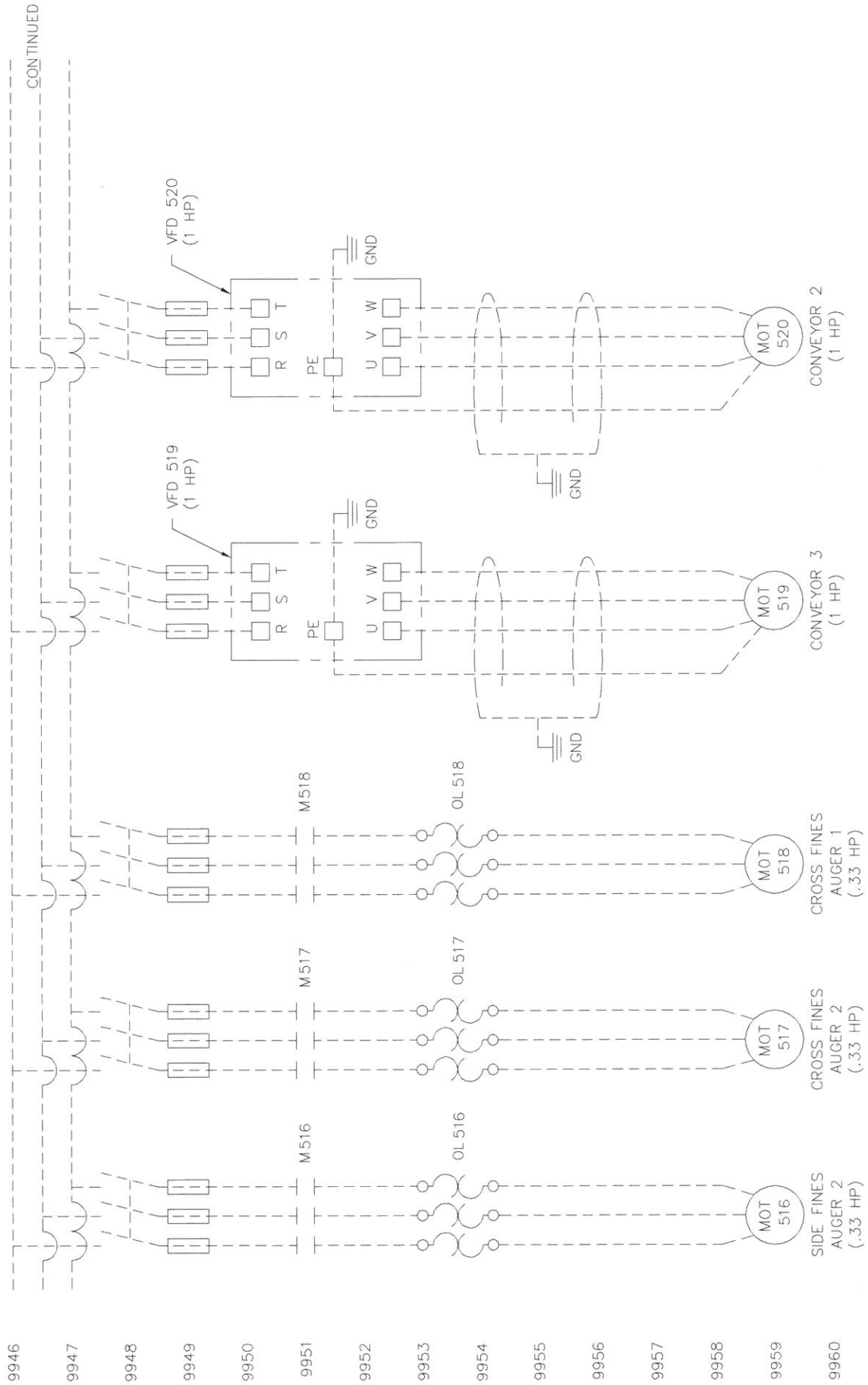
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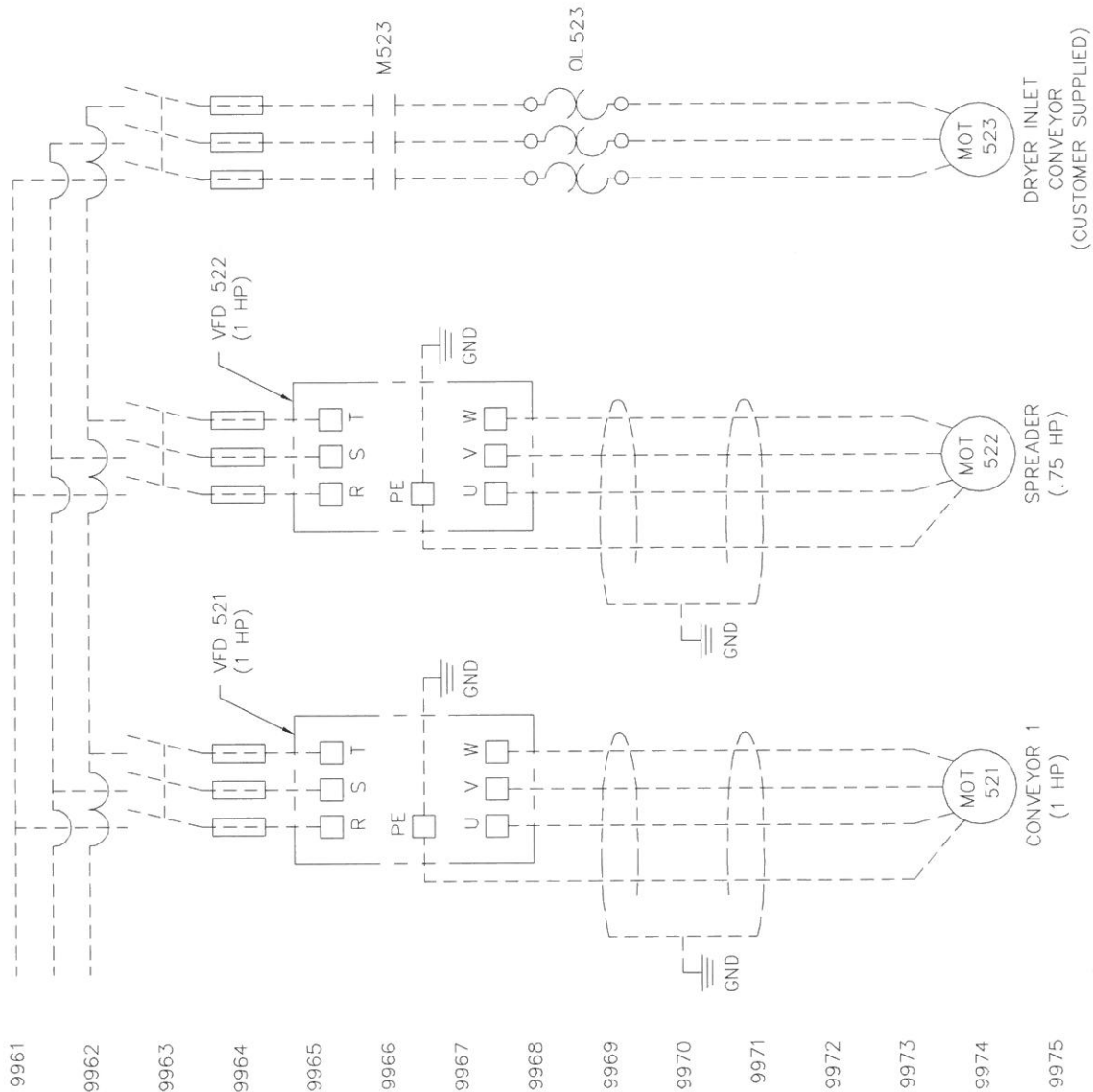


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(DRYER EXHAUST FAN)

